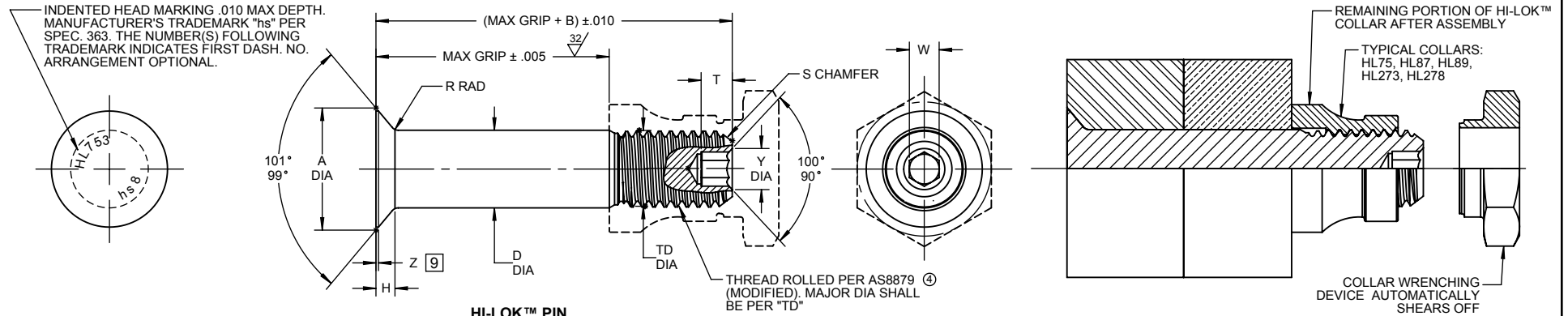


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HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

7																		1																		9																	
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM																																				
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM								W HEX	T DEPTH	Y DIA																																						
5						NOTE: USE HL647(J6-)																																															
6	13/64	.3813 .3765	.325	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0750 .0730	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,100	4,350																																				
8	17/64	.5066 .5018	.395	.2651 .2646	.2651 .2641	.2440 .2410	.006	.1013 .0993	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,800	7,750																																				
10	21/64	.6335 .6287	.500	.3276 .3271	.3276 .3266	.3060 .3020	.007	.1283 .1263	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	21,000	12,300																																				
12	25/64	.7604 .7556	.545	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1553 .1533	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	30,000	19,100																																				
14	29/64	.8884 .8812	.635	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1828 .1798	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	40,300	25,800																																				
16	33/64	1.0139 1.0068	.685	.5151 .5146	.5151 .5141	.4930 .4880	.010	.2093 .2063	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	52,200	34,300																																				
18	37/64	1.1408 1.1337	.770	.5771 .5766	.5771 .5761	.5550 .5500	.010	.2365 .2335	.050 .040	.025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	65,600	43,500																																				
20	41/64	1.2723 1.2651	.825	.6396 .6391	.6396 .6386	.6180 .6120	.010	.2654 .2624	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	80,600	54,600																																				
24	49/64	1.5308 1.5236	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.012	.3214 .3184	.050 .040	.025	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	115,000	79,200																																				
28	57/64	1.7845 1.7773	1.210	.8896 .8891	.8896 .8886	.8680 .8610	.014	.3754 .3724	.050 .040	.025	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	156,000	117,000																																				
32	1-1/64	2.0405 2.0310	1.390	1.0146 1.0141	1.0146 1.0136	.9930 .9860	.014	.4304 .4264	.050 .040	.025	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	202,000	143,000																																				

SEE COLLAR STANDARDS
 FOR COLLAR STRENGTHS.
 LOWER STRENGTH (PIN OR
 COLLAR) DETERMINES
 SYSTEM STRENGTH

"HI-LOK", "HL", AND "HI-KOTE"
 ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY F.CARENGELLA	DATE 2016-10-04	TITLE HI-LOK™ PIN	
VAN	1971-11-18	100° FLUSH MS24694 TENSION HEAD	
APPROVED R. TING	DATE 1971-11-22	PH13-8Mo STAINLESS STEEL	
		1/16 GRIP VARIATION, 1/64 OVERSIZE	
REVISION ④	DATE 2017-06-26	DRAWING NUMBER HL753	
		1 OF 2	

- 1 Head edge out of roundness shall not exceed "F".
- 2 Concentricity: Conical surface of head to "D" diameter within .005 FIM.
- 3 "H" is dimensioned from maximum "D" diameter.
- 4 Dimensions are in inches and to be met after finish.
- 5 Surface texture per ASME B46.1.
- 6 Hole preparation per NAS618.
- 7 Maximum "D" diameter may be increased by .0002 to allow for solid film application.
8. Use HL853 for oversize replacement.
- 9 Curved or flat edge manufacturer's option.

MATERIAL: PH13-8Mo stainless steel per AMS5629.

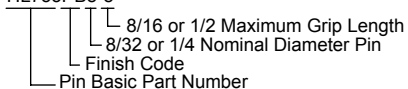
HEAT TREAT: 125,000 psi shear minimum.

FINISH: HL753-()-() = Solid film lube per AS5272, Type I.
HL753LL-()-() = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL753PB-()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL753TB-()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
④ HL753HK-()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL753 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

④ **EXAMPLE:** Pin Part Number
HL753PB8-8



DRAWING NUMBER

HL753

2 OF 2