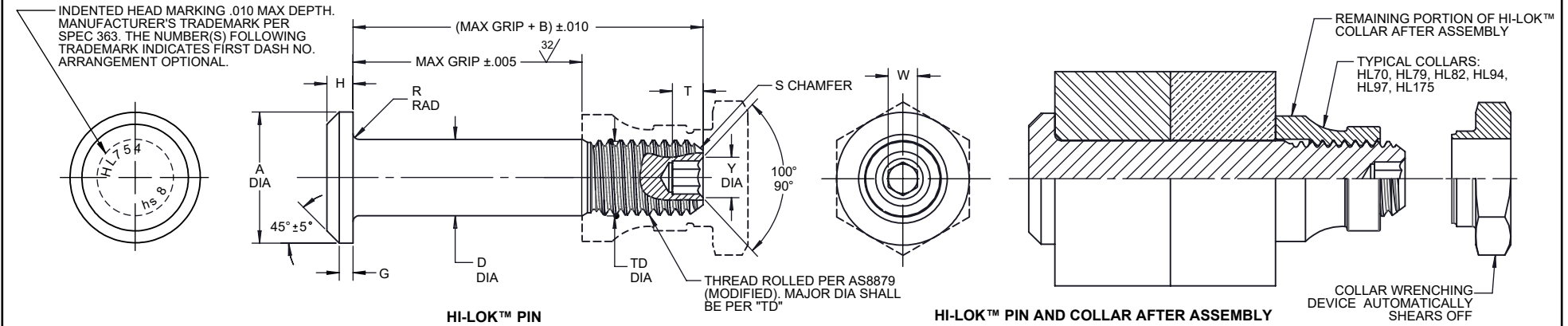




FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT PLATING OR COATING	WITH PLATING OR COATING							W HEX	T DEPTH	Y DIA		
5	5/32	.262 .242	.312	.1635 .1630	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	[5]	5,280	2,200
6	3/16	.315 .295	.325	.1895 .1890	.1895 .1885	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,060	3,000
8	1/4	.412 .387	.395	.2495 .2490	.2495 .2485	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	12,260	5,100
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	19,160	8,000
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	27,600	11,300
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	37,500	15,500
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	49,100	20,000
18	9/16	.864 .829	.770	.5615 .5610	.5615 .5605	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	62,100	25,000
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	76,700	30,200
24	3/4	1.108 1.066	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.070	.151 .136	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.320 .300	.398 .378	110,400	40,200

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

- 11 GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions are in inches and to be met after finish.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Evidence of broken edge across points.
6. Use HL936 for oversize replacement.

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

HOW TO ORDER EXAMPLE: Pin Part Number
HL754AP8-8

8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Finish Code
Pin Basic Part Number

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum (220,000 psi tensile minimum).

FINISH: HL754-(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL754AP(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL754JT(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1, with light blue identification on top of head and cetyl alcohol lube per Hi-Shear Spec. 305.
11 HL754NAP(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305

SPECIFICATION: HI-LOK™ Product Specification 342.

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

DRAWN BY D. P. S.	DATE 1983-03-04	TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION
APPROVED R. TING	DATE 1983-03-04	
REVISION 11	DATE 2024-02-13	DRAWING NUMBER HL754