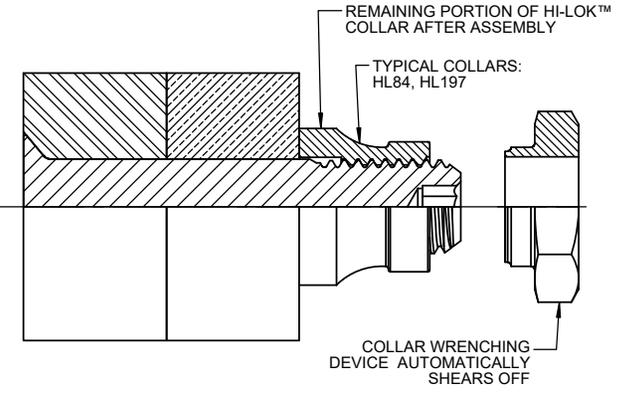
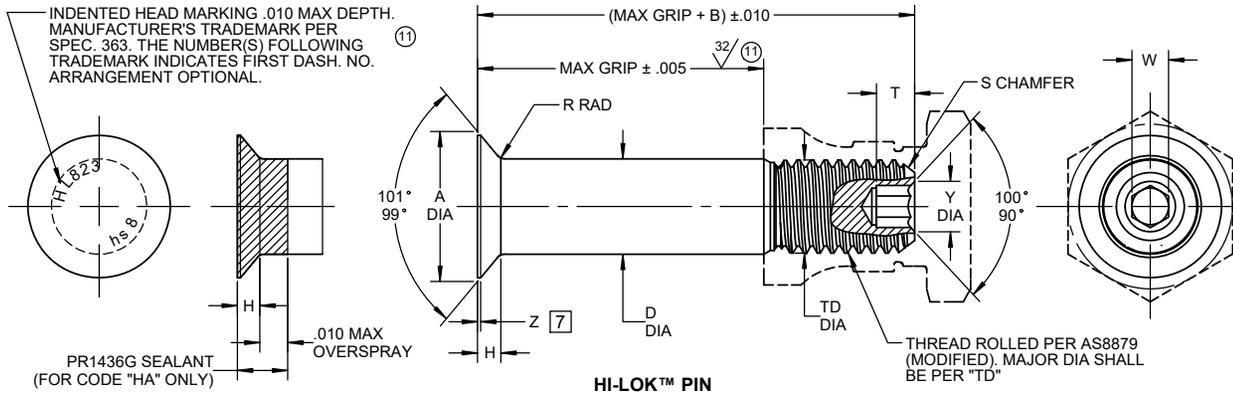


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HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F REF	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 HL537( )6-( )											
6	7/32	.3536 .3486	.325	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0568 .0547	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,100	2,590	
8	9/32	.4732 .4682	.395	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0807 .0786	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	11,800	4,760	
10	11/32	.5619 .5569	.500	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0917 .0896	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	17,600	7,100	
12	13/32	.6912 .6862	.545	.4057 .4052	.4057 .4047	.3680 .3640	.008	.1198 .1177	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	24,600	10,600	
14	15/32	.8041 .7969	.635	.4682 .4677	.4682 .4672	.4310 .4260	.009	.1409 .1379	.050 .040	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	32,700	14,450	
16	17/32	.9166 .9095	.685	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1619 .1589	.050 .040	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	42,000	19,550	
18	19/32	1.0337 1.0266	.770	.5927 .5922	.5927 .5917	.5550 .5500	.010	.1850 .1820	.050 .040	.025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	52,400	24,700	
20	21/32	1.1230 1.1158	.890	.6552 .6547	.6552 .6542	.6180 .6120	.010	.1963 .1933	.050 .040	.025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	64,100	29,600	
24	25/32	1.3500 1.3428	1.115	.7802 .7797	.7802 .7792	.7430 .7370	.012	.2391 .2361	.050 .040	.025	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	90,900	42,900	

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

DRAWN BY VAN	DATE 1968-06-11	TITLE HI-LOK™ PIN 100° FLUSH MS20426 HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED J.M.	DATE 1968-06-11	DRAWING NUMBER HL823
REVISION 11	DATE K. PHAM 2022-2-24	1 OF 2

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
  2. Concentricity: Conical surface of head to "D" diameter within .003 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 Curved or flat edge manufacturer's option.
  - 8 Maximum "D" diameter may be increased by .0002 to allow for aluminum coating or solid film application.
  9. Oversize replacement for HL523 and HL537.
  - 10 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in UK and European Union.

**MATERIAL:** 6Al-4V titanium alloy per AMS4928 or AMS4967.

**HEAT TREAT:** 95,000 psi shear minimum.

- FINISH:**
- HL823(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
  - 11 10 HL823AP(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per lube per Hi-Shear Spec. 305.
  - 11 10 HL823AZ(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on the thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - 11 10 HL823HA(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on the thread end, and apply precoat No. PR1436G sealant (.002-.005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL823RA(-)(-) = Phosphate fluoride treat with color code red on the thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL823SY(-)(-) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color code red on the thread end.
  - 11 10 HL823GM(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads (no overspray on the shank is allowed) and top of head only (.005 max overspray on the head bearing surface permissible) with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - 11 10 HL823AD(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305. Top of head shall be painted in accordance with BAC5684, Type I. No overspray is allowed except in the "Z" land area.
  - 11 10 HL823EF(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on top of head only (.005 max overspray on the head bearing surface permissible) with color blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL823NKJ(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL823NKK(-)(-) = Sulfuric acid anodizing per ISO8080 and HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL823NKL(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

**SPECIFICATION:** HI-LOK™ Product Specification 342.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HL823 oversize pin replaces.  
Second dash number indicates maximum grip in 1/16ths.  
See Finish note for explanation of code letters.

**HOW TO ORDER  
EXAMPLE:**

