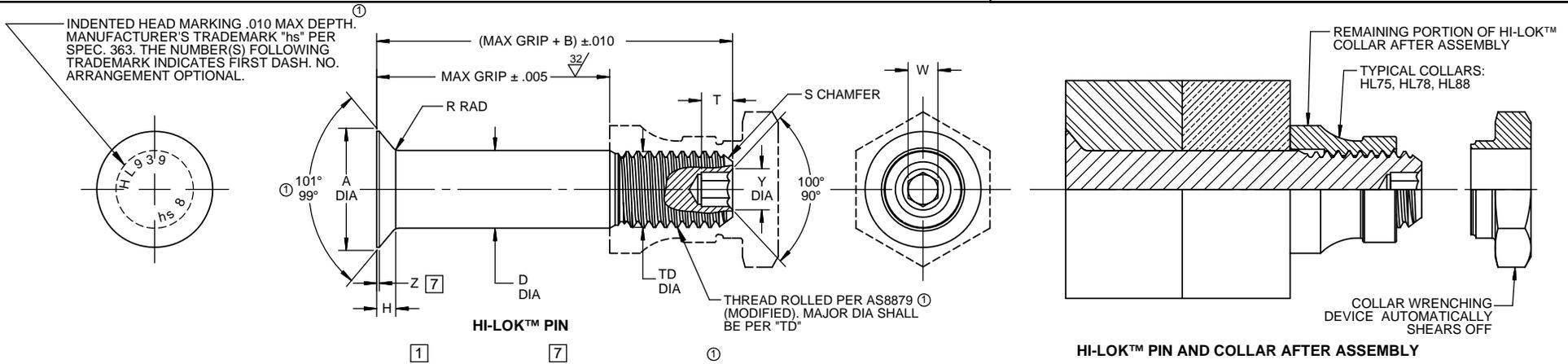


① For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://WWW.LISI-AEROSPACE.COM/LICENSES)



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

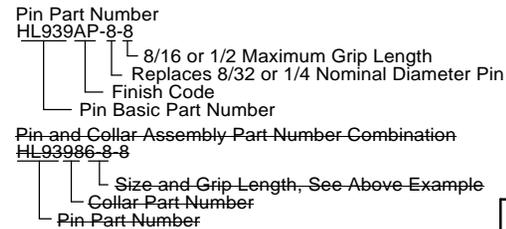
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	
				WITHOUT COATING OR PLATING	WITH COATING OR PLATING								W HEX	T DEPTH	Y DIA			
5	5/32						NOTE: USE HL731-6(-).											
6	13/64	.3813 .3765	.325	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0750 .0730	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.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	.150 .130	.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	.170 .150	.180 .160	21,100	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	.200 .180	.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	.230 .210	.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	.260 .240	.289 .269	52,500	34,300	

- GENERAL NOTES:**
- 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 Curved or flat edge manufacturer's option.
 - ⑧ Use HL949 for oversize replacement.
 - ⑨ Non-lubed pin must be used with wet sealant or with lubed collars.
 - 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 European Union.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL939 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

① **EXAMPLE:**



MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum (210,000 psi tensile minimum).

- FINISH:**
- HL939(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑩ HL939AP(-)(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL939JT(-)(-) = Passivate per Hi-Shear Spec. 258, with light blue identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑩ HL939PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑨ HL939PY(-)(-) = Passivate per Hi-Shear Spec. 258.

SPECIFICATION: HI-LOK™ Product Specification 342.

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY J.FOBISPO	DATE 2000-06-05	TITLE HI-LOK™ PIN
APPROVED J.RAUSCH	DATE 2000-06-05	100° FLUSH MS24694 TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/64 OVERSIZE
REVISION ①	DATE M.BEARD 2017-09-26	DRAWING NUMBER HL939