



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	AFTER COATING OR PLATING								W HEX	T DEPTH	Y DIA		
5							NOTE: USE HL937() 6(-)										
6	7/32	.3303 .3253	.325	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0472 .0449	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,400	2,600
8	9/32	.4265 .4210	.395	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0612 .0589	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	15,500	4,400
10	11/32	.5056 .5001	.500	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0681 .0658	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	23,200	7,000
12	13/32	.5921 .5866	.545	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0782 .0759	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	32,400	10,000
14	15/32	.6997 .6932	.635	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0971 .0944	.040 .030	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	43,100	13,500
16	17/32	.7857 .7792	.685	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1070 .1043	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,400	18,000

- 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 4. Dimensions are in inches and to be met after finish.
 - ⑤ 5. Surface texture per ASME B46.1.
 6. Hole preparation per NAS618.
 - ⑦ 7. Curved or flat edge manufacturer's option
 - ⑧ 8. 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.

MATERIAL: Nickel base alloy per AMS5662.

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

FINISH:

HL947-()-() = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.

⑧ HL947AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

HL947JT()-() = Passivate per Hi-Shear Spec. 258, with light blue identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.

HL947PB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, 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 HL947 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER

③ **EXAMPLE:** Pin Part Number
HL947AP8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number

"HI-LOK", "HL", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY D.P.S.	DATE 1987-02-03	TITLE HI-LOK™ PIN 100° FLUSH SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED J.G.WILCOX	DATE 1987-02-04	DRAWING NUMBER HL947	
REVISION ③	DATE M.BEARD 2017-06-27	1 OF 1	