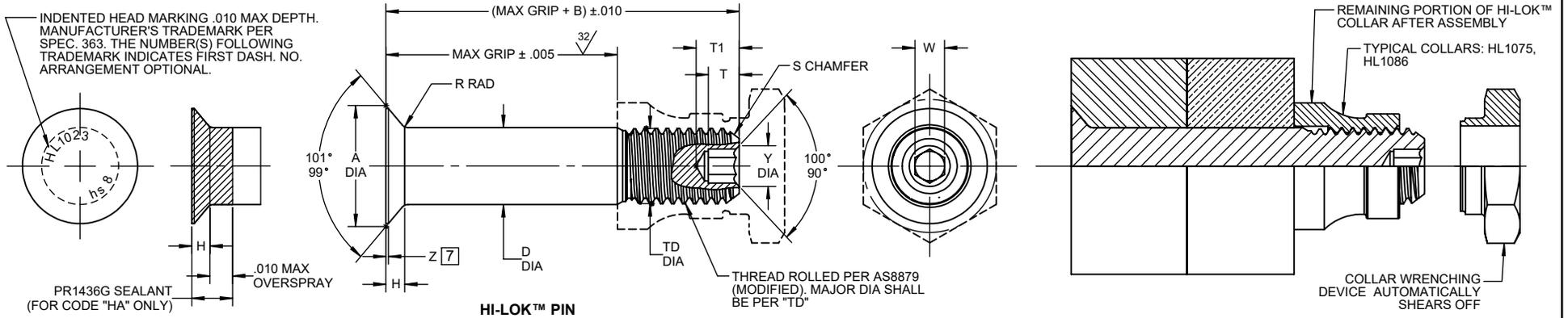


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HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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	T1 DEPTH MAX	Y DIA		
5							NOTE: USE HL1013()6-()											
6	3/16	.3813 .3765	.325	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0750 .0730	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.140	.119 .104	6,130	3,180
7	7/32	.4452 .4378	.355	.2338 .2333	.2338 .2328	.2100 .2070	.006	.0950 .0930	.030 .020	.015	1/32 x 37°	.2160-28 UNJF-3A	.0806 .0791	.100 .080	.140	.119 .104	8,160	4,280
8	1/4	.5066 .5018	.395	.2651 .2646	.2651 .2641	.2440 .2410	.006	.1013 .0993	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.160	.142 .122	10,490	5,820
10	5/16	.6335 .6287	.500	.3276 .3271	.3276 .3266	.3060 .3020	.007	.1283 .1263	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.200	.180 .160	16,000	9,200
12	3/8	.7604 .7556	.545	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1553 .1533	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.235	.217 .197	22,700	14,000
14	7/16	.8884 .8812	.635	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1828 .1798	.040 .030	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.280	.253 .233	30,600	18,900
16	1/2	1.0139 1.0068	.685	.5151 .5146	.5151 .5141	.4930 .4880	.010	.2093 .2063	.050 .040	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.320	.289 .269	39,600	25,600
18	9/16	1.1408 1.1337	.770	.5771 .5766	.5771 .5761	.5550 .5500	.010	.2365 .2335	.050 .040	.025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.360	.326 .306	49,700	32,400
20	5/8	1.2723 1.2651	.825	.6396 .6391	.6396 .6386	.6180 .6120	.010	.2654 .2624	.050 .040	.025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.400	.326 .306	61,000	41,000
24	3/4	1.5308 1.5236	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.012	.3214 .3184	.050 .040	.025	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.425	.398 .378	87,200	59,500

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

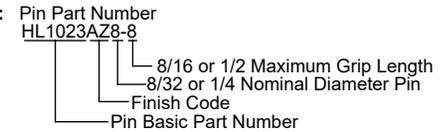
DRAWN BY J.F. OBISPO	DATE 1995-03-22	TITLE HI-LOK™ PIN 100° FLUSH MS24694 TENSION HEAD TITANIUM, 1/64 OVERSIZE 1/16 GRIP VARIATION (SPECIAL APPLICATION)
APPROVED E.E.B.	DATE 1995-03-23	
REVISION 11	DATE 2024-04-16	DRAWING NUMBER HL1023

GENERAL NOTES:

①

1. Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .003 FIM.
3. Dimensions are in inches and to be met after finish.
4. Surface texture per ASME B46.1.
5. Hole preparation per NAS618.
6. "H" is dimensioned from maximum "D" diameter.
7. Curved or flat edge manufacturer's option.
8. Use HL1033 for oversize replacement.

**HOW TO ORDER
EXAMPLE:**



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

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

FINISH:

- HL1023-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1023AZ()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1023BB()-() = 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 the thread end. Top of head painted in accordance with BAC5684, Type 5 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1023BN()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads (no overspray on the shank allowed) and top of head only (.005 max overspray on the head bearing surface permissible) with color white on thread end. Top of head painted in accordance with BAC5684, Type 5 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1023EF()-() = 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.
- HL1023EZ()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end. Top of head is painted in accordance with BAC5684, Type 5 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1023GM()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads (no overspray on the shank 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.
- HL1023HA()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and apply Precoat No. PR1436G sealant (.002-.005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1023HD()-() = I.V.D. aluminum coating per BAC5315, with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1023RA()-() = Phosphate fluoride treat with color red on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1023VF()-() = Anodize per Hi-Shear Spec 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1023NKJ()-() = 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.
- HL1023NKK()-() = 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.
- HL1023NKL()-() = 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 HL1023 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HL1023

DRAWING NUMBER

HL1023

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