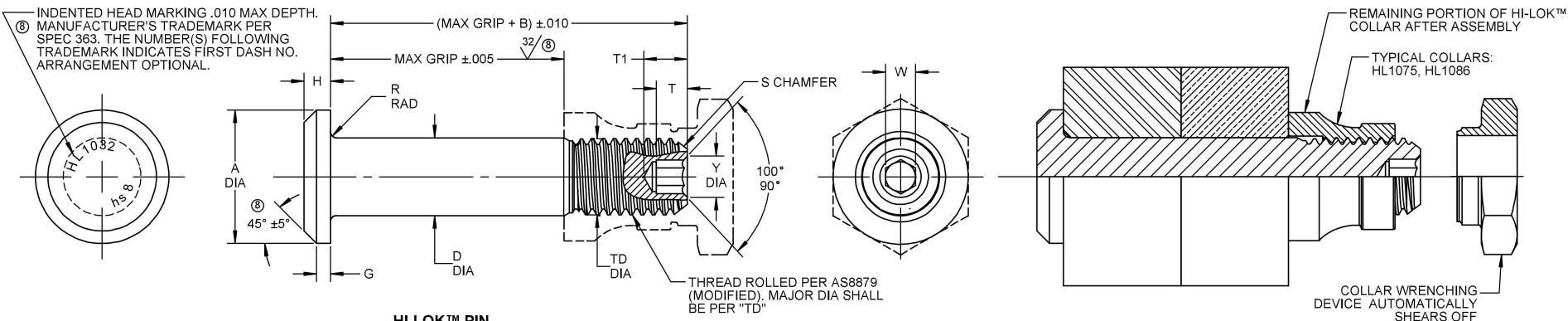


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HI-LOK™ PIN

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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 COATING OR SOLID FILM	AFTER COATING OR SOLID FILM							W HEX	T DEPTH	T1 DEPTH MAX	Y DIA		
5						NOTE: USE HL1022(J6-(-)											
6	7/32	.390 .370	.325	.2182 .2177	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.140	.119 .104	7,100	3,180
8	9/32	.460 .435	.395	.2807 .2802	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.160	.142 .122	11,800	5,820
10	11/32	.520 .500	.500	.3432 .3427	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.200	.180 .160	17,600	9,200
12	13/32	.620 .600	.545	.4057 .4052	.4057 .4047	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.235	.217 .197	24,600	14,000
14	15/32	.695 .670	.635	.4682 .4677	.4682 .4672	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.280	.253 .233	32,700	18,900
16	17/32	.790 .765	.685	.5307 .5302	.5307 .5297	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.320	.289 .269	42,000	25,600
18	19/32	.905 .870	.770	.5927 .5922	.5927 .5917	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.360	.326 .306	52,400	32,400
20	21/32	.975 .940	.825	.6552 .6547	.6552 .6542	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.400	.326 .306	64,100	41,000
24	25/32	1.185 1.145	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.425	.398 .378	90,900	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 PROTRUDING TENSION HEAD TITANIUM	
APPROVED E.E.B.	DATE 1995-03-23	1/16 GRIP VARIATION, 1/32 OVERSIZE (SPECIAL SOCKET APPLICATION)	
REVISION 8	DATE K. PHAM 2022-04-04	DRAWING NUMBER HL1032	

- 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. Oversize replacement for HL1012 and HL1022.
- ⑧ ⑥ 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: 160,000 psi tensile minimum (95,000 psi shear minimum).

- FINISH:**
- HL1032-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑧ ⑥ HL1032AZ()-() = 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.
- HL1032DK()-() = Solid film lube per "KalGard™" FA. "KALGARD" is a trademark of Metal Improvement Company.
- ⑧ ⑥ HL1032GL()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only (no overspray is allowed on the shank) with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑧ HL1032VF()-() = Anodize per Hi-Shear Spec 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1032RA()-() = Phosphate fluoride treat with color red on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1032SY()-() = Phosphate fluoride treat, solid film lube per AS5272, Type I, color red on thread end.
- HL1032NKJ()-() = 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.
- HL1032NKK()-() = 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.
- HL1032NKL()-() = 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.

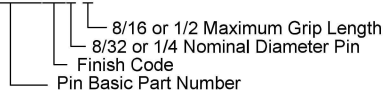
SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL1032 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER

EXAMPLE:

Pin Part Number
 HL1032AZ8-8



HL1032

DRAWING NUMBER

HL1032

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