



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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 PLATING, COATING	WITH PLATING, COATING								W HEX	T DEPTH	T1 DEPTH MAX	Y DIA		
			○					NOTE: USE HL1063-6- ( )										
6	7/32	.3813 .3765	.325	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0684 .0664	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.140	.119 .104	7,100	3,180
8	9/32	.5066 .5018	.395	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0948 .0928	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.160	.142 .122	11,800	5,820
10	11/32	.6335 .6287	.500	.3432 .3427	.3432 .3422	.3060 .3020	.007	.1218 .1198	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.200	.180 .160	17,600	9,200
12	13/32	.7604 .7556	.545	.4057 .4052	.4057 .4047	.3680 .3640	.008	.1488 .1468	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.235	.217 .197	24,600	14,000
14	15/32	.8884 .8812	.635	.4682 .4677	.4682 .4672	.4310 .4260	.009	.1763 .1733	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.280	.253 .233	32,700	18,900
16	17/32	1.0139 1.0068	.685	.5307 .5302	.5307 .5297	.4930 .4880	.010	.2027 .1997	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.320	.289 .269	42,000	25,600

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

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
  - Concentricity: Conical surface of head to "D" diameter within .003 FIM.
  - "H" is dimensioned from maximum "D" diameter.
  - Dimensions are in inches and to be met after finish.
  - Surface texture per ASME B46.1.
  - Hole preparation per NAS618.
  - Curved or flat edge manufacturer's option.
  - Non-lubed pins must be used with lubed collars.
  - Use HL1067 for oversize replacement.
  - After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating 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:** A-286 high temperature alloy per AMS5737 or AMS5731.

**HEAT TREAT:** 160,000 psi tensile minimum (95,000 psi shear minimum) at 70°F.

- FINISH:**
- HL1065-(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1065AZ(-)(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, with color black on the thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1065CG(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color green on the thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1065DU(-)(-) = Solid film lube per AS5272, Type I.
  - HL1065N(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, without lubricant. (For use in LOX systems).
  - HL1065PY(-)(-) = Passivate per Hi-Shear Spec. 258.

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

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HL1065 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

HL1065AZ8-8

- 8/16 or 1/2 Maximum Grip Length
- Replaces 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

Pin and Collar Assembly Part Number Combination

HL1065AZ93-8-8

- Size and Grip Length, See Above Example
- Collar Part Number
- Pin Finish
- Pin Basic Part Number

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

DRAWN BY J.F. OBISPO	DATE 2003-10-23	TITLE HI-LOK™ PIN
APPROVED M. CAWLEY	DATE 2003-10-23	100° FLUSH MS24694 TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 1/32 OVERSIZE
REVISION 1	DATE KEVIN TRAN 2017-09-21	DRAWING NUMBER <b>HL1065</b>