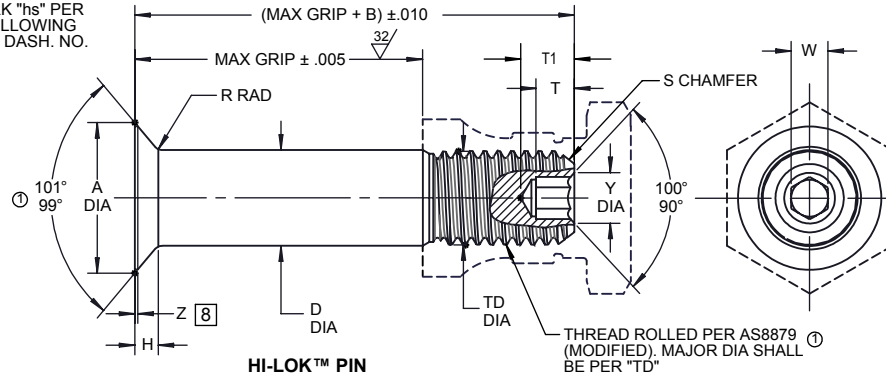
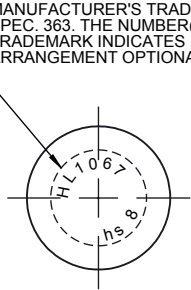
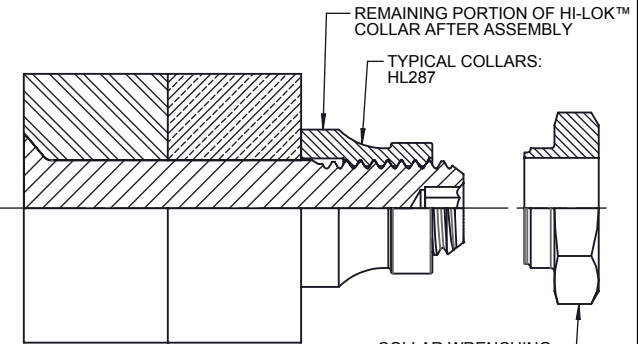


INDENTED HEAD MARKING .010 MAX DEPTH.  
MANUFACTURER'S TRADEMARK "hs" PER  
SPEC. 363. THE NUMBER(S) FOLLOWING  
TRADEMARK INDICATES FIRST DASH. NO.  
ARRANGEMENT OPTIONAL.



HI-LOK™ PIN



COLLAR WRENCHING  
DEVICE AUTOMATICALLY  
SHEARS OFF

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 HL1065-6(-)										
6	15/64	.3813	.360	.2339	.2339	.1840	.005	.0618	.030	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806	.100	.140	.119	8,160	3,180
		.3765		.2334	.2329	.1810		.0598	.020				.0791	.080		.104		
8	19/64	.5066	.430	.2963	.2963	.2440	.006	.0882	.030	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967	.110	.160	.142	13,100	5,820
		.5018		.2958	.2953	.2410		.0862	.020				.0947	.090		.122		
10	23/64	.6335	.530	.3589	.3589	.3060	.007	.1152	.040	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295	.130	.200	.180	19,200	9,200
		.6287		.3584	.3579	.3020		.1132	.030				.1270	.110		.160		
12	27/64	.7604	.575	.4214	.4214	.3680	.008	.1422	.040	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617	.160	.235	.217	26,500	14,000
		.7556		.4209	.4204	.3640		.1402	.030				.1582	.140		.197		
14	31/64	.8884	.660	.4839	.4839	.4310	.009	.1697	.050	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930	.190	.280	.253	34,900	18,900
		.8812		.4834	.4829	.4260		.1667	.040				.1895	.170		.233		
16	35/64	1.0139	.710	.5464	.5464	.4930	.010	.1961	.050	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242	.220	.320	.289	44,600	25,600
		1.0068		.5459	.5454	.4880		.1931	.040				.2207	.200		.269		

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.
  - 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:** HL1067-(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.

① ⑨ HL1067AZ(-)(-) = 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.

HL1067CG(-)(-) = 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.

HL1067DU(-)(-) = Solid film lube per AS5272, Type I.

⑧ HL1067N(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, without lubricant. (For use in LOX system).

⑧ HL1067PY(-)(-) = Passivate per Hi-Shear Spec. 258.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HL1067 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:**

Pin Part Number  
HL1067AZ8-8

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  
HL1067AZ287-8-8

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, 3/64 OVERSIZE
REVISION 1	DATE KEVIN TRAN 2017-09-21	DRAWING NUMBER <b>HL1067</b>