



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

FIRST DASH NO.	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, PLATING OR SOLID FILM	WITH COATING, PLATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
5	13/64						NOTE: USE HL36-6									
6	7/32	.390 .370	.325	.2182 .2177	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900- 32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,400	4,350
8	9/32	.460 .435	.395	.2807 .2802	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	15,500	7,750
10	11/32	.520 .490	.500	.3432 .3427	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	23,200	12,300
12	13/32	.620 .585	.545	.4057 .4052	.4057 .4047	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	32,400	19,100
14	15/32	.695 .660	.635	.4682 .4677	.4682 .4672	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	43,100	25,800
16	17/32	.790 .755	.685	.5307 .5302	.5307 .5297	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,400	34,300

**GENERAL NOTES:**

1. Concentricity: "A" to "D" diameter within 0.10 FIR.
2. Dimensions are in inches and to be met after finish.
3. Surface texture per ASME B46.1
4. Hole preparation per NAS618.

**CODE:** First dash number indicates nominal diameter in 1/32nds which HL136 oversize pin replaces.  
 Second dash number indicates maximum grip in 1/16ths.  
 See Finish note for explanation of code letters.

③ **MATERIAL:** Type 431 stainless steel per AMS5628.

**HEAT TREAT:** 125,000 psi shear minimum.

**FINISH:**

- ③ HL136(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1 and cetyl alcohol lube per Hi-Shear Spec. 305.
- ③ HL136AP(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC Aluminum Pigmented Coating per HS294 and cetyl alcohol lube per Hi-Shear Spec. 305
- ③ HL136D(-)(-) = Solid film lube per AS5272
- ③ HL136NAP(-)(-) = HI-KOTE™ 1 NC Aluminum Pigmented Coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305
- ③ HL136PB(-)(-) = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

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

**HOW TO ORDER  
 EXAMPLES:**

③ Pin Part Number Only  
 HL136AP8-8  
 8/16 or 1/2 Maximum Grip Length  
 Replaces 8/32 or 1/4 Nominal Grip Diameter Pin  
 Finish Code  
 Pin Part Number

③ Pin and Collar Assembly Part Number Combination  
 HL13679-8-8  
 Size and Grip Length, See Above Example  
 Collar Part Number  
 Pin Part Number

\* \* The double Shear values shown are based on cross sectional area for nominal diameter pin.

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY SHRODE	DATE 1967-06-14	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD 431 STAINLESS STEEL 1/16" GRIP VARIATION, 1/32" OVERSIZE	
APPROVED MILLER	DATE 1967-06-19		
REVISION ③	DATE C. Artos 2023-05-03	DRAWING NUMBER <b>HL136</b>	