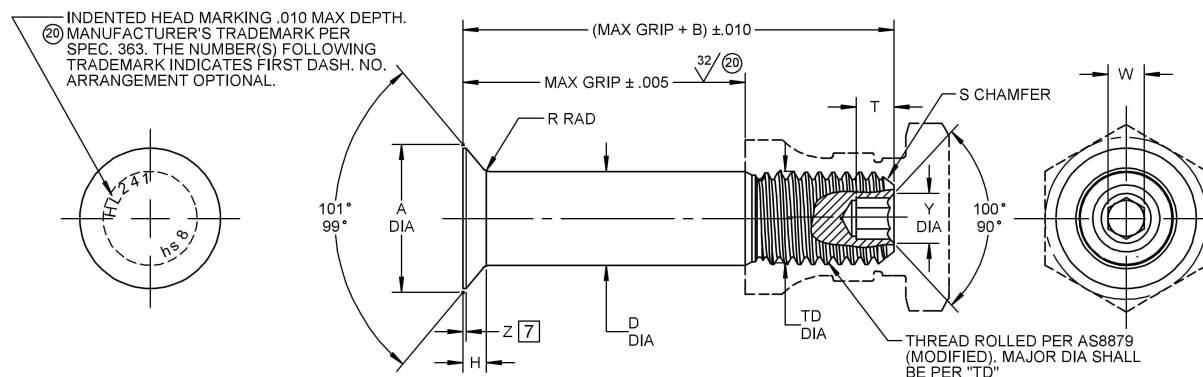
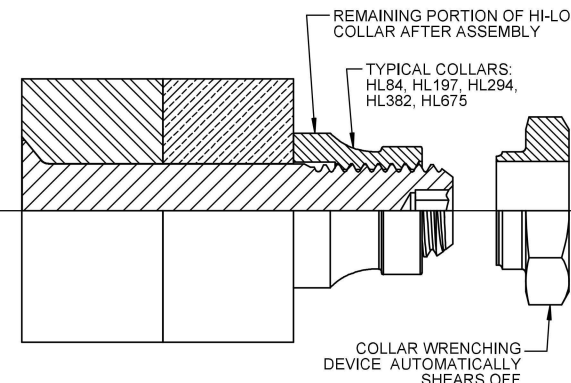


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HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

[2]																		[1]																	
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, PLATING, SOLID FILM	AFTER COATING, PLATING, SOLID FILM								W HEX	T DEPTH	Y DIA																				
5							NOTE: USE HL141()6-()																												
6	7/32	.3303 .3253	.325	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0470 .0449	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,100	2,000																		
8	9/32	.4260 .4210	.395	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0610 .0589	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	11,800	3,700																		
10	11/32	.5051 .5001	.500	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0679 .0658	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	17,600	5,000																		
12	13/32	.5916 .5866	.545	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0780 .0759	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	24,600	7,200																		
14	15/32	.6992 .6932	.635	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	32,700	10,000																		
16	17/32	.7852 .7792	.685	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	42,600	13,500																		
18	19/32	.8692 .8622	.770	.5927 .5922	.5927 .5917	.5550 .5500	.010	.1160 .1131	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	52,400	17,000																		
20	21/32	.9562 .9492	.825	.6552 .6547	.6552 .6542	.6180 .6120	.010	.1263 .1233	.050 .040	.022	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	64,100	21,000																		
24	25/32	1.1282 1.1162	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.012	.1460 .1410	.050 .040	.022	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	90,900	30,700																		

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

DRAWN BY J.F.OBISPO	DATE 2015-04-16	TITLE HI-LOK™ PIN 100° FLUSH SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 1/32 OVERSIZE
BRIEF	1971-03-31	
APPROVED MILLER	DATE 1971-03-31	
REVISION (20)	DATE K. PHAM 2022-04-11	DRAWING NUMBER HL241

20 [9] 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.

HEAT TREAT: 95,000 psi shear minimum at 70°F.

FINISH: 20HL241(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.

20 9 HL241AP(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec.294, and cetyl alcohol lube per Hi-Shear Spec. 305.

20 9 HL241AZ(-)(-) = 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.

HL241DU(-)(-) = Solid film lube per AS5272, Type I.

HL241N(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, without lubricant.
(For use in LOX system).

HL241PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color green on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.


20 HL241PY(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1.

HL241UC(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HL241V(-)(-) = Solid film lube per LUBECON™ 2123, Type II.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL241 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

EXAMPLE:


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

DRAWING NUMBER

HL241