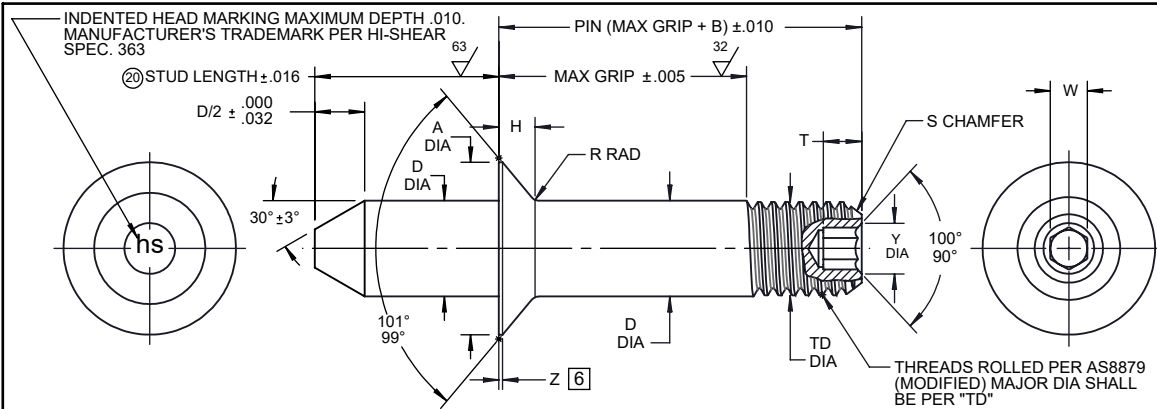
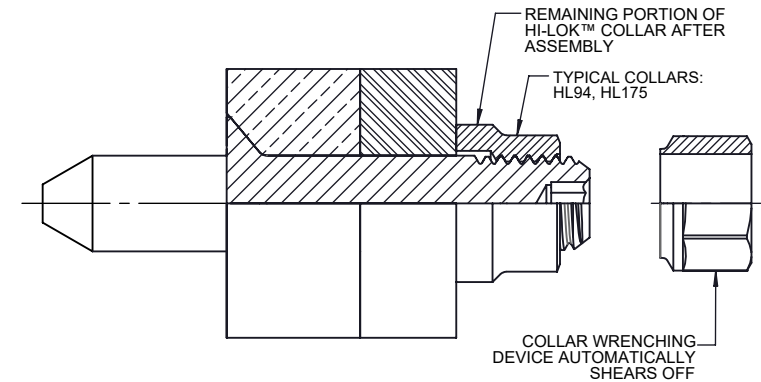




HI-LOK™ STUD PIN



HI-LOK™ STUD PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM DIA	A DIA	B REF	D DIA	TD DIA	F	H REF	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
6	3/16	.322 .292	.325	.1895 .1890	.1840 .1810	.010	.050	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,060	2,600
8	1/4	.416 .384	.395	.2495 .2490	.2440 .2410	.012	.063	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	12,260	4,400
10	5/16	.501 .468	.500	.3120 .3115	.3060 .3020	.014	.072	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .160	.180 .160	19,160	7,000
12	3/8	.587 .554	.545	.3745 .3740	.3680 .3640	.016	.082	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	27,600	10,000

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 to "D" diameter within .005 FIM.
 - "H" dimensioned from maximum "D" diameter.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Dimensions are in inches.

MATERIAL: Type 431 stainless steel per AMS5628.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HL34-()-()-() = Passivate per Hi-Shear Spec. 258, 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, Second dash number indicates maximum grip in 1/16ths. Third dash number indicates stud length in 1/16ths.

HOW TO ORDER
EXAMPLE:

Stud Pin Part Number
 HL34-8-8-8
 8/16 or 1/2 Maximum Stud Length
 8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
 HL3494-8-8-8
 Size and grip length, see above example
 Collar Part Number
 Pin Basic Part Number

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

DRAWN BY SCHAD	DATE 1959-06-01	TITLE HI-LOK™ STUD PIN 100° FLUSH SHEAR HEAD 431 STAINLESS STEEL 1/16 GRIP VARIATION
APPROVED J.K.	DATE 1959-06-01	
REVISION (18)	DATE J. LO 2020-07-23	DRAWING NUMBER HL34