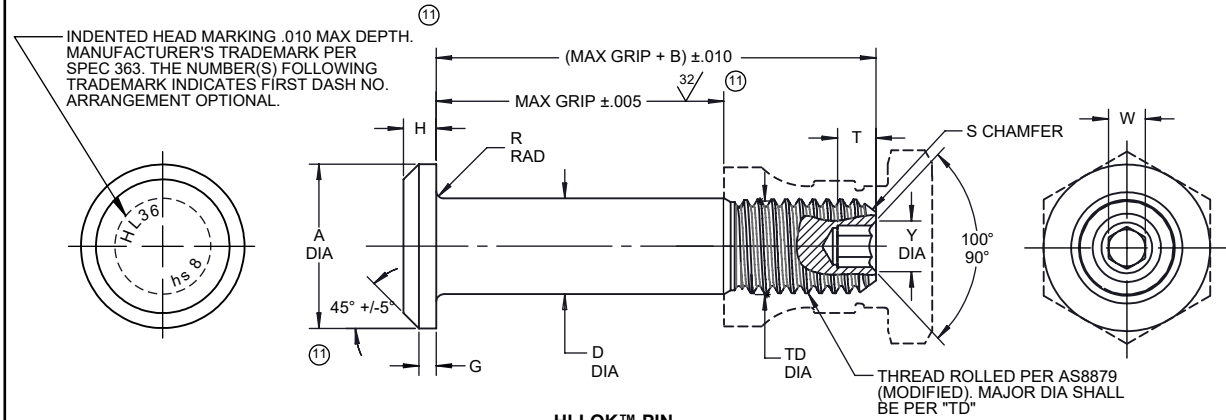
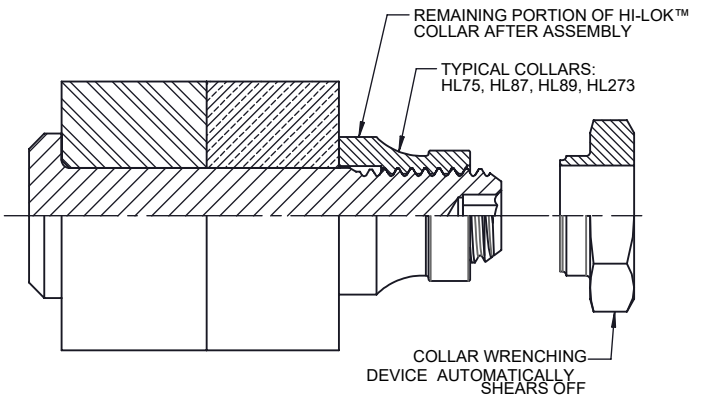




HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

FIRST DASH NO.	PIN 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 PLATING, COATING OR SOLID FILM LUBE	WITH PLATING, COATING OR SOLID FILM LUBE							W HEX	T DEPTH	Y DIA		
5	3/16					NOTE: Use HL32-6										
6	13/64	.377 .357	.325	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,100	4,350
8	17/64	.440 .415	.395	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .077	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,800	7,750
10	21/64	.505 .475	.500	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .098	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	21,100	12,300
12	25/64	.600 .530	.545	.3901 .3896	.3901 .3891	.3680 .3640	.075	.140 .120	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	30,000	19,100
14	29/64	.676 .592	.635	.4526 .4521	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	40,300	25,800
16	33/64	.770 .717	.685	.5151 .5146	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	52,500	34,300

** The Double Shear Values shown
 are based on cross sectional
 area for nominal diameter pin.

DRAWN BY BRIEJ		DATE 1964-11-03	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD 431 STAINLESS STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED MILLER		DATE 1964-11-03	DRAWING NUMBER HL36	
REVISION 11		DATE C.Artos 2023-4-25	1 OF 2	

1. Concentricity: "A" to "D" diameter within .010 FIR.
2. Dimensions are in inches and to be met after finish.
3. Non-lubed pins must be used with wet sealant or with lubed collars.
4. Surface texture per ASME B46.1.
5. Hole preparation per NAS618.
6. Use HL136 for oversize replacement.

HEAT TREAT: 125,000 psi shear minimum.

FINISH ⑪ HL36-()-() = Passivate per AMS2700, Method 1, Type 8, Class 1 and cetyl alcohol lube per Hi-Shear Spec. 305.

⑪ HL36AP()-() = HI-KOTE™ 1 or HI-KOTE™ 1NC Aluminum Pigmented Coating per HS294 and cetyl alcohol lube per Hi-Shear Spec 305

HL36BJ()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.

HL36D()-() = Solid film lube per Spec. AS5272.

⑪ HL36NAP()-() = HI-KOTE™ 1 NC Aluminum Pigmented Coating per HS294 and cetyl alcohol lube per Hi-Shear Spec. 305.

HL36PB()-() = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

③ HL36PN()-() = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL36 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

EXAMPLE:

HL36BJ8-8

Diagram illustrating the structure of a pin part number:

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

~~HL3687-8-8~~

Size and grip length, see above example
Collar Part Number
Pin Part Number