



HI-LOK™ PIN

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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 OR SOLID FILM	AFTER COATING OR SOLID FILM								W HEX	T DEPTH	Y DIA		
5	5/32	.2922 .2874	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0540 .0520	.025 .015	.010	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	9	4,010	1,730
6	3/16	.3536 .3486	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0688 .0667	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	2,590
8	1/4	.4732 .4682	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0939 .0918	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	4,760
10	5/16	.5619 .5569	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.1048 .1027	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	14,600	7,100
12	3/8	.6912 .6862	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.1329 .1308	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	10,600
14	7/16	.8041 .7969	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.1540 .1510	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	28,600	14,450
16	1/2	.9166 .9095	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1750 .1720	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	37,300	19,550

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

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

DRAWN BY BRIEJ	DATE 1965-07-25	TITLE HI-LOK™ PIN 100° FLUSH MS20426 HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION
APPROVED MILLER	DATE 1965-07-25	
REVISION 8	DATE A CHAE 2022-05-05	DRAWING NUMBER HL445

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 3. "H" dimensioned from maximum "D" diameter.
 4. Dimensions are in inches and to be met after finish.
 5. Non-lubed pins must be used with wet sealent or with lubed collars.
 6. Surface texture per ASME B46.1.
 7. Hole preparation per NAS618.
 - 8 Maximum "D" diameter may be increased by .0002 to allow for solid film lube.
 - 9 Evidence of broken edge across points.
 - 10 Curved or flat edge manufacturer's option.
 11. Use HL447 for oversize replacement.
 - 12 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 the UK and European Union.

MATERIAL: A-286 high temperature alloy per Spec. AMS5737 or AMS5731.

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

- FINISH:**
- HL445-()-() = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL445AP()-() = 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.
 - HL445AZ()-() = 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.
 - HL445EL()-() = Solid film lube per "Electrofilm" 4396.
 - HL445N()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, without lubricant (for use in LOX systems).
 - HL445PB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color code green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL445PY()-() = Passivate per AMS2700, Method 1, Type 8, Class 1.
 - HL445V()-() = Solid film lubricant per "Lubeco" 2123, Type II.

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. See Finish note for explanation of code letters.

**HOW TO ORDER
 EXAMPLE:**

