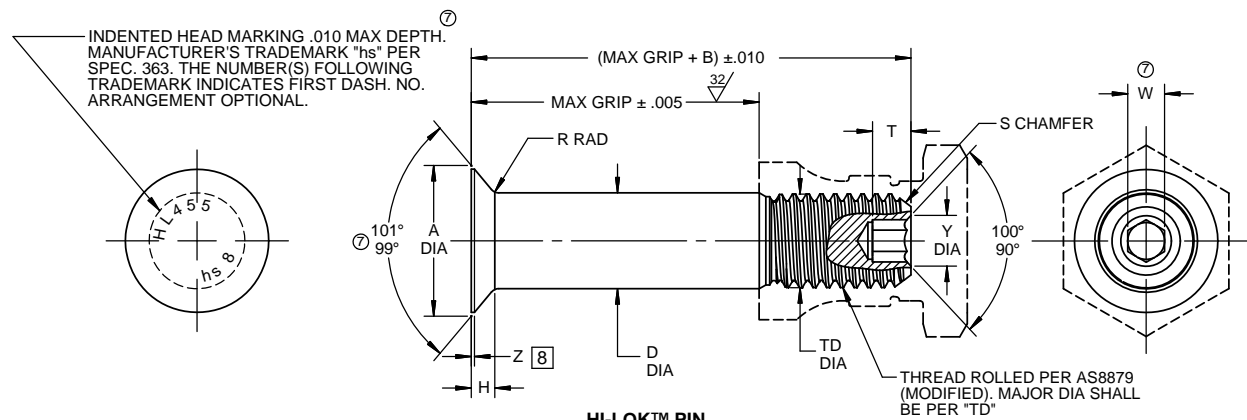
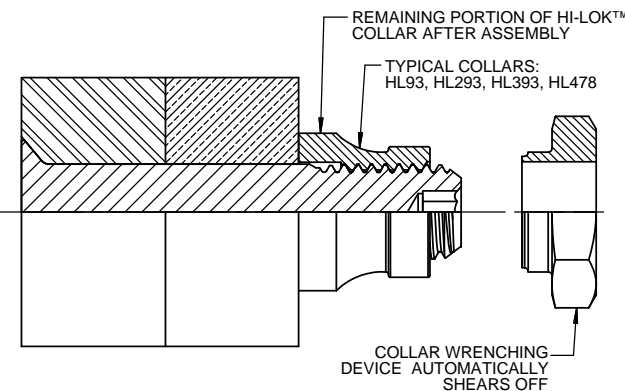


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HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

				[9]		[1]		[8]									
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING S.F.L. OR PLATING	WITH COATING S.F.L. OR PLATING								W HEX	T DEPTH	Y DIA		
5	13/64					NOTE: USE HL453-6- ()											
6	7/32	.3813 .3765	.325	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0684 .0664	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,100	3,180
8	9/32	.5066 .5018	.395	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0948 .0928	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	11,800	5,820
10	11/32	.6335 .6287	.500	.3432 .3427	.3432 .3422	.3060 .3020	.007	.1218 .1198	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	17,600	9,200
12	13/32	.7604 .7556	.545	.4057 .4052	.4057 .4047	.3680 .3640	.008	.1488 .1468	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	24,600	14,000
14	15/32	.8884 .8812	.635	.4682 .4677	.4682 .4672	.4310 .4260	.009	.1763 .1733	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	32,700	18,900
16	17/32	1.0139 1.0068	.685	.5307 .5302	.5307 .5297	.4930 .4880	.010	.2027 .1997	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	42,000	25,600
18	19/32	1.1408 1.1337	.770	.5927 .5922	.5927 .5917	.5550 .5500	.010	.2300 .2270	.050 .040	.025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	52,400	32,400
20	21/32	1.2723 1.2651	.825	.6552 .6547	.6552 .6542	.6180 .6120	.010	.2589 .2559	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	64,100	41,000
24	25/32	1.5308 1.5236	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.012	.3149 .3119	.050 .040	.025	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	90,900	59,500

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

DRAWN BY SHRODE	DATE 1987-10-17	TITLE HI-LOK™ PIN	
APPROVED MILLER	DATE 1987-10-17	100° FLUSH MS24694 TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 1/32 OVERSIZE	
REVISION 7	DATE M.BEARD 2017-06-26	DRAWING NUMBER HL455	

- 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" is dimensioned from maximum "D" diameter.
 - ⑦ 4. Dimensions are in inches and to be met after finish.
 - 5 Evidence of broken edge across point.
 - ⑦ 6. Surface texture per ASME B46.1.
 - 7. Hole preparation per NAS618.
 - 8 Curved or flat edge manufacturer's option.
 - 9 Maximum "D" diameter may be increased by .0002" to allow for plated, coated or solid film application.
 - 10 Non-lubed pin must be used with wet sealant or with lubed collars.
 - 11 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 European Union.

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

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum) at 70°F.

- FINISH:**
- HL455(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color blue on top of head and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 11 HL455AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 11 HL455AZ(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL455EL(-)(-) = Solid film lube per "Electrofilm" 4396.
 - HL455N(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2., without lubricant. (For use in LOX systems.)
 - HL455UC(-)(-) = 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.
 - 10 HL455PY(-)(-) = Passivate per Hi-Shear Spec. 258.
 - HL455PZ(-)(-) = 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 of the pin which HL455 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER

⑦ **EXAMPLE:**

Pin Part Number
HL455AP8-8

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

HL455

DRAWING NUMBER

HL455

2 OF 2