



HI-LOK™ PIN

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

[5]

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 COATING OR SOLID FILM LUBE	WITH COATING OR SOLID FILM LUBE							W HEX	T DEPTH	Y DIA		
5	5/32	.262 .242	.312	.1635 .1630	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0645 .0635	.135 .115	.090 .075	5,280	2,200
6	3/16	.315 .295	.325	.1895 .1890	.1895 .1885	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,060	3,000
8	1/4	.412 .387	.395	.2495 .2490	.2495 .2485	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	12,260	5,100
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	19,160	8,000
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	27,600	11,300
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	37,500	15,500
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	49,100	20,000
18	9/16	.864 .829	.770	.5615 .5610	.5615 .5605	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	62,100	25,000
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	76,700	30,200
24	3/4	1.108 1.066	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.070	.151 .136	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	110,400	40,200
28	7/8	1.285 1.241	1.210	.8740 .8735	.8740 .8730	.8680 .8610	.090	.187 .172	.050 .035	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	150,300	59,100
32	1	1.468 1.424	1.390	.9990 .9985	.9990 .9980	.9930 .9860	.110	.218 .203	.060 .045	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	196,300	80,000

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 VAN	DATE 1969-12-20	TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION
APPROVED J.M.	DATE 1969-12-23	
REVISION (12)	DATE A.CHAE 2020-12-11	DRAWING NUMBER HL644

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIR.
2. Dimensions are in inches and to be met after finish.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Maximum "D" diameter may be increased by .0002 to allow for solid film or coating application.
6. Use HL744 for oversize replacement.
7. 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: PH13-8Mo stainless steel per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: ⑫ HL644-()-() = Passivate per Hi-Shear Spec. 262 and solid film lube per AS5272, Type I.

⑦ HL644AP()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.

HL644LL()-() = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.

HL644TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.

HL644YE()-() = Passivate per Hi-Shear Spec. 262, white paint on head, and cetyl alcohol lube per Hi-Shear Spec. 305.

HL644HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

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:**

Pin Part Number
 HL644AP8-8

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

Pin and Collar Assembly Part Number Combination
 HL64479-8-8

Size and Grip Length, See Above Example
 Collar Part Number
 Pin Part Number

HL644

DRAWING NUMBER

HL644

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