



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
												W HEX	T DEPTH	Y DIA		
5																
NOTE: USE HL21-6-() or HL421-6-()																
6	13/64	.3813 .3765	.325	.2026 .2016	.1840 .1810	.005	.0750 .0730	.030 .020	.015	1/32" x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	6,130	3,180
8	17/64	.5066 .5018	.395	.2651 .2641	.2440 .2410	.006	.1013 .0993	.030 .020	.015	1/32" x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	10,490	5,820
10	21/64	.6335 .6287	.500	.3276 .3266	.3060 .3020	.007	.1283 .1263	.040 .030	.015	3/64" x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	16,000	9,200
12	25/64	.7604 .7556	.545	.3901 .3891	.3680 .3640	.008	.1553 .1533	.040 .030	.015	3/64" x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	22,700	14,000
14	29/64	.8884 .8812	.635	.4526 .4516	.4310 .4260	.009	.1828 .1798	.050 .040	.022	3/64" x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	30,600	18,900
16	33/64	1.0139 1.0068	.685	.5151 .5141	.4930 .4880	.010	.2093 .2063	.050 .040	.022	3/64" x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	39,600	25,600
18	37/64	1.1408 1.1337	.770	.5771 .5761	.5550 .5500	.010	.2365 .2335	.050 .040	.022	1/16" x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	49,700	32,400
20	41/64	1.2723 1.2561	.825	.6396 .6386	.6180 .6120	.010	.2654 .2624	.050 .040	.022	1/16" x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	61,000	41,000
24	49/64	1.5308 1.5236	1.050	.7646 .7636	.7430 .7370	.012	.3214 .3184	.050 .040	.022	1/16" x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	87,200	59,500

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions are in inches and to be met after plating.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Non-lubed pins must be used with wet sealant or with lubed collars.
 - Curved or flat edge manufacturer's option.
 - Use HL221 for oversize replacement.
- CODE:**
- HOW TO ORDER**
- EXAMPLE:**

First dash number indicates nominal diameter in 1/32nds of the pin which HL65 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

Pin Part Number
HL65PB8-8
8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Finish Code
Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HL65PB87-8-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Finish
Pin Part Number

MATERIAL: Alloy steel per AMS6415, AMS6349, or AMS-S-6049.

HEAT TREAT: 160,000-180,000 psi tensile per AMS-H-6875.

FINISH:

HL65-()-() = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

HL65A()-() = Cadmium plate per AMS2400-3 and cetyl alcohol lube per Hi-Shear Spec. 305.

HL65PB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

HL65PN()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

SPECIFICATION: HI-LOK™ Product Specification 342.

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY BRIEJ	DATE 1964-07-29	TITLE HI-LOK™ PIN 100° FLUSH MS24694 TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED CESSNA	DATE 1964-07-30	DRAWING NUMBER HL65
REVISION 16	DATE M.BEARD 2017-09-27	1 OF 1