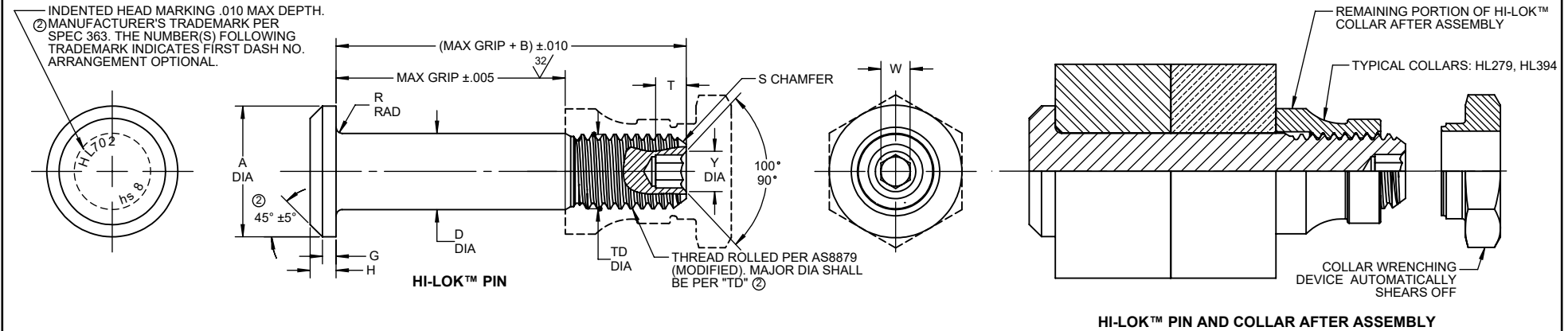


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②

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	AFTER COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
5	7/32	NOTE: USE HL40-6 or HL440-6														
6	15/64	.340 .320	.360	.2339 .2334	.2339 .2329	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,160	2,500
8	19/64	.440 .415	.430	.2963 .2958	.2963 .2953	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,100	4,300
10	23/64	.535 .505	.530	.3589 .3584	.3589 .3579	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	19,200	6,300
12	27/64	.635 .600	.575	.4214 .4209	.4214 .4204	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	26,500	8,700
14	31/64	.710 .675	.660	.4839 .4834	.4839 .4829	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	34,900	12,100
16	35/64	.800 .765	.710	.5464 .5459	.5464 .5454	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	44,600	15,300
18	39/64	.894 .859	.795	.6084 .6079	.6084 .6074	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	55,300	19,000
20	43/64	.983 .948	.850	.6709 .6704	.6709 .6699	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	67,200	23,000
24	51/64	1.138 1.096	1.075	.7959 .7954	.7959 .7949	.7430 .7370	.070	.151 .136	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	94,500	30,700
28	59/64	1.315 1.271	1.235	.9209 .9204	.9209 .9199	.8680 .8610	.090	.187 .172	.050 .035	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.455 .425	.471 .451	127,000	45,000
32	1-3/64	1.498 1.454	1.415	1.0459 1.0454	1.0459 1.0449	.9930 .9860	.110	.218 .203	.060 .045	5/64 x 45°	1.000-12 UNJF-3A	.5100 .5040	.580 .550	.618 .598	163,000	60,900

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 D.P.S.	DATE 1992-07-16	TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 3/64 OVERSIZE	
APPROVED A. BROWN	DATE 1992-07-20		
REVISION ②	DATE R. MANZANO 2023-03-03	DRAWING NUMBER HL702	

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- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIR.
 - ② 2. Dimensions are in inches and to be met after finish.
 - ② 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 - ⑤ Non-lubed pins must be used with wet sealant or with lubed collars..
 - ② ⑥ 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 the UK and European Union.

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

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

- ② **FINISH:**
- HL702-()-() = Passivate per AMS2700, Method 1, Type 8, Class 1, and Cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑤ HL702AZ()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL702CG()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color green on thread end, plus cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL702DU()-() = Solid film lube per MIL-PRF-46010, Type I.
 - ⑤ HL702N()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, without lube (For use in LOX systems).
 - ⑤ HL702PY()-() = Passivate per AMS2700, Method 1, Type 8, Class 1 (For use in LOX systems)
 - ② HL702NAZ()-() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305

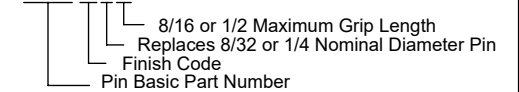
SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL702 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

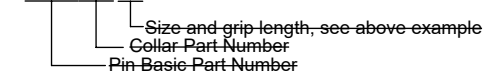
HOW TO ORDER

EXAMPLE: Pin Part Number Only

HL702AZ8-8



Pin and Collar Assembly Part Number Combination
HL702279-8-8



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REVISION ②	DATE R. MANZANO 2023-03-03	DRAWING NUMBER HL702	2 OF 2