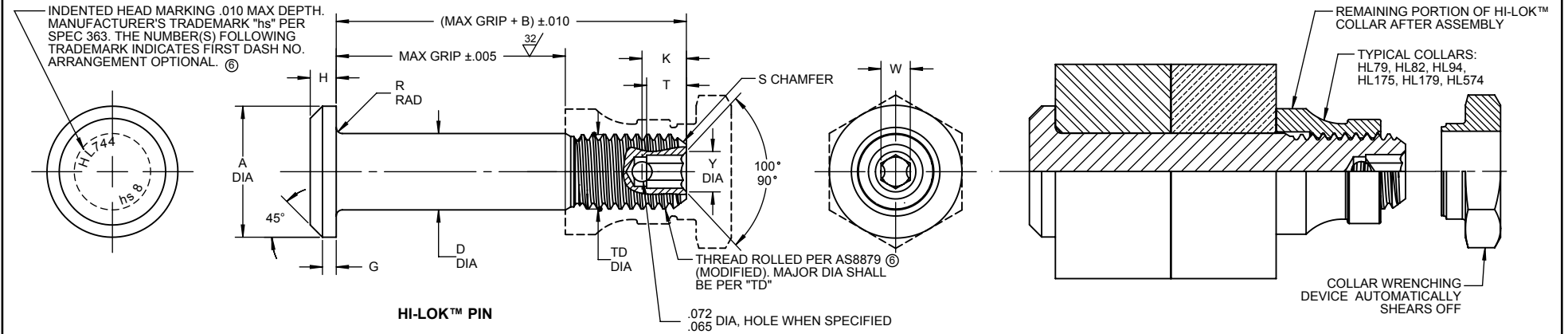




HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

⑤																	⑥																	* *	
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	K	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM																		
				WITHOUT SOLID FILM	WITH SOLID FILM								W HEX	T DEPTH	Y DIA																				
-5							NOTE: USE HL644-6																												
-6	13/64	.315 .295	.325	.2026 .2021	.2026 .2016	.1840 .1810	.025	.055 .045	-	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.1806 .0791	.135 .115	.119 .104	8,100	3,000																		
-8	17/64	.412 .387	.395	.2651 .2646	.2651 .2641	.2440 .2410	.030	.069 .059	.155 .135	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,800	5,100																		
-10	21/64	.505 .475	.500	.3276 .3271	.3276 .3266	.3060 .3020	.035	.078 .068	-	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	21,100	8,000																		
-12	25/64	.600 .565	.545	.3901 .3896	.3901 .3891	.3680 .3640	.040	.088 .078	-	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	30,000	11,300																		
-14	29/64	.676 .641	.635	.4526 .4521	.4526 .4516	.4310 .4260	.045	.105 .093	-	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	40,300	15,500																		
-16	33/64	.770 .735	.685	.5151 .5146	.5151 .5141	.4930 .4880	.050	.115 .103	-	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	52,200	20,000																		
-18	37/64	.864 .829	.770	.5771 .5766	.5771 .5761	.5550 .5500	.055	.127 .112	-	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	65,600	25,000																		
-20	41/64	.953 .918	.825	.6396 .6391	.6396 .6386	.6180 .6120	.060	.137 .122	-	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	80,600	30,200																		
-24	49/64	1.108 1.066	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.070	.151 .136	-	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	115,000	40,200																		
-28	57/64	1.285 1.241	1.210	.8896 .8891	.8896 .8886	.8680 .8610	.090	.187 .172	-	.050 .035	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	156,000	59,100																		
-32	1-1/64	1.468 1.424	1.390	1.0146 1.0141	1.0146 1.0136	.9930 .9860	.110	.218 .203	-	.060 .045	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	202,000	80,000																		

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

* * The Double Shear values shown are based on cross sectional area for nominal diameter pin.

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

DRAWN BY VAN	DATE 1971-02-19	TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED R. TING	DATE 1971-02-19	
REVISION ⑥	DATE F. CARINGELLA 2017-11-06	DRAWING NUMBER HL744

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIR.
- ⑥ 2. Dimensions are in inches and to be met after finish.
- ⑥ 3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
- ⑤ 5. Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
6. Use HL844 for oversize replacement.

MATERIAL: PH13-8Mo stainless steel per Spec. AMS5629

HEAT TREAT: 125,000 psi shear minimum.

FINISH:

- ⑥ HL744-()-() = Solid film lube per Spec. AS5272.
- ⑥ HL744-()-()D = Solid film lube per Spec. AS5272, and drilled hole.
- ⑥ HL744LL-()-() = Passivate per Hi-Shear Spec. 262. and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑥ HL744LL-()-()D = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL744TB-()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑥ HL744HK-()-() = 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 of the pin which HL744 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.
 "D" after second dash number indicates drilled thread.

HOW TO ORDER

⑥ **EXAMPLE:**

Pin Part Number
 HL744TB8-8

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
 HL74479-8-8

Size and Grip Length, see above example.
 Collar Part Number
 Pin Part Number

HL744

DRAWING NUMBER

HL744

2 OF 2