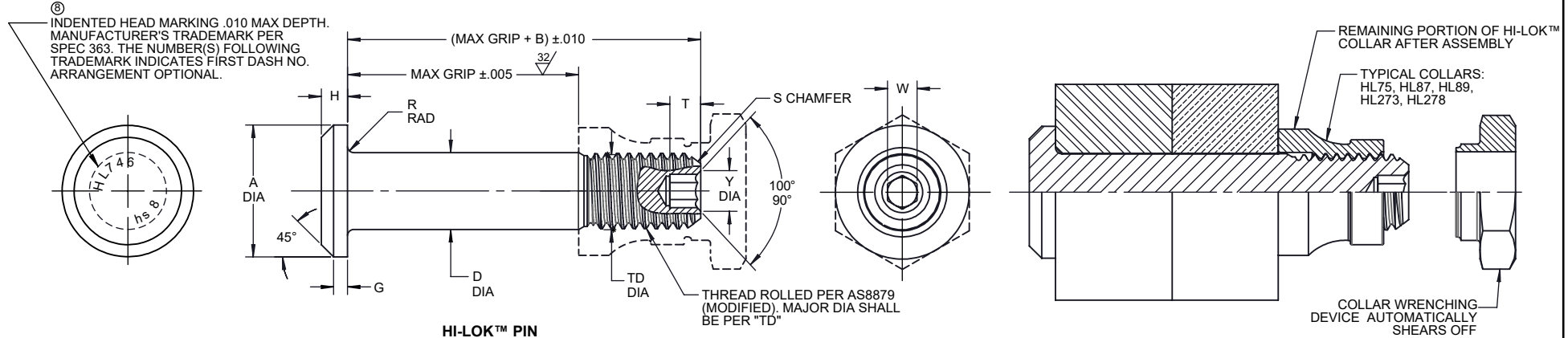




HI-LOK™ PIN

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

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 S.F.L	AFTER COATING OR S.F.L							W HEX	T DEPTH	Y DIA		
5	3/16			NOTE: USE HL646-6(-)												
6	13/64	.377 .357	.325	.2026 2021	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,100	4,350
8	17/64	.440 .415	.395	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,800	7,750
10	21/64	.505 .475	.500	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	21,100	12,300
12	25/64	.600 .565	.545	.3901 .3896	.3901 .3891	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	30,000	19,100
14	29/64	.676 .641	.635	.4526 .4521	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	40,300	25,800
16	33/64	.770 .735	.685	.5151 .5146	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	52,200	34,300
18	37/64	.877 .842	.770	.5771 .5766	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	65,600	43,500
20	41/64	.953 .918	.825	.6396 .6391	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	80,600	54,600
24	49/64	1.150 1.110	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	115,000	79,200
28	57/64	1.330 1.290	1.210	.8896 .8891	.8896 .8886	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	156,000	117,000
32	1-1/64	1.510 1.470	1.390	1.0146 1.0141	1.0146 1.0136	.9930 9860	.300	.435 .420	.060 .045	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	202,000	143,000

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

DRAWN BY VAN	DATE 1971-08-05	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION, 1/64 OVSZIE
APPROVED R. TING	DATE 1971-08-09	
REVISION 8	DATE K. MURKER 2019-11-19	DRAWING NUMBER HL746

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions are in inches and to be met after finish.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Use HL846 for oversize replacement.
- 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 European Union.

MATERIAL: PH13-8Mo stainless steel per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: ⑧ HL746-()-() = Solid film lube per AS5272, Type I.
 ⑥ HL746AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL746LL()-() = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL746TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL746PB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL746HK()-() = 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 HL746 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

⑧ **EXAMPLE:**

Pin Part Number
 HL746-8-8

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

⑧

HL746

DRAWING NUMBER

HL746

2 OF 2