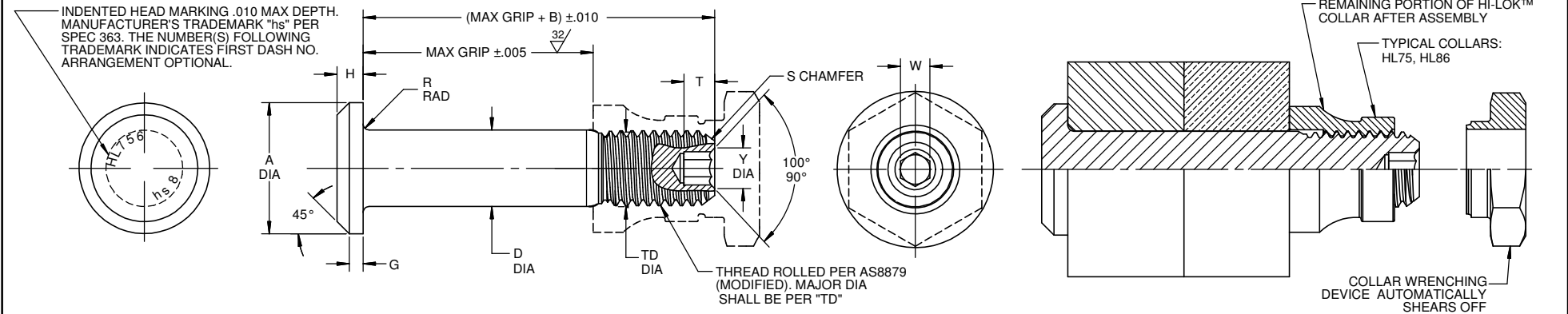


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HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

HI-LOK™ PIN

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD COLD-WORKED	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											W HEX	T DEPTH	Y DIA		
** 5	5/32	.322 .306	.312	.1635 .1625	.1595 .1570	.030	.060 .055	.025 .015	1/32 x 37°	.1640-32 UNJC-3A	.0645 .0635	.135 .115	.090 .075	4,010	2,180
6	3/16	.377 .357	.325	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	3,180
8	1/4	.440 .415	.395	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	5,820
10	5/16	.505 .475	.500	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	14,600	9,200
12	3/8	.600 .530	.545	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	14,000
14	7/16	.676 .592	.635	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	28,600	18,900
16	1/2	.770 .717	.685	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	37,300	25,600
18	9/16	.877 .842	.770	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	47,200	32,400
20	5/8	.953 .918	.825	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	58,300	41,000
24	3/4	1.150 1.110	1.050	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	83,900	59,500
28	7/8	1.330 1.290	1.210	.8740 .8730	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.455 .425	.471 .451	114,000	81,500
32	1	1.510 1.470	1.390	.9990 .9980	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 37°	1.0000-12 UNJF-3A	.5100 .5040	.580 .550	.618 .598	149,000	106,000

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

\*\* 5 Size must be installed using a torque controlled hex key.

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

DRAWN BY VAN	DATE 1970-07-15	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED R. TING	DATE 1970-04-24	
REVISION (16)	DATE F. CARINGELLA 2019-08-14	DRAWING NUMBER <b>HL756</b>

**GENERAL NOTES:**

1. Concentricity: "A" to "D" diameter within .010 FIR.
- 2 Dimensions are in inches and to be met before lubrication.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
- 5 Double shear test and fatigue test pins having grip equal two diameters or longer per Specification 342.
- 6 Dimensions are in inches and to be met after finish.
- 7 Non-lubed pins must be used with lubed collars or with wet sealant.
8. Use HL856 for oversize replacement.

**MATERIAL:**

6AL-4V titanium alloy per Spec. AMS4928 or AMS4967.

**HEAT TREAT:**

160,000 psi tensile minimum (95,000 psi shear minimum).

**16 FINISH:**

- 6 HL756BJ( )-( ) =I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3 and cetyl alcohol lube per Hi-Shear Spec. 305.
- 6 HL756BV( )-( ) =I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3 with color code blue on thread end. 7
- 6 HL756JB( )-( ) =I.V.D. aluminum coating per A/DET 0012 (.00015-.00045 thick), and cetyl alcohol lube per A/DET 0013.
- 2 HL756VF( )-( ) =Surface coating per Hi-Shear Spec. 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.

**SPECIFICATION:**

HI-LOK™ Product Specification 342. 5

**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**

**16 EXAMPLE:**

Pin Part Number  
HL756BJ8-8  
└─ 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**

HL756BJ86-8-8  
└─ Size and Grip Length, See Above Example  
└─ Collar Part Number  
└─ Pin Part Number