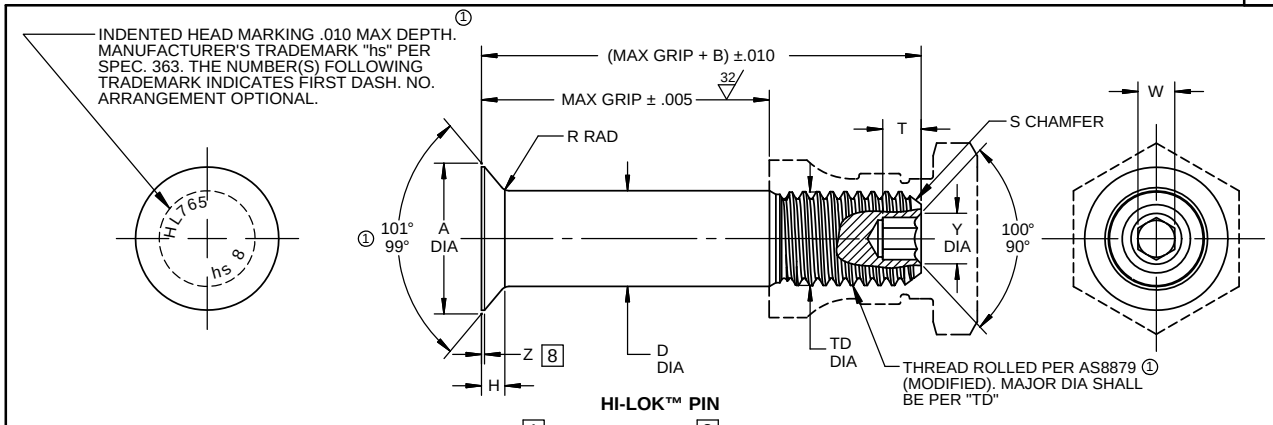
lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

Design Holder

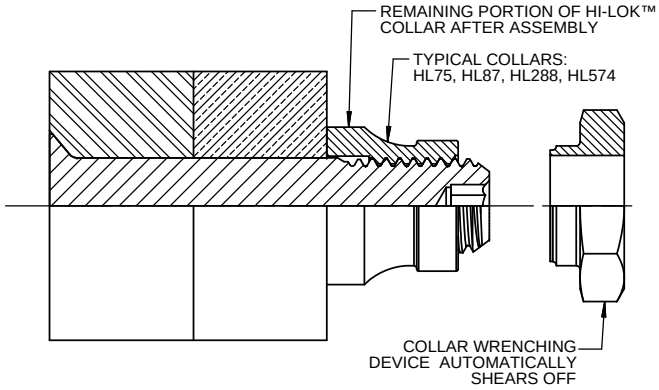
CAGE No. 73197

① For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



HI-LOK™ PIN

1 8 ①



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	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM **	TENSION POUNDS MINIMUM
5	3/16		NOTE: USE HL721-6													
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	.100 .080	.119 .104	6,970	3,850
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	.110 .090	.142 .122	11,920	6,550
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	.130 .110	.180 .160	18,200	10,350
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	.160 .140	.217 .197	25,800	15,750
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	.190 .170	.253 .233	34,800	21,200
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	.220 .200	.289 .269	45,000	28,800
18	37/64	1.1408 1.1337	.770	.5771 .5761	.5550 .5500	.010	.2365 .2335	.050 .040	.025	1/16" x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	56,500	36,400
20	41/64	1.2723 1.2651	.825	.6396 .6386	.6180 .6120	.010	.2654 .2624	.050 .040	.025	1/16" x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	69,300	46,100
24	49/64	1.5308 1.5236	1.050	.7646 .7636	.7430 .7370	.012	.3214 .3184	.050 .040	.025	1/16" x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	99,100	66,900

GENERAL NOTES:
1. Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
3. "H" is dimensioned from maximum "D" diameter.
① 4. Dimensions are in inches and to be met after plating.
5. Non-lubed pins must be used with wet sealant or with lubed collars.
① 6. Surface texture per ASME B46.1.
7. Hole preparation per NAS618.
8. Curved or flat edge manufacturer's option.
9. Use HL821 for oversize replacement.

MATERIAL: ① Alloy steel per Spec. AMS6415, AMS6349, or AMS-S-6322.

HEAT TREAT: ① 180,000-200,000 psi tensile per Spec. AMS-H-6875.

FINISH: ① HL765-( )-( ) = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
① HL765PN-( )-( ) = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2. (See note 5.)

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds which HL765 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

HOW TO ORDER
① **EXAMPLE:**

Pin Part Number
HL765PN8-8
- 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~~
~~HL76587-8-8~~
- ~~Size and Grip Length, See Above Example~~
- ~~Collar Part Number~~
- ~~Pin Part Number~~

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

DRAWN BY	DATE	TITLE
VAN	1974-04-09	HI-LOK™ PIN 100° FLUSH MS24694 TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED	DATE	
R.TING	1974-04-11	
REVISION	DATE	DRAWING NUMBER
①	M.BEARD 2017-11-15	HL765 1 OF 1

HL765