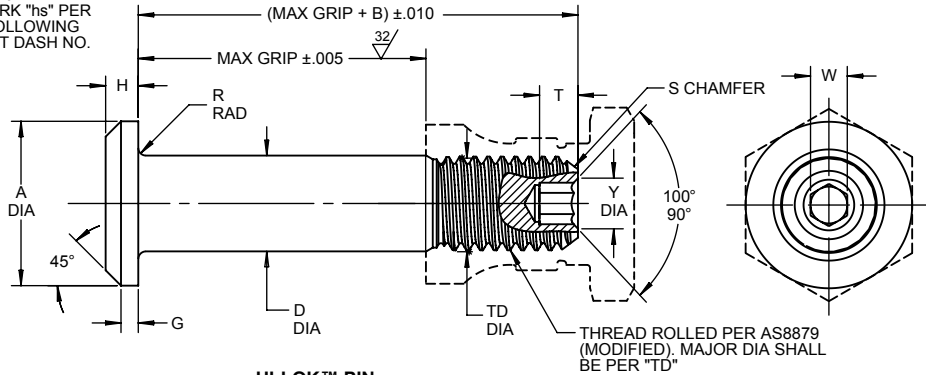
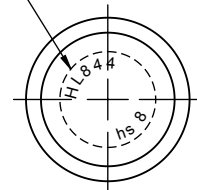
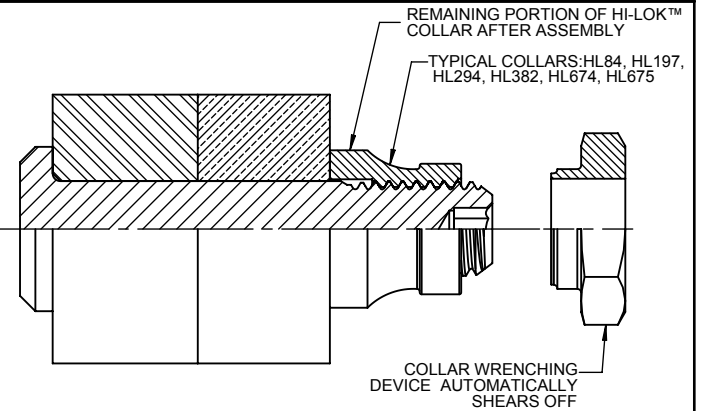


INDENTED HEAD MARKING .010 MAX DEPTH.
 MANUFACTURER'S TRADEMARK "hs" PER
 SPEC 363. THE NUMBER(S) FOLLOWING
 TRADEMARK INDICATES FIRST DASH NO.
 ARRANGEMENT OPTIONAL.



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 SOLID FILM LUBE	WITH SOLID FILM LUBE							W HEX	T DEPTH	Y DIA		
5	13/64			NOTE: USE HL744-6- ()												
6	7/32	.315 .295	.325	.2182 .2177	.2182 .2172	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,400	3,000
8	9/32	.412 .387	.395	.2807 .2802	.2807 .2797	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	15,500	5,100
10	11/32	.505 .475	.500	.3432 .3427	.3432 .3422	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	23,200	8,000
12	13/32	.600 .565	.545	.4057 .4052	.4057 .4047	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	32,400	11,300
14	15/32	.676 .641	.635	.4682 .4677	.4682 .4672	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	43,100	15,500
16	17/32	.770 .735	.685	.5307 .5302	.5307 .5297	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,400	20,000
18	19/32	.864 .829	.770	.5927 .5922	.5927 .5917	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	69,200	25,000
20	21/32	.953 .918	.825	.6552 .6547	.6552 .6542	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	84,500	30,200
24	25/32	1.108 1.066	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.070	.151 .136	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	120,000	40,200
28	29/32	1.285 1.241	1.210	.9052 .9047	.9052 .9042	.8680 .8610	.090	.187 .172	.050 .035	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	161,000	59,100
32	1-1/32	1.468 1.424	1.390	1.0302 1.0297	1.0302 1.0292	.9930 .9860	.110	.218 .203	.060 .045	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	209,000	80,000

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

DRAWN BY VAN	DATE 1971-11-19	TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED R. TING	DATE 1971-11-22	
REVISION 3	DATE KEVIN TRAN 2017-06-22	DRAWING NUMBER HL844

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 - ③ 2. Dimensions are in inches and to be met after finish.
 - ③ 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 application.

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

HEAT TREAT: 125,000 psi shear minimum.

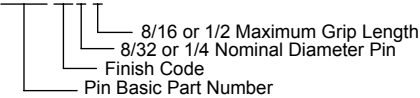
- FINISH:**
- ③ HL844-()-() = Solid film lube per AS5272.
 - ③ HL844LL-()-() = Passivate per Hi-Shear Spec. 262, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL844TB-()-() = HI-KOTE™ 2 solid film lube per Hi-Shear. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ③ HL844HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds which HL844 oversize pin replaces.
 second dash number indicates maximum grip in 1/16ths. see finish note for explanation of code letters.

HOW TO ORDER

③ **EXAMPLE:** Pin Part Number
 HL844TB8-8



Pin and Collar Assembly Part Number Combination



HL844

DRAWING NUMBER

HL844

2 OF 2