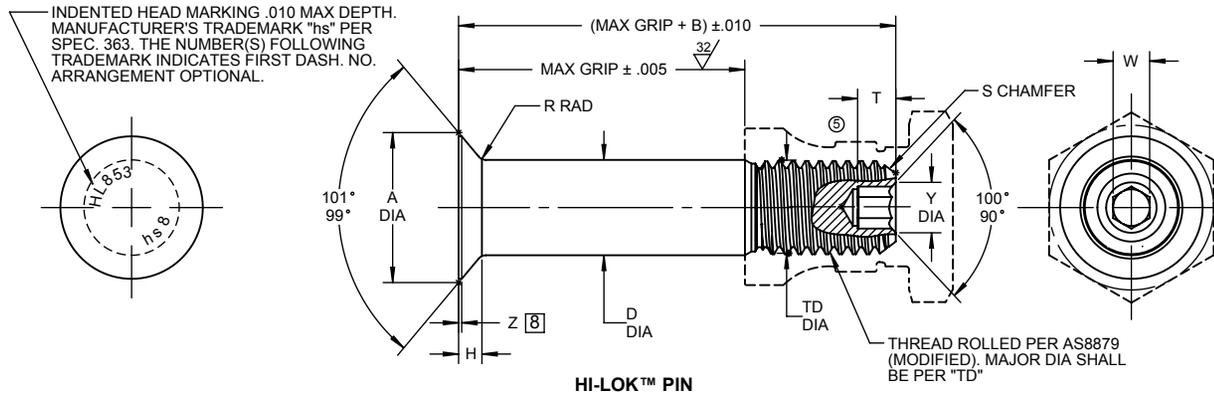


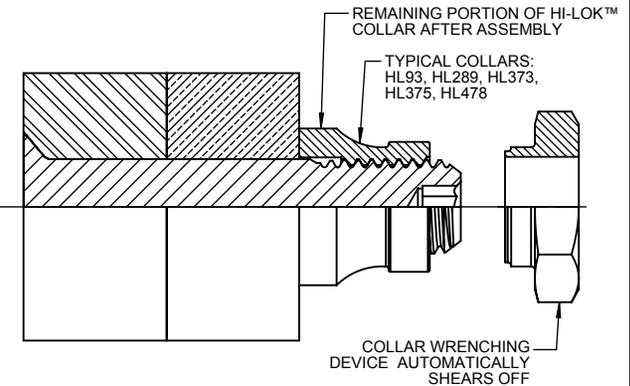
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HI-LOK™ PIN



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	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM								W HEX	T DEPTH	Y DIA			
5							NOTE: USE HL753()6(-)											
6	7/32	.3813 .3765	.325	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0684 .0664	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,400	4,350	
8	9/32	.5066 .5018	.395	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0948 .0928	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	15,500	7,750	
10	11/32	.6335 .6287	.500	.3432 .3427	.3432 .3422	.3060 .3020	.007	.1218 .1198	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	23,200	12,300	
12	13/32	.7604 .7556	.545	.4057 .4052	.4057 .4047	.3680 .3640	.008	.1488 .1468	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	32,400	19,100	
14	15/32	.8884 .8812	.635	.4682 .4677	.4682 .4672	.4310 .4260	.009	.1763 .1733	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	43,100	25,800	
16	17/32	1.0139 1.0068	.685	.5307 .5302	.5307 .5297	.4930 .4880	.010	.2027 .1997	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,400	34,300	
18	19/32	1.1408 1.1337	.770	.5927 .5922	.5927 .5917	.5550 .5500	.010	.2300 .2270	.050 .040	.025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	69,200	43,500	
20	21/32	1.2723 1.2651	.825	.6552 .6547	.6552 .6542	.6180 .6120	.010	.2589 .2559	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	84,500	54,600	
24	25/32	1.5308 1.5236	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.012	.3149 .3119	.050 .040	.025	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	120,000	79,200	
28	29/32	1.7845 1.7773	1.210	.9052 .9047	.9052 .9042	.8680 .8610	.014	.3689 .3659	.050 .040	.025	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	161,000	117,000	
32	1-1/32	2.0405 2.0310	1.390	1.0302 1.0297	1.0302 1.0292	.9930 .9860	.014	.4239 .4199	.050 .040	.025	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	209,000	143,000	

HL853

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

DRAWN BY J.F. OBISPO		DATE 2016-05-16		TITLE HI-LOK™ PIN	
APPROVED R. TING		DATE 1971-11-23		100° FLUSH MS24694 TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION, 1/32 OVERSIZE	
REVISION 5		DATE 2017-04-05		DRAWING NUMBER HL853	

- GENERAL NOTES:**
- 1] Head edge out of roundness shall not exceed "F".
 - 2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - ⑤ 3. Dimensions are in inches and to be met after finish.
 - ⑤ 4. Surface texture per ASME B46.1.
 - 5. Hole preparation per NAS618.
 - 6. "H" is dimensioned from maximum "D" diameter.
 - 7] Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
 - 8] Curved or flat edge manufacturer's option.
 - ⑤ 9] 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:**
- HL853-()-() = Solid film lube per AS5272, Type I.
 - ⑤ 9] HL853AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL853LL()-() = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL853PB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL853TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑤ HL853HK()-() = 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 HL853 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER

⑤ **EXAMPLE:** Pin Part Number

HL853PB8-8

