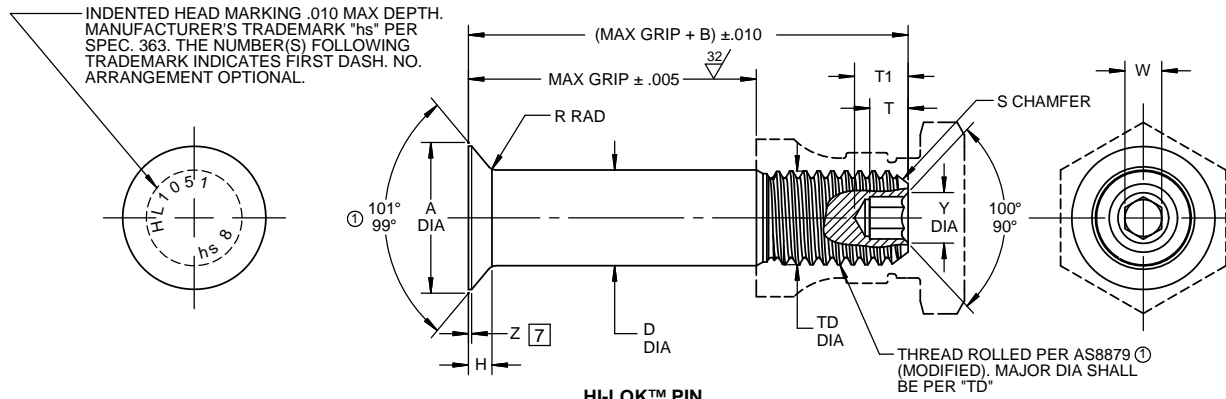
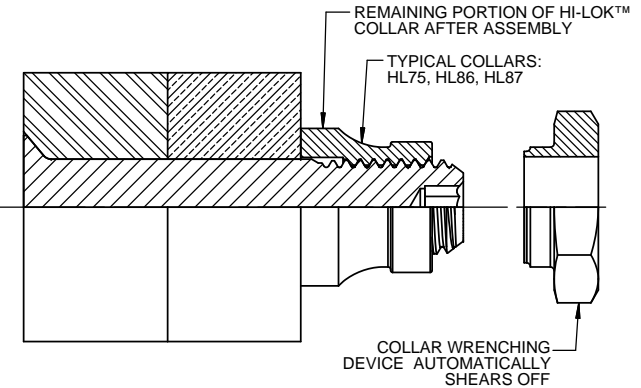


①

For the current list of licensed manufacturers, please visit the
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[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://WWW.LISI-AEROSPACE.COM/LICENSES)



HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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
												W HEX	T DEPTH	T1 DEPTH MAX	Y DIA		
5	5/32	.3304 .3256	.312	.1635 .1625	.1595 .1570	.004	.0700 .0680	.025 .015	.010	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	.140	[8]	4,010	2,180
6	3/16	.3813 .3765	.325	.1895 .1885	.1840 .1810	.005	.0805 .0785	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.140	.119 .104	5,380	3,180
8	1/4	.5066 .5018	.395	.2495 .2485	.2440 .2410	.006	.1080 .1060	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.160	.142 .122	9,300	5,820
10	5/16	.6335 .6287	.500	.3120 .3110	.3060 .3020	.007	.1350 .1330	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.200	.180 .160	14,600	9,200
12	3/8	.7604 .7556	.545	.3745 .3735	.3680 .3640	.008	.1620 .1600	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.235	.217 .197	21,000	14,000
14	7/16	.8884 .8812	.635	.4370 .4360	.4310 .4260	.009	.1895 .1865	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.280	.253 .233	28,600	18,900
16	1/2	1.0139 1.0068	.685	.4995 .4985	.4930 .4880	.010	.2160 .2130	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.320	.289 .269	37,300	25,600

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

- GENERAL NOTES:**
- ① Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within .003 FIM.
 3. "H" is dimensioned from maximum "D" diameter.
 - ④ Dimensions are in inches and to be met after finish.
 - ⑤ Surface texture per ASME B46.1.
 - ⑥ Hole preparation per NAS618.
 - ⑦ Curved or flat edge manufacturer's option.
 - ⑧ Evidence of broken edge across points.
 9. Use HL1053 for oversize replacement.

MATERIAL: ① Alloy steel per AMS6415, AMS6322, AMS6349.

HEAT TREAT: 160,000-180,000 psi tensile per AMS-H-6875.

FINISH: HL1051PB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ Product Specification 342.

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
① **EXAMPLE:**

Pin Part Number
HL1051PB8-8

— 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
HL1051AZ86-8-8

— Size and Grip Length, See Above Example
— Collar Part Number
— Pin Finish
— Pin Basic Part Number

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			TITLE HI-LOK™ PIN 100° FLUSH MS24694 TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION	
DRAWN BY J.F.OBISPO	DATE 2003-10-23		DRAWING NUMBER HL1051	
APPROVED M.CAWLEY	DATE 2003-10-23			
REVISION ①	DATE M.BEARD 2017-08-07		1 OF 1	