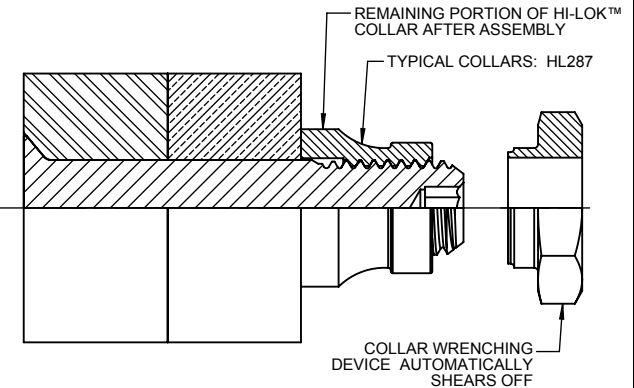


HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

[1]																	[7]																
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F REF	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	7/32						NOTE: USE HL749( )6-( )																										
6	15/64	.3813 .3765	.360	.2339 .2334	.2339 .2329	.1840 .1810	.005	.0618 .0598	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,160	3,180																
8	19/64	.5066 .5018	.430	.2963 .2958	.2963 .2953	.2440 .2410	.006	.0882 .0862	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,100	5,820																
10	23/64	.6335 .6287	.530	.3589 .3584	.3589 .3579	.3060 .3020	.007	.1152 .1132	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	19,200	9,200																
12	27/64	.7604 .7556	.575	.4214 .4209	.4214 .4204	.3680 .3640	.008	.1422 .1402	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	26,500	14,000																
14	31/64	.8884 .8812	.660	.4839 .4834	.4839 .4829	.4310 .4260	.009	.1697 .1667	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	34,900	18,900																
16	35/64	1.0139 1.0068	.710	.5464 .5459	.5464 .5454	.4930 .4880	.010	.1961 .1931	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	44,600	25,600																
18	39/64	1.1408 1.1337	.795	.6084 .6079	.6084 .6074	.5550 .5500	.010	.2234 .2204	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	55,300	32,400																
20	43/64	1.2723 1.2651	.850	.6709 .6704	.6709 .6699	.6180 .6120	.010	.2523 .2493	.050 .040	.022	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	67,200	41,000																
24	51/64	1.5308 1.5236	1.075	.7959 .7954	.7959 .7949	.7430 .7370	.012	.3083 .3053	.050 .040	.022	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	94,500	59,500																

④

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

HL1205

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

DRAWN BY HC	DATE 1992-09-22	TITLE HI-LOK™ PIN	
APPROVED A. BROWN	DATE 1992-09-30	100° FLUSH MS24694 TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 3/64 OVERSIZE	
REVISION 4	DATE F. CARINGELLA 2018-09-19	DRAWING NUMBER <b>HL1205</b>	

1 OF 2

- 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. Dimensions are in inches and to be met after finish.
  - 4. Surface texture per ASME B46.1.
  - 5. Hole preparation per NAS618.
  - 6. "H" is dimensioned from maximum "D" diameter.
  - 7 Curved or flat edge manufacturer's option.
  - 8 Non-lubed pins must be used with lubed collars or wet sealant
  - 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:** A-286 high temperature alloy per AMS5737 or AMS5731.

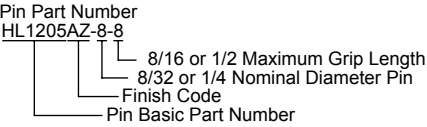
**HEAT TREAT:** 95,000 psi shear minimum at 70°F.

- FINISH:**
- HL1205-( )-( ) = Passivate per Hi-Shear Spec. 258, and Cetyl alcohol lube per Hi-Shear Spec. 305.
  - 9 HL1205AZ( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1205CG( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL1205DU( )-( ) = Solid film lube per AS5272, Type I.
  - 8 HL1205N( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, without lube (for use in LOX systems).
  - 8 HL1205PY( )-( ) = Passivate per Hi-Shear Spec. 258.

**SPECIFICATION:** HI-LOK™ Product Specification 342.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HL1205 oversize pin replaces.  
 Second dash number indicates maximum grip in 1/16ths.  
 See Finish note for explanation of code letters.

**HOW TO ORDER  
 EXAMPLE:**



HL1205