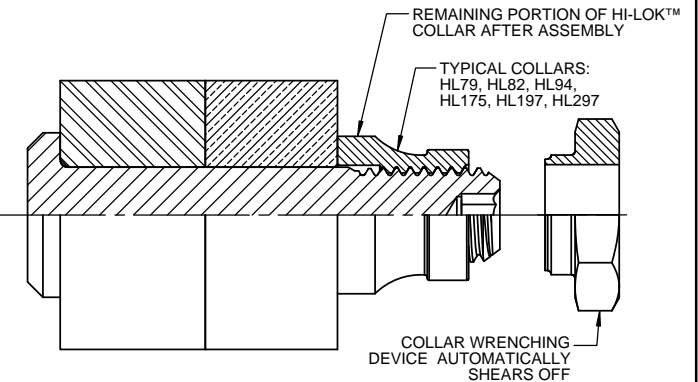
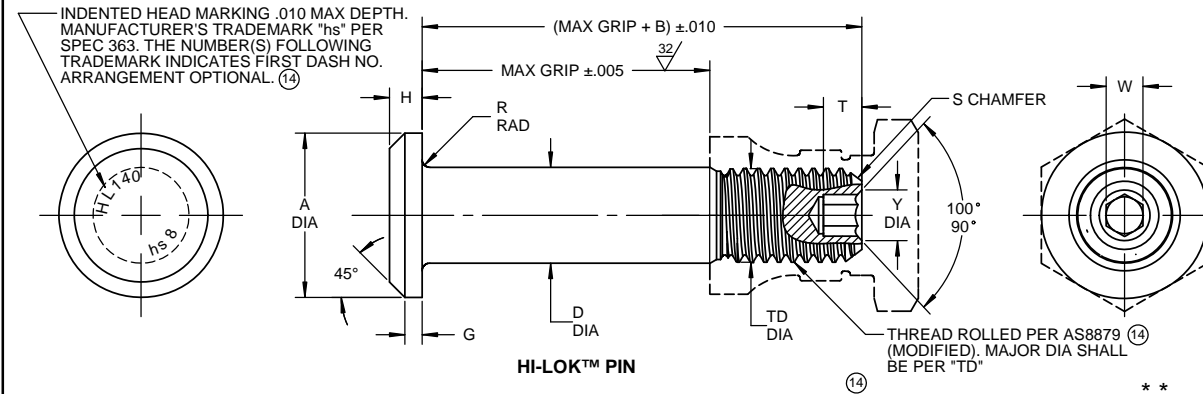


(14)

For the current list of licensed manufacturers, please visit the
 LISI AEROSPACE website at:
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)



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 COATING, PLATING OR SOLID FILM	WITH COATING, PLATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
5	3/16						NOTE: USE HL40-6-()									
6	13/64	.315 .295	.325	.2026 .2021	.2026 .2016	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	6,130	2,500
8	17/64	.412 .387	.395	.2651 .2646	.2651 .2641	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	10,490	4,300
10	21/64	.505 .475	.500	.3276 .3271	.3276 .3266	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	16,000	6,300
12	25/64	.600 .565	.545	.3901 .3896	.3901 .3891	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	22,700	8,700
14	29/64	.676 .641	.635	.4526 .4521	.4526 .4516	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	30,600	12,100
16	33/64	.770 .735	.685	.5151 .5146	.5151 .5141	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	39,600	15,300
18	37/64	.864 .829	.770	.5771 .5766	.5771 .5761	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	49,700	19,000
20	41/64	.953 .918	.825	.6396 .6391	.6396 .6386	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	61,000	23,000
24	49/64	1.108 1.066	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.070	.151 .136	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	87,200	30,700

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions are in inches and to be met after finish.
 3. Non-lubed pins must be used with lubed collars.
 4. Surface texture per ASME B46.1.
 5. Hole preparation per NAS618.
 6. Use HL240 for oversize replacement.
 - 7 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced NC by REACH compliant HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: A-286 high temperature alloy per Spec. AMS5737 or AMS5731.

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

- FINISH:** HL140(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- 14 7 HL140AZ(-)(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 14 HL140DU(-)(-) = Solid film lube AS5272, Type I.
 - 3 HL140GU(-)(-) = Silver plate per AMS2410.
 - 3 HL140PY(-)(-) = Passivate per Hi-Shear Spec. 258.
 - 3 HL140V(-)(-) = Solid film lubricant per LUBECO™ 2123, Type II.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL140 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER

(14) **EXAMPLES:**

Pin Part Number
 HL140AZ8-8
 — 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
 HL14079-8-8
 — 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.

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY BRLEJ	DATE 1965-03-08	TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED MILLER	DATE 1965-03-08		
REVISION (14)	DATE M.BEARD 2017-11-07	DRAWING NUMBER HL140	

1 OF 1