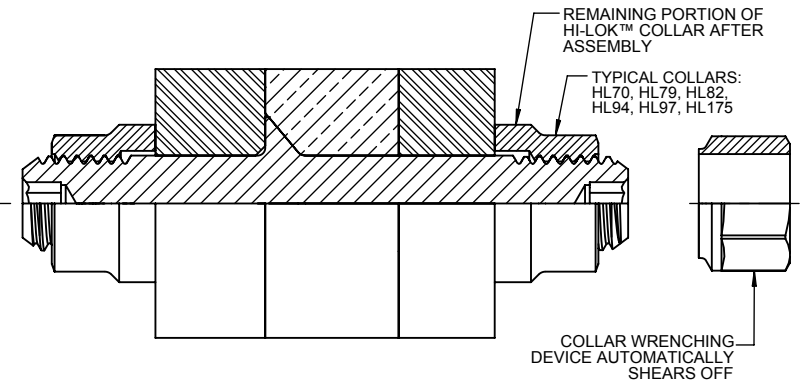


HI-LOK™ THREADED STUD PIN



HI-LOK™ THREADED STUD 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
				WITH COATING OR SOLID FILM	WITH COATING OR SOLID FILM								W HEX	T DEPTH	Y DIA		
6	3/16	.3536 .3486	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.069 .067	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	2,590
8	1/4	.4732 .4632	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.094 .092	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	4,760
10	5/16	.5619 .5569	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.105 .103	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.119 .104	14,600	7,100
12	3/8	.6912 .6862	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.133 .131	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	10,600

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

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
  - Concentricity: Conical surface of head to "D" diameter within .005 FIM. Threaded stud side to pin side within .010 FIM.
  - "H" is dimensioned from maximum "D" diameter.
  - Dimensions are in inches and to be met after finish.
  - Surface texture per ASME B46.1.
  - Hole preparation per NAS618.
  - Use HL245 for oversize replacement.
  - Curved or flat edge manufacturer's option.
  - Maximum "D" diameter may be increased by .0002 to allow for aluminum coating application.
  - 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:** 6Al-4V titanium alloy per AMS4928 or AMS4967.

**HEAT TREAT:** 95,000 psi shear minimum.

**FINISH:** HL145-( )-( )-( ) = Cetyl alcohol per Hi-Shear Spec. 305.  
 10HL145AP( )-( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL145DL( )-( )-( ) = Kalgard FA or EM620C solid film lube per AS5272, Type I, 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.  
 Third dash number indicates stud end grip in 1/16ths.  
 See Finish note for explanation of code letters.

**HOW TO ORDER**

EXAMPLE: Threaded Stud Pin Part Number  
 HL145AP-8-8-8

8/16 or 1/2 Threaded Stud Maximum Grip Length  
 8/16 or 1/2 Pin Maximum Grip Length  
 8/32 or 1/4 Nominal Pin Diameter  
 Finish Code  
 Pin Basic Part Number

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

DRAWN BY VAN	DATE 1969-11-05	TITLE HI-LOK™ THREADED STUD PIN 100° FLUSH MS20426 SHEAR HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED J.M.	DATE 1969-11-05	
REVISION 8	DATE F.CARINGELLA 2017-11-21	DRAWING NUMBER <b>HL145</b>