



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	G REF	H	R RAD	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		HL75 HL86 HL87	HL73 HL273 HL89	
5	5/32	.322 .306	.312	.1635 .1630	.1635 .1625	.1595 .1570	.030	.060 .055	.025 .015	1/32" x 45°	.1640-32 UNJC-3A	.0645 .0635	.135 .115	5,280	2,300	2,940	
6	3/16	.377 .357	.325	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	7,060	2,750	4,000	
8	1/4	.440 .415	.395	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	12,260	5,000	7,500	
10	5/16	.502 .472	.500	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	19,160	8,300	11,750	
12	3/8	.565 .530	.545	.3745 .3740	.3745 .3735	.3680 .3640	.065	.140 .130	.030 .020	3/64" x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	27,600	12,700	18,000	
14	7/16	.627 .592	.635	.4370 .4365	.4370 .4360	.4310 .4260	.075	.160 .150	.030 .020	3/64" x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	37,500	19,000	23,750	
16	1/2	.752 .717	.685	.4995 .4990	.4995 .4985	.4930 .4880	.085	.188 .178	.030 .020	3/64" x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	49,100	25,500	32,000	

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

DRAWN BY VAN	DATE 1968-08-13	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD PH15-7Mo STAINLESS STEEL 1/16 GRIP VARIATION
APPROVED J. Miller	DATE 1968-08-13	
REVISION 2	DATE B. CHAN 2021-06-29	DRAWING NUMBER HL152

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
- ② 2. Surface texture per ASME B46.1.
3. Hole preparation per NAS618.
4. 5 Size must be installed using a torque controlled hex key
5. 303Se Steel Collars see reference collar standards page for detail dimensions
6. 17-PH Steel Collars see reference collar standards page for detail dimensions

MATERIAL: PH15-7Mo stainless steel per AMS5657

HEAT TREAT: 125,000 PSI Shear Min.

FINISH: HL152-()-() = Passivate per AMS2700, Method 1, Type 8, Class 1 ②

SPECIFICATION: HI-LOK™ Product Specification HS342. ②

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

EXAMPLE:

Pin Part Number

HL152 - 8 - 8

8/16 or 1/2 Maximum Grip Length
 Replaces 8/32 or 1/4 Nominal Diameter Pin
 Collar Part Number
 Pin Basic Part Number

Pin and Collar Part Number Combination

HL152-86-8-8

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

HL152

DRAWING NUMBER

HL152

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