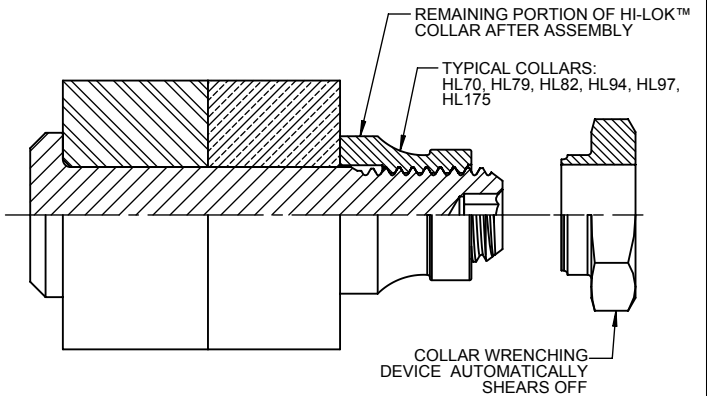


HI-LOK™ PIN



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
											W HEX	T DEPTH	Y DIA		
5	5/32	.262 .242	.312	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.080 .080	5	5,570	2,200
6	3/16	.315 .295	.325	.1895 .1885	.1840 .1810	.025	.055 .045	.030 .020	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,480	3,000
8	1/4	.412 .387	.395	.2495 .2485	.2440 .2410	.030	.069 .059	.030 .020	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,000	5,500
10	5/16	.505 .475	.500	.3120 .3110	.3060 .3020	.035	.078 .068	.040 .030	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	20,200	8,000
12	3/8	.600 .565	.545	.3745 .3735	.3680 .3640	.040	.088 .078	.040 .030	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	29,200	11,000
14	7/16	.676 .641	.635	.4370 .4360	.4310 .4260	.045	.105 .093	.050 .040	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	39,700	15,500
16	1/2	.770 .735	.685	.4995 .4985	.4950 .4880	.050	.115 .103	.050 .040	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	51,800	19,500
18	9/16	.864 .829	.770	.5615 .5605	.5550 .5500	.055	.127 .112	.050 .040	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	65,600	24,500
20	5/8	.953 .918	.825	.6240 .6230	.6180 .6120	.060	.137 .122	.050 .040	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	81,000	29,500
24	3/4	1.108 1.066	1.050	.7490 .7480	.7430 .7370	.070	.151 .136	.050 .040	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	117,000	39,500

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions are in inches and to be met after finish.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
- 5 Evidence of broken edge across points.

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
 HL156PB8-8

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
 HL156PB70-8-8

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

MATERIAL: Multiphase MP35N per AMS5758 or AMS5844.

HEAT TREAT: 132,000 psi shear minimum.

FINISH: 6 HL156(-)(-) = LF31-35-8 solid film lubricant.
 (This finish is no longer available, parts in
 stock are ok until depleted. Substitute with solid
 film lube per Everlube 382.)

HL156KF(-)(-) = Passivate and Everlube 382.

HL156PB(-)(-) = 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.

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY VAN	DATE 1971-07-27	TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD MP35N "MULTIPHASE" 1/16 GRIP VARIATION	
APPROVED R. TING	DATE 1971-07-29		
REVISION 6	DATE F. CARINGELLA 2017-11-21	DRAWING NUMBER HL156	