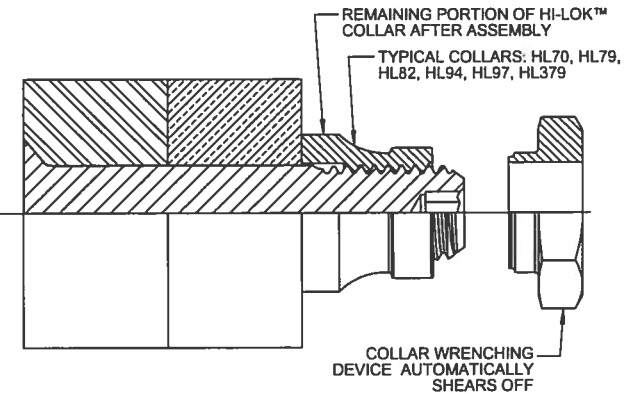
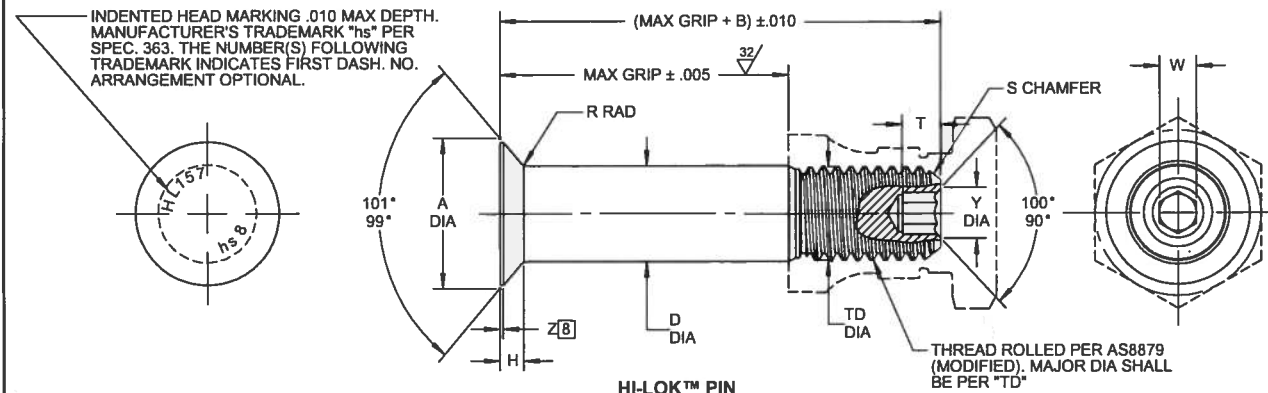


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HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
5	5/32	.2612 .2564	.312	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.010	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	.119 .104	5,570	1,800
6	3/16	.3016 .2966	.325	.1895 .1885	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,480	2,700
8	1/4	.3948 .3898	.395	.2495 .2485	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,000	4,700
10	5/16	.4739 .4689	.500	.3120 .3110	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	20,200	7,400
12	3/8	.5604 .5554	.545	.3745 .3735	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	29,200	10,500
14	7/16	.6680 .6620	.635	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	39,700	14,500
16	1/2	.7540 .7480	.685	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	51,800	19,000
18	9/16	.8380 .8310	.770	.5615 .5605	.5550 .5500	.010	.1160 .1130	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	65,600	24,000
20	5/8	.8250 .9180	.825	.6240 .6230	.6180 .6120	.010	.1260 .1230	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	81,000	29,500
24	3/4	1.0970 1.0850	1.050	.7490 .7480	.7430 .7370	.012	.1460 .1410	.050 .040	.025	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	117,000	42,000

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .003 FIM.
 - Dimensions to be met after finish and before solid film lubricant.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - "H" is dimensioned from maximum "D" diameter.
 - Evidence of broken edge across points.
 - Curved or flat edge manufacturer's option.
 - Use HL1157 for oversize replacement.

MATERIAL: Multiphase MP35N per AMS5758 or AMS5844.

HEAT TREAT: 132,000 psi shear minimum.

- ⑤ **FINISH:** HL157-() = LF31-35-8 solid film lubricant.
(This finish no longer available, parts in stock are ok until depleted. Substituted with solid film lube per Everlube 382.)
- HL157PB() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL157KF() = Passivate and solid film lube per Everlube 382.

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.
See Finish note for explanation of code letters.

**HOW TO ORDER
EXAMPLE:**

Pin Part Number
HL157PB8-8

8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Cadmium Plating, Type II, Class 2
Pin Basic Part Number

"HI-LOK", "HL", and "HI-KOTE",
are Trademarks of Hi-Shear Corporation

DRAWN BY VAN		DATE 1971-07-27		TITLE HI-LOK™ PIN	
APPROVED R. Ting		DATE 1971-07-29		100° FLUSH SHEAR HEAD MP35N "MULTIPHASE" 1/16 GRIP VARIATION	
REVISION ⑤		DATE J. Obispo 2017-06-22		DRAWING NUMBER HL157	