



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	.322 .306	.312	.1635 .1625	.1595 .1570	.035	.065 .060	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.080 .065	[6]	5,570	3,080
6	3/16	.377 .357	.325	.1895 .1885	.1840 .1810	.040	.085 .075	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,480	4,550
8	1/4	.440 .415	.395	.2495 .2485	.2440 .2410	.055	.110 .100	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,000	8,100
10	5/16	.505 .475	.500	.3120 .3110	.3060 .3020	.080	.140 .130	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	20,200	12,900
12	3/8	.600 .565	.545	.3745 .3735	.3680 .3640	.110	.175 .165	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	29,200	20,000
14	7/16	.676 .641	.635	.4370 .4360	.4310 .4260	.135	.200 .190	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	39,700	26,900
16	1/2	.770 .735	.685	.4995 .4985	.4930 .4880	.145	.240 .230	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	51,800	36,000
18	9/16	.877 .842	.770	.5615 .5605	.5550 .5500	.245	.330 .320	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	65,600	45,600
20	5/8	.953 .918	.825	.6240 .6230	.6180 .6120	.260	.360 .350	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	81,000	57,200
24	3/4	1.150 1.110	1.050	.7490 .7480	.7430 .7370	.265	.390 .375	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	117,000	83,000

- 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.
 6. Use HL1158 for oversize replacement.

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
 HL158PB8-8

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

MATERIAL: Multiphase MP35N per AMS5758 and AMS5844.

HEAT TREAT: 132,000 psi shear minimum (220,000 psi tensile minimum).

FINISH: HL158-()-() = 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.)
 HL158KF-()-() = Passivate and Everlube 382.
 HL158PB-()-() = 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 1971-07-21	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD MP35 "MULTIPHASE" 1/16 GRIP VARIATION	
J.F. OBISPO	2015-09-28		
APPROVED R. TING	DATE 1971-07-22	DRAWING NUMBER HL158	
REVISION 10	DATE A.CHAE 2021-01-28		