



HI-LOK™ PIN

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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	WITH COATING							W HEX	T DEPTH	Y DIA		
4	1/8	.290 .275	.294	.1375 .1370	.1375 .1365	.1335 .1310	.025	.055 .045	.020 .010	1/32 x 45°	.1380-32 UNJC-3A	.0645 .0635	.100 .085	[5]	2,840	1,450
5	5/32	.322 .306	.312	.1635 .1630	.1635 .1625	.1595 .1570	.030	.065 .055	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	[5]	4,010	2,180
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	.110 .080	.119 .104	5,380	3,180
8	1/4	.440 .415	.395	.2495 .2490	.2495 .2480	.2440 .2410	.045	.090 .077	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,300	5,820

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

- 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
 HL244TB6-8
 8/16 or 1/2 Maximum Grip Length
 6/32 or 3/16 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number
 Pin and Collar Assembly Part Number Combination
 HL244189-6-8
 Size and Grip Length, See Above Example
 Collar Part Number
 Pin Part Number

MATERIAL: Waspaloy high temperature alloy per AMS5708.

HEAT TREAT: 160,000 psi tensile minimum at 70°F.

FINISH: HL244-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol tube per Hi-Shear Spec. 305.
 HL244TB-()-() = Passivate per Hi-Shear Spec. 258, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol tube 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 1969-01-03	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD WASPALOY HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION
APPROVED J.M	DATE 1969-01-07	
REVISION 7	DATE KEVIN TRAN 2017-06-22	DRAWING NUMBER HL244