



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 OR SOLID FILM | AFTER COATING OR SOLID FILM | | | | | | | W HEX | T DEPTH | Y DIA | | |
| 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 | .090 .075 | 5,280 | 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 | .119 .104 | 7,060 | 4,350 |
| 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 | .142 .122 | 12,260 | 7,750 |
| 10 | 5/16 | .505 .475 | .500 | .3120 .3115 | .3120 .3110 | .3060 .3020 | .055 | .112 .102 | .030 .020 | 3/64 x 45° | .3125-24 UNJF-3A | .1295 .1270 | .170 .150 | .180 .160 | 19,160 | 12,300 |
| 12 | 3/8 | .600 .530 | .545 | .3745 .3740 | .3745 .3735 | .3680 .3640 | .075 | .140 .130 | .030 .020 | 3/64 x 45° | .3750-24 UNJF-3A | .1617 .1582 | .200 .180 | .217 .197 | 27,600 | 19,100 |
| 14 | 7/16 | .676 .592 | .635 | .4370 .4365 | .4370 .4360 | .4310 .4260 | .095 | .160 .150 | .030 .020 | 3/64 x 45° | .4375-20 UNJF-3A | .1930 .1895 | .230 .210 | .253 .233 | 37,500 | 25,800 |
| 16 | 1/2 | .770 .717 | .685 | .4995 .4990 | .4995 .4985 | .4930 .4880 | .095 | .188 .178 | .030 .020 | 3/64 x 45° | .5000-20 UNJF-3A | .2242 .2207 | .260 .240 | .289 .269 | 49,100 | 34,300 |

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. Non-lube pins must be used with wet sealant or with lubed collars.
 6. Use HL36 for oversize replacement.
 7. After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in the UK and European Union.

MATERIAL: Type 431 stainless steel per AMS5628.

HEAT TREAT: 125,000 psi shear minimum.

- FINISH**
- HL32(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL32AP(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL32D(-)(-) = Solid film lube per Spec. AS5272, Type I.
 - HL32NAP(-)(-) = HI-KOTE™ 1 NC Aluminum Pigmented Coating per Hi-Shear Spec. 294 and cetyl alcohol per Hi-Shear Spec. 305.
 - HL32PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL32PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

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
 HL32AP8-8

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

| "HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION | | | |
|--|--------------------------------|---|--|
| DRAWN BY SCHAD | DATE 1957-04-26 | TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD 431 STAINLESS STEEL 1/16 GRIP VARIATION | |
| APPROVED CESSNA | DATE 1957-04-26 | DRAWING NUMBER HL32 | |
| REVISION (21) | DATE C.Artois 2023-04-25 | 1 OF 1 | |