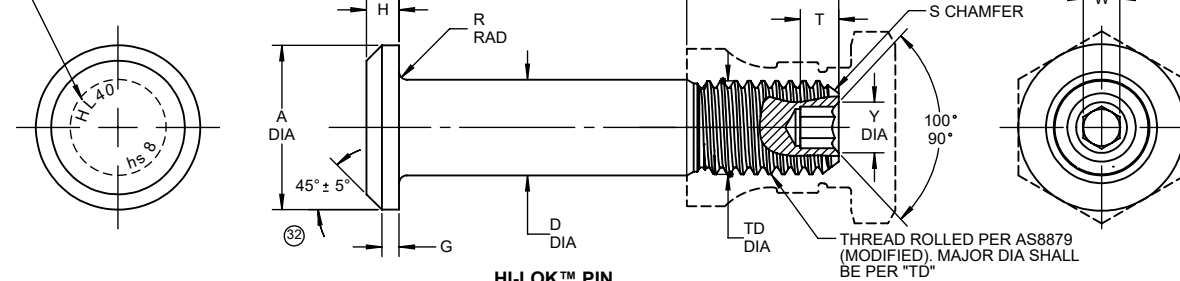
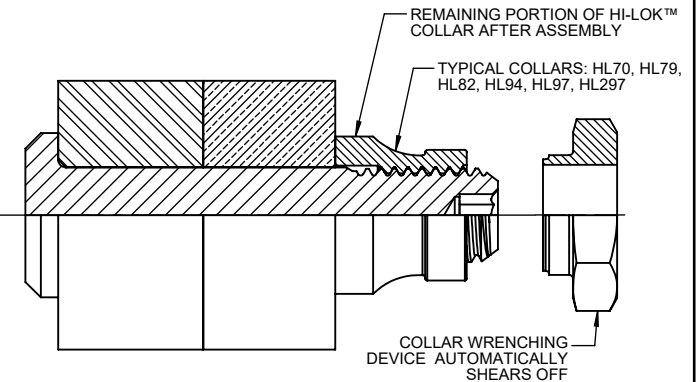


INDENTED HEAD MARKING .010 MAX DEPTH.
MANUFACTURER'S TRADEMARK PER
SPEC 363. THE NUMBER(S) FOLLOWING
TRADEMARK INDICATES FIRST DASH NO.
ARRANGEMENT OPTIONAL.



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 [5]		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING PLATING OR SOLID FILM	WITH COATING PLATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
4	1/8	.240 .225	.294	.1375 .1370	.1375 .1365	.1335 .1310	.020	.042 .032	.020 .010	1/32 x 45°	.1380-32 UNJC-3A	.0645 .0635	.100 .085	[7]	2,840	1,350
5	5/32	.262 .242	.312	.1635 .1630	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	[7]	4,010	1,940
6	3/16	.315 .295	.325	.1895 .1890	.1895 .1885	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	2,500
8	1/4	.412 .387	.395	.2495 .2490	.2495 .2485	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	4,300
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	14,600	6,300
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	8,700
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	28,600	12,100
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	37,300	15,300
18	9/16	.864 .829	.770	.5615 .5610	.5615 .5605	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	47,200	19,000
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	58,300	23,000
24	3/4	1.108 1.066	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.070	.151 .136	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	83,900	30,700

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIM.
- Dimensions are in inches and to be met after finish.
- Surface texture per ASME B46.1.
- Hole preparation per NAS618.
- Maximum "D" diameter may be increased by .0002 to allow for solid film application.
- Broach petals removed.
- Evidence of broken edge across points.
- Non-lubed pins must be used with lubed collars or wet sealant.
- Use HL140 for oversize replacement.

- [32][8]HL40PY(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1.
HL40TF(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
HL40V(-)(-) = Solid film lubricant per LUBECO™ 2123, Type II.
HL40HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

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
HL40DU8-8
└── 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 C.E.K.		DATE 1962-10-17		TITLE HI-LOK™ PIN	
J.F.OBISPO		2015-12-08		PROTRUDING SHEAR HEAD	
APPROVED M.E.C.		DATE 1962-10-17		A-286 HIGH TEMPERATURE ALLOY	
REVISION [32]		DATE A.CHAE 2022-06-15		DRAWING NUMBER HL40	
				1 OF 1	