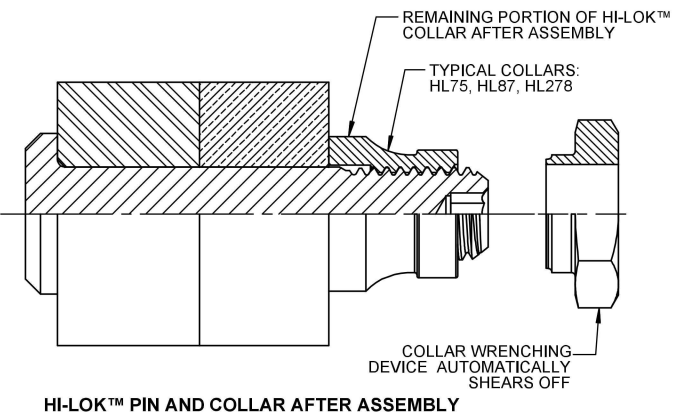
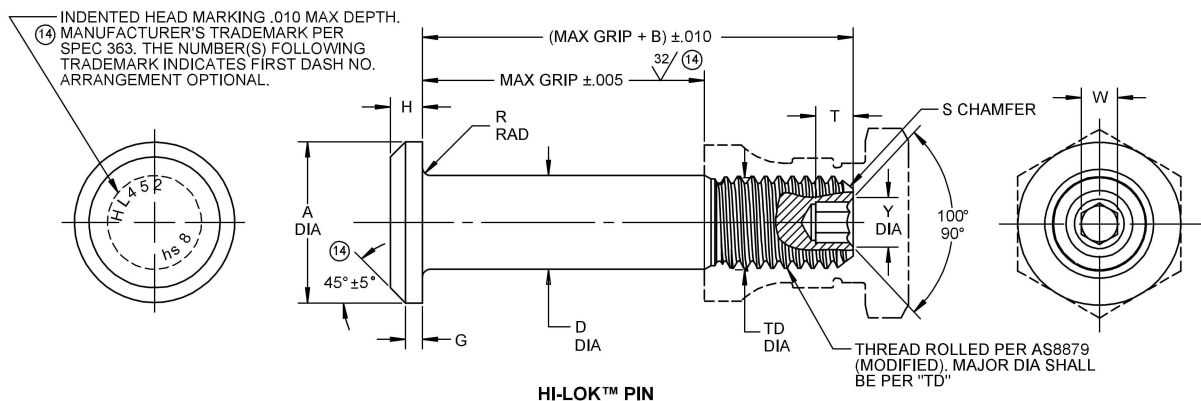


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SEE COLLAR STANDARDS
 FOR COLLAR STRENGTHS.
 LOWER STRENGTH (PIN OR
 COLLAR) DETERMINES
 SYSTEM STRENGTH

[6]

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 PLATING/ COATING OR S.F.L.	WITH PLATING/ COATING OR S.F.L.							W HEX	T DEPTH	Y DIA		
(14)	5					NOTE: USE HL448()6-()										
6	13/64	.377 .357	.325	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	6,130	3,180
8	17/64	.440 .415	.395	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .077	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	10,490	5,820
10	21/64	.505 .485	.500	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	16,000	9,200
12	25/64	.600 .580	.545	.3901 .3896	.3901 .3891	.3680 .3640	.065	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	22,700	14,000
14	29/64	.676 .651	.635	.4526 .4521	.4526 .4516	.4310 .4260	.075	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	30,600	18,900
16	33/64	.770 .745	.685	.5151 .5146	.5151 .5141	.4930 .4880	.085	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	39,600	25,600
18	37/64	.877 .842	.770	.5771 .5766	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	49,700	32,400
20	41/64	.953 .918	.825	.6396 .6391	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	61,000	41,000
24	49/64	1.150 1.110	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	87,200	59,500

"HI-LOK", "HL", AND "HI-KOTE",
 ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY BRIEJ	DATE 1963-04-01	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED M.E.C.	DATE 1963-04-01		
REVISION (14)	DATE K. PHAM 2022-04-11	DRAWING NUMBER HL452	

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions are in inches and to be met after finish.
3. Non-lubed pins must be used with lubed collars.
4. Surface texture per ASME B46.1.
5. Hole preparation per NAS618.
6. Maximum "D" diameter may be increased by .0002 to allow for plating, coating or solid film lube application.
7. Use HL454 for oversize replacement.
8. After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in UK and European Union.

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum) at 70°F.

- = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color blue on top of head only, and cetyl alcohol lube per Hi-Shear Spec. 305.
- = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- = Solid film lube per AS5272, Type I.
- = Solid film lube per Electrofilm No. 4396.
- = Cadmium plate per AMS-QQ-P-416, Type II, Class 3, without lubricant. (For use in LOX system.)
- = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- = Passivate per AMS2700, Method 1, Type 8, Class 1.
- = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL452 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

Pin Part Number
HL452N8-8

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