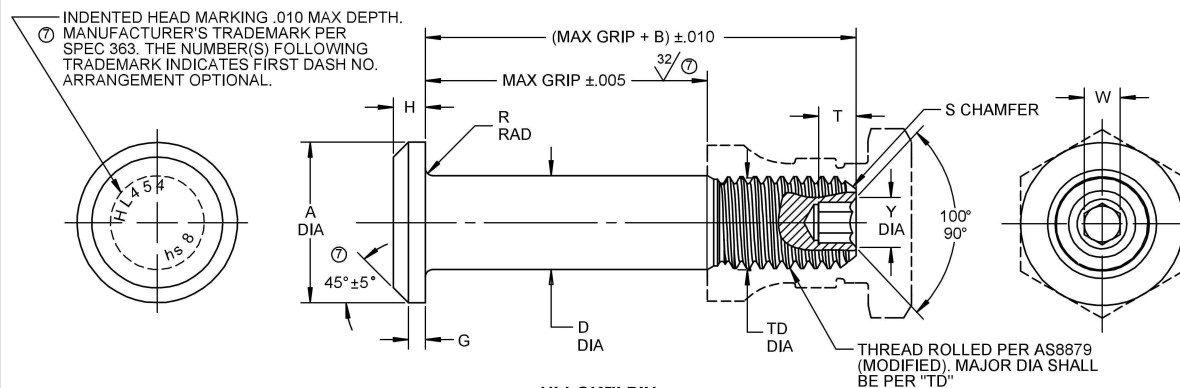
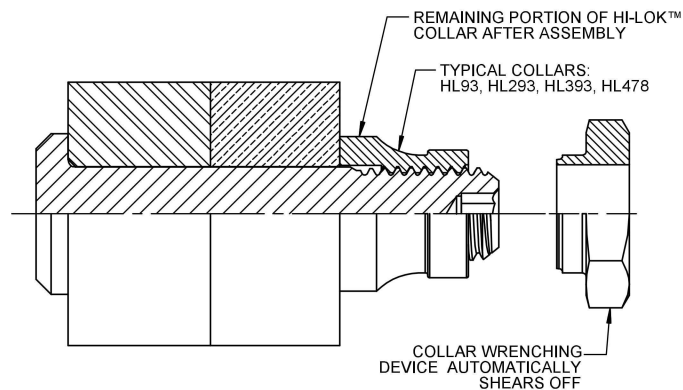


For the current list of licensed manufacturers, please visit the  
LISI AEROSPACE website at:

[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)



HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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		
						NOTE: USE HL448-6-( )										
6	7/32	.390 .370	.325	.2182 .2177	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,100	3,180
8	9/32	.460 .435	.395	.2807 .2802	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	11,800	5,820
10	11/32	.520 .500	.500	.3432 .3427	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	17,600	9,200
12	13/32	.620 .600	.545	.4057 .4052	.4057 .4047	.3680 .3640	.065	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	24,600	14,000
14	15/32	.695 .670	.635	.4682 .4677	.4682 .4672	.4310 .4260	.075	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	32,700	18,900
16	17/32	.790 .765	.685	.5307 .5302	.5307 .5297	.4930 .4880	.085	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	42,000	25,600
18	19/32	.905 .870	.770	.5927 .5922	.5927 .5917	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	52,400	32,400
20	21/32	.975 .940	.825	.6552 .6547	.6552 .6542	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	64,100	41,000
24	25/32	1.185 1.145	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	90,900	59,500

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

HL454

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

DRAWN BY SHRODE	DATE 1967-10-17	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED MILLER	DATE 1967-10-17		
REVISION 7	DATE K. PHAM 2022-3-3	DRAWING NUMBER HL454	1 OF 2

- GENERAL NOTES:**
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. Oversize replacement for HL448 and HL452.
  - ⑦ ⑧ 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 UK and European Union.

**MATERIAL:** A-286 high temperature alloy per AMS5737 or AMS5731.

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

- FINISH:** HL454-( )-( ) = 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.
- ⑦ ⑧ HL454AZ( )-( ) = 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.
- HL454DU( )-( ) = Solid film lube per AS5272, Type I.
- HL454EL( )-( ) = Solid film lube per Electrofilm No. 4396.
- ③ HL454N( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 3, without lubricant. (For use in LOX system.)
- HL454UC( )-( ) = 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.
- ⑦ ③ HL454PY( )-( ) = Passivate per AMS2700, Method 1, Type 8, Class 1.
- ⑦ HL454PZ( )-( ) = Passivate per AMS2700, Method 1, Type 8, Class 1 and cetyl alcohol lube per Hi-Shear Spec. 305.

**SPECIFICATION:** HI-LOK™ Product Specification 342.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HL454 Rev 7 oversize pin replaces.  
 Second dash number indicates maximum grip in 1/16ths.  
 See Finish note for explanation of code letters.

**HOW TO ORDER  
 EXAMPLE:**

Pin Part Number  
 HL454AZ8-8

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

HL454

DRAWING NUMBER

**HL454**

2 OF 2