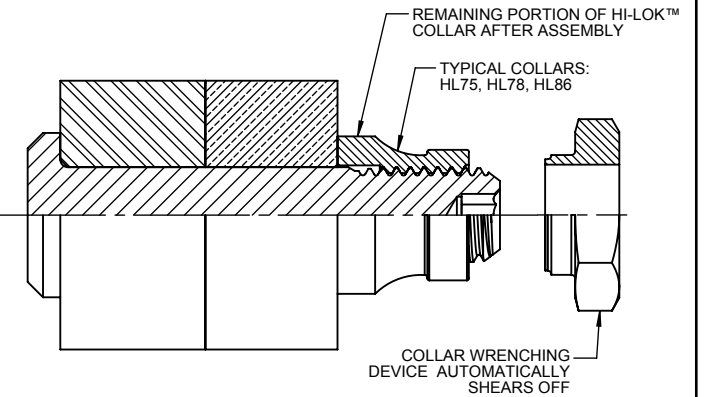


HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

33 5

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	.0801 .0791	.135 .115	7	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	.135 .115	.119 .104	5,380	3,180
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	9,300	5,820
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	14,600	9,200
12	3/8	.565 .530	.545	.3745 .3740	.3745 .3735	.3680 .3640	.065	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	14,000
14	7/16	.627 .592	.635	.4370 .4365	.4370 .4360	.4310 .4260	.075	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	28,600	18,900
16	1/2	.752 .717	.685	.4995 .4990	.4995 .4985	.4930 .4880	.085	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	37,300	25,600
18	9/16	.877 .842	.770	.5615 .5610	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	47,200	32,400
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	58,300	41,000
24	3/4	1.150 1.110	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	83,900	59,500
28	7/8	1.330 1.290	1.210	.8740 .8735	.8740 .8730	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	114,000	81,500
32	1	1.510 1.470	1.390	.9990 .9985	.9990 .9980	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	149,000	106,000

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

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

DRAWN BY BRIEJ J.F.OBISPO		DATE 1963-04-02 2015-05-20		TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION	
APPROVED M.C.		DATE 1963-04-02			
REVISION 33		DATE M.BEARD 2017-05-18		DRAWING NUMBER HL48 1 OF 2	

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 - ③ 2. Dimensions are in inches, and to be met after finish.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 - ⑤ 5. Maximum "D" diameter may be increased by .0002 to allow for solid film application.
 - ⑥ 6. Broach petals removed.
 - ⑦ 7. Evidence of broken edge across points.
 - ⑧ 8. Non-lubed pins must be used with lubed collars.
 9. Use HL248 for oversize replacement.

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:**
- HL48-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL48BC()-() = Passivate per Hi-Shear Spec. 258 with blue paint on top of head only and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL48DL()-() = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL48DS()-() = Solid film lube per LUBECO™ M390.
 - HL48DU()-() = Solid film lube per AS5272, Type I.
 - ⑧ HL48GU()-() = Silver plate per AMS2410.
 - ⑥ HL48K()-() = Solid film lube per LUBECO™ 905.
 - ⑥ HL48MA()-() = Solid film lube per "KalGard™" RA. "KALGARD" is a trademark of Metal Improvement Company
 - ⑧ HL48PY()-() = Passivate per Hi-Shear Spec. 258.
 - HL48TF()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
 - HL48V()-() = Solid film lube per LUBECO™ 2123, Type II.
 - HL48HK()-() = 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
 HL48DU8-8

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