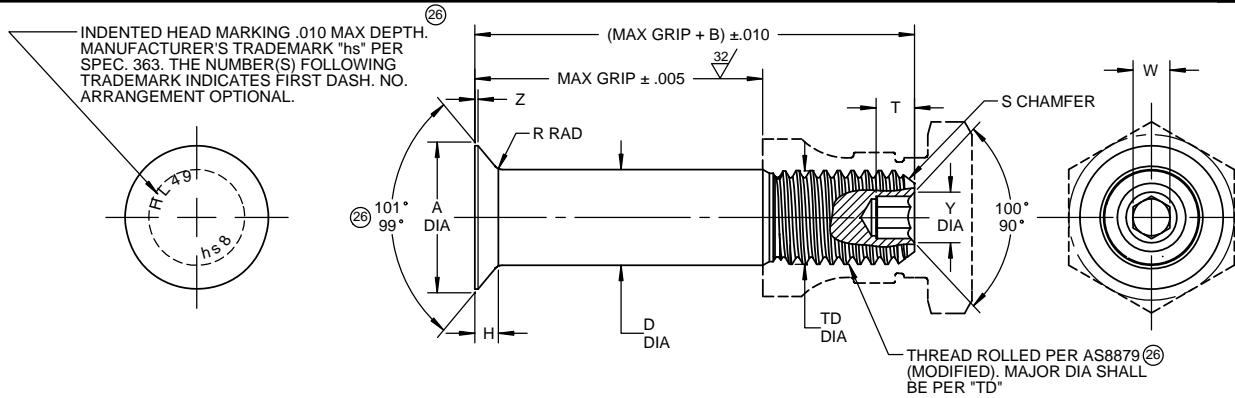
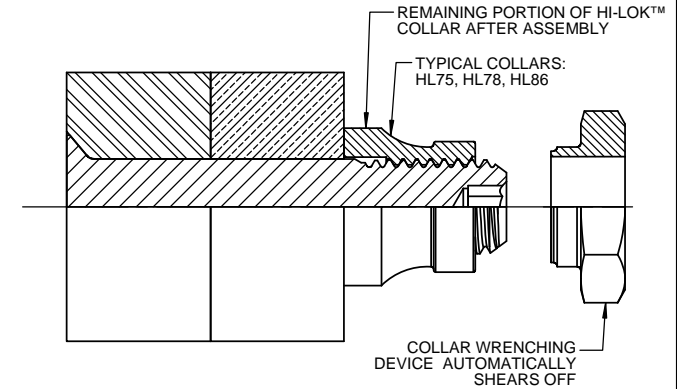


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HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT PLATING / SOLID FILM LUBE	AFTER PLATING / SOLID FILM LUBE								W HEX	T DEPTH	Y DIA		
5	5/32	.3304 .3256	.312	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0700 .0680	.025 .015	.015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	9	4,010	2,180
6	3/16	.3813 .3765	.325	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0805 .0785	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	3,180
8	1/4	.5066 .5018	.395	.2495 .2490	.2495 .2485	.2440 .2410	.006	.1079 .1059	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	5,820
10	5/16	.6335 .6287	.500	.3120 .3115	.3120 .3110	.3060 .3020	.007	.1349 .1329	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	14,600	9,200
12	3/8	.7604 .7556	.545	.3745 .3740	.3745 .3735	.3680 .3640	.008	.1619 .1599	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	14,000
14	7/16	.8884 .8812	.635	.4370 .4365	.4370 .4360	.4310 .4260	.009	.1894 .1864	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	28,600	18,900
16	1/2	1.0139 1.0068	.685	.4995 .4990	.4995 .4985	.4930 .4880	.010	.2158 .2128	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	37,300	25,600
18	9/16	1.1408 1.1337	.770	.5615 .5610	.5615 .5605	.5550 .5500	.010	.2430 .2400	.050 .040	.025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	47,200	32,400
20	5/8	1.2723 1.2651	.825	.6240 .6235	.6240 .6230	.6180 .6120	.010	.2720 .2690	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	58,300	41,000
24	3/4	1.5308 1.5236	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.012	.3280 .3250	.050 .040	.025	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	83,900	59,500
28	7/8	1.7845 1.7773	1.210	.8740 .8735	.8740 .8730	.8680 .8610	.014	.3820 .3790	.050 .040	.025	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	114,000	81,500
32	1	2.0405 2.0310	1.390	.9990 .9985	.9990 .9980	.9930 .9860	.014	.4370 .4330	.050 .040	.025	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	DATE 1963-04-03	TITLE HI-LOK™ PIN 100° FLUSH MS24694 TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION
APPROVED M.C.	DATE 1963-04-03	
REVISION 26	DATE M.BEARD 2017-06-21	DRAWING NUMBER HL49

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 3. "H" is dimensioned from maximum "D" diameter.
 4. Dimensions are in inches and to be met after finish.
 - 5 Non-lubed pins must be used with lubed collars.
 6. Surface texture per ASME B46.1.
 7. Hole preparation per NAS618.
 - 8 Maximum "D" diameter may be increased by .0002 to allow for solid film application.
 - 9 Evidence of broken edge across points.
 10. Use HL249 for oversize replacement.
 - 11 Curved or flat edge manufacturer's option.
 - 12 Broach petals removed.

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:**
- HL49(-)(-) = Passivate per Hi-Shear Spec. 258 and, cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL49BC(-)(-) = Passivate per Hi-Shear Spec. 258 with blue paint on top of head only and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 26 HL49DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL49DS(-)(-) = Solid film lube per "Lubeco" M390.
 - 26 HL49DU(-)(-) = Solid film lube per AS5272, Type I.
 - 5 HL49GU(-)(-) = Silver plate per AMS2410.
 - 12 HL49K(-)(-) = Solid film lube per "Lubeco" 905.
 - 12 HL49MA(-)(-) = Solid film lube per Kalgard RA.
 - 5 HL49PY(-)(-) = Passivate per Hi-Shear Spec. 258.
 - HL49TF(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
 - HL49V(-)(-) = Solid film lubricant per "Lubeco" 2123, Type II.
 - 26 HL49HK(-)(-) = 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

26 **EXAMPLE:**

Pin Part Number
 HL49DL8-8
 — 8/16 or 1/2 Maximum Grip Length
 — 8/32 or 1/4 Nominal Diameter Pin
 — Finish Code
 — Pin Basic Part Number

Pin and Collar Assembly Part Number Combination

HL4986-8-8
 — Size and Grip Length, See Above Example
 — Collar Part Number
 — Pin Part Number