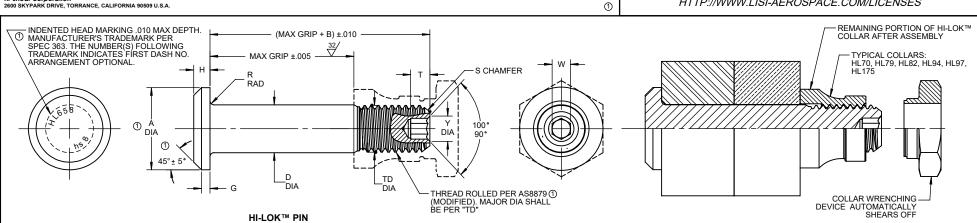
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

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HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

1

| FIRST | PIN | | | _ | | | | | s | THREAD MODIFIED | SOCKET | | | DOUBLE | TENSION |
|-------------|------------|-----------------|-----------------|-----------------|-------------------|-----------------|--------------|--------------|----------------|---------------------|----------------|--------------|-----------------|----------------------------|-------------------|
| DASH NO. | NOM DIA | A DIA | B REF | D DIA | T D DIA | G REF | Н | RAD | CHAMFER REF | | W HEX | T DEPTH | Y DIA | SHEAR POUNDS MINIMUM | POUNDS MINIMUM |
| 5 | 5/32 | .262 .242 | .312 | .1635 .1630 | .1595 .1570 | .020 | .047 .037 | .025 .015 | 1/32" x 45° | .1640-32 UNJC-3A | .0801 .0791 | .100 .080 | 5 | 4,560 | 2,200 |
| 6 | 3/16 | .315 .295 | .325 | .1895 .1890 | .1840 .1810 | .025 | .055 .045 | .025 .015 | 1/32" x 45° | .1900-32 UNJF-3A | .0806 .0791 | .100 .080 | .119 .104 | 6,125 | 2,900 |
| 8 | 1/4 | .412 .387 | .395 | .2495 .2490 | .2440 .2410 | .030 | .069 .059 | .025 .015 | 1/32" x 45° | .2500-28 UNJF-3A | .0967 .0947 | .110 .090 | .142 .122 | 10,600 | 5,100 |
| 10 | 5/16 | .505 .475 | .500 | .3120 .3115 | .3060 .3020 | .035 | .078 .068 | .030 .020 | 3/64" x 45° | .3125-24 UNJF-3A | .1295 .1270 | .130 .110 | .180 .160 | 16,600 | 7,100 |
| 12 | 3/8 | .600 .565 | .545 | .3745 .3740 | .3680 .3640 | .040 | .088 .078 | .030 .020 | 3/64" x 45° | .3750-24 UNJF-3A | .1617 .1582 | .160 .140 | .217 .197 | 23,900 | 9,800 |
| 14 | 7/16 | .676 .641 | .635 | .4370 .4365 | .4310 .4260 | .045 | .105 .093 | .030 .020 | 3/64" x 45° | .4375-20 UNJF-3A | .1930 .1895 | .190 .170 | .253 .233 | 32,500 | 14,000 |
| 16 | 1/2 | .770 .735 | .685 | .4995 .4990 | .4930 .4880 | .050 | .115 .103 | .030 .020 | 3/64" x 45° | .5000-20 UNJF-3A | .2242 .2207 | .220 .200 | .289 .269 | 42,400 | 17,800 |

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

- GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within .010 FIM.

 ① 2. Dimensions are in inches and to be met after finish.
 - ① 3. Surface texture per ASME B46.1.
 - 4. Hole preparation per NAS618.
 - [5] Evidence of broken edge across points.

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 108,000 psi shear minimum (180,000 psi tensile minimum).

① **FINISH:** HL658-()-() = 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. Second dash number indicates maximum grip in 1/16ths.

HOW TO ORDER

EXAMPLE: Pin Part Number

HL658-8-8 8/16 or 1/2 Maximum Grip Length - 8/32 or 1/4 Nominal Diameter Pin Pin Part Number

① Pin and Collar Assembly Part Number Combination HL65894-8-8

> Size and Grip Length, See Above Example Collar Part Number Pin Part Number

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

| DRAWN BY | DATE | TITLE | | | | | | |
|----------|----------------------|--------------------------------------|--|--|--|--|--|--|
| D.P.S | 1982-03-30 | HI-LOK™ PIN PROTRUDING SHEAR HEAD | | | | | | |
| APPROVED | DATE | NICKEL BASE ALLOY (INCONEL 718) | | | | | | |
| R.TING | 1982-03-30 | 1/16" GRIP VARIATION | | | | | | |
| REVISION | DATE | DRAWING NUMBER | | | | | | |
| (-) | A.CHAE 2020-11-10 | HL658 1 OF 1 | | | | | | |