



HI-LOK™ PIN

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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
											W HEX	T DEPTH	Y DIA		
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 D.P.S.	DATE 1982-03-30	TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION
APPROVED R.TING	DATE 1982-03-30	
REVISION ①	DATE A.CHAE 2020-11-10	DRAWING NUMBER <b>HL658</b>