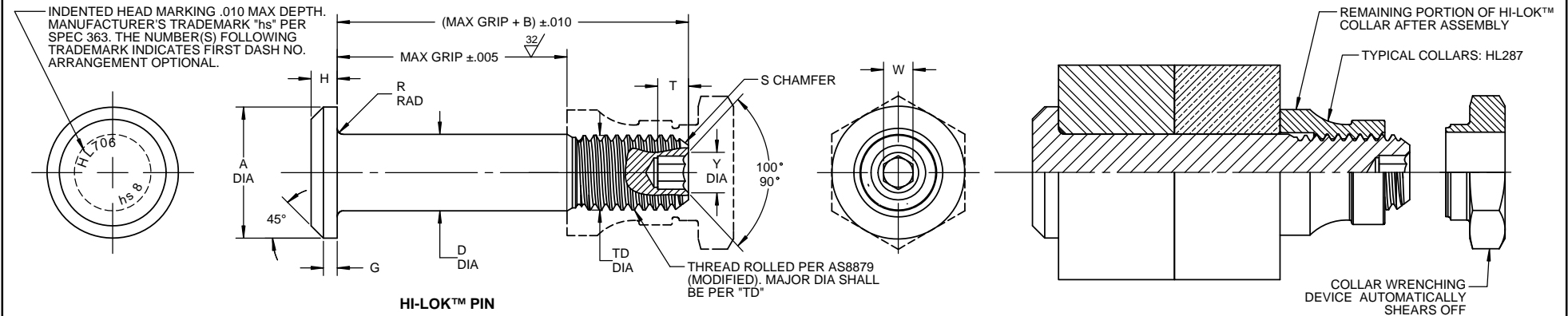


③ For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:  
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)



HI-LOK™ PIN

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

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							NOTE: USE HL48-6-( ) OR HL448-6-( )									
6	15/64	.400 .380	.360	.2339 .2334	.2339 .2329	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,160	3,180
8	19/64	.470 .445	.430	.2963 .2958	.2963 .2953	.2440 .2410	.045	.090 .077	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,100	5,820
10	23/64	.535 .515	.530	.3589 .3584	.3589 .3579	.3060 .3020	.055	.112 .098	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	19,200	9,200
12	27/64	.620 .600	.575	.4214 .4209	.4214 .4204	.3680 .3640	.065	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	26,500	14,000
14	31/64	.705 .685	.660	.4839 .4834	.4839 .4829	.4310 .4260	.075	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	34,900	18,900
16	35/64	.795 .770	.710	.5464 .5459	.5464 .5454	.4930 .4880	.085	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	44,600	25,600
18	39/64	.920 .885	.795	.6084 .6079	.6084 .6074	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	55,300	32,400
20	43/64	.990 .955	.850	.6709 .6704	.6709 .6699	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	67,200	41,000
24	51/64	1.200 1.160	1.075	.7959 .7954	.7959 .7949	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	94,500	59,500

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
  - ③ 2. Dimensions are in inches and to be met after finish.
  - ③ 3. Non-lubed pins must be used with wet sealant or with lubed collars..
  - ③ 4. Surface texture per ASME B46.1.
  5. Hole preparation per NAS618.
  - ⑥ After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HL706 oversize pin replaces.  
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER**

③ **EXAMPLE:**

Pin Part Number  
 HL706AZ8-8  
 └─ 8/16 or 1/2 Maximum Grip Length  
 └─ Replaces 8/32 or 1/4 Nominal Diameter Pin  
 └─ Finish Code  
 └─ Pin Basic Part Number

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

**HEAT TREAT:** 95,000 psi shear minimum at 70°F.

- FINISH:**
- HL706-( )-( ) = Passivate per Hi-Shear Spec. 258, and Cetyl alcohol lube per Hi-Shear Spec. 305.
  - ⑥ HL706AZ-( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL706DU-( )-( ) = Solid film lube per AS5272, Type I.
  - HL706CG-( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color green on thread end, plus cetyl alcohol lube per Hi-Shear Spec. 305.
  - ③ HL706N-( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, without lube (for use in LOX systems).

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

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY D.P.S.	DATE 1992-07-16	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 3/64 OVERSIZE	
APPROVED	DATE		
REVISION ③	DATE M.BEARD 2017-08-01	DRAWING NUMBER <b>HL706</b> 1 OF 1	