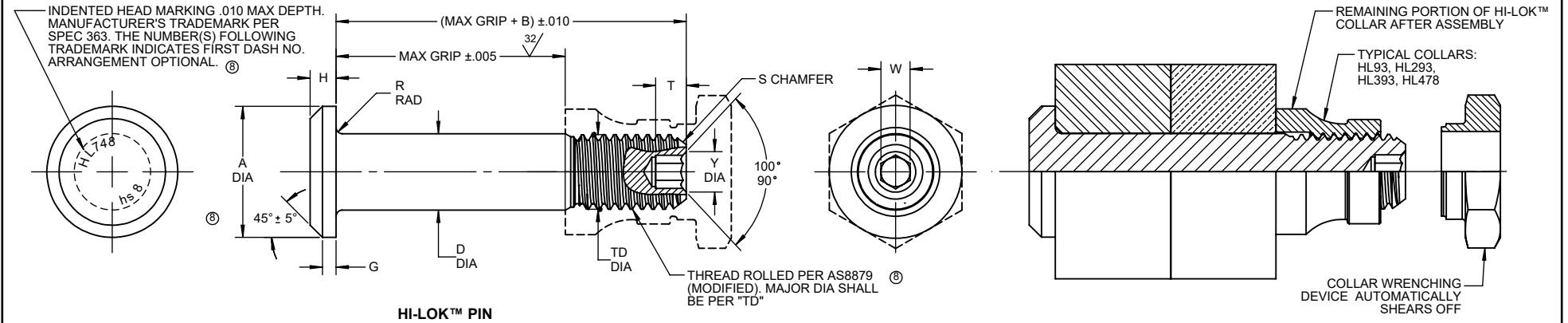


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HI-LOK™ PIN

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

				6		8											**	
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	13/64	NOTE: USE HL248-6- ()																
-6	7/32	.390 .370	.325	.2182 .2177	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,100	3,180		
-8	9/32	.460 .435	.395	.2807 .2802	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	11,800	5,820		
-10	11/32	.520 .490	.500	.3432 .3427	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	17,600	9,200		
-12	13/32	.585 .550	.545	.4057 .4052	.4057 .4047	.3680 .3640	.065	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	24,600	14,000		
-14	15/32	.650 .615	.635	.4682 .4677	.4682 .4672	.4310 .4260	.075	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	32,700	18,900		
-16	17/32	.775 .740	.685	.5307 .5302	.5307 .5297	.4930 .4880	.085	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	42,000	25,600		
-18	19/32	.905 .870	.770	.5927 .5922	.5927 .5917	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	52,400	32,400		
-20	21/32	.975 .940	.825	.6552 .6547	.6552 .6542	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	64,100	41,000		
-24	25/32	1.185 1.145	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	90,900	59,500		
-28	29/32	1.375 1.335	1.210	.9052 .9047	.9052 .9042	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	122,000	81,500		

** The Double Shear values shown
 are based on cross sectional
 area for nominal diameter pin.

"HI-LOK", "HL", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY SHRODE	DATE 1967-10-18	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED J.MILLER	DATE 1967-10-18	
REVISION 8	DATE A.CHAE 2022-05-31	DRAWING NUMBER HL748

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIR.
 - ② 2. Dimensions are in inches and to be met after finish.
 - ③ 3. Non-lubed pins must be used with lubed collars.
 - ④ 4. Surface texture per ASME B46.1.
 5. Hole preparation per NAS618.
 - ⑥ 6. Maximum "D" diameter may be increased by .0002 to allow for solid film or coating application.
 - ⑦ 7. 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 the UK and European Union.

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

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum) at 70°F.

- FINISH:**
- ② HL748(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑦ HL748AZ(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ② HL748DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ② HL748DU(-)(-) = Solid film lube per AS5272, Type I.
 - ③ HL748PY(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1.
 - ② HL748V(-)(-) = Solid film lube per "Lubeco" 2123, Type II.
 - ② HL748HK(-)(-) = HI-KOTE™ 4 NC aluminum pigmented coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL748 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

**⑧ HOW TO ORDER
 EXAMPLE:**

Pin Part Number
HL748 AZ 8 - 8
 └─ 8/16 or 1/2 Maximum Grip Length
 └─ Replaces 8/32 or 1/4 Nominal Diameter Pin
 └─ Finish Code
 └─ Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HL74893-8-8
 └─ Size and grip length, see above example
 └─ Collar Part Number
 └─ Pin Basic Part Number