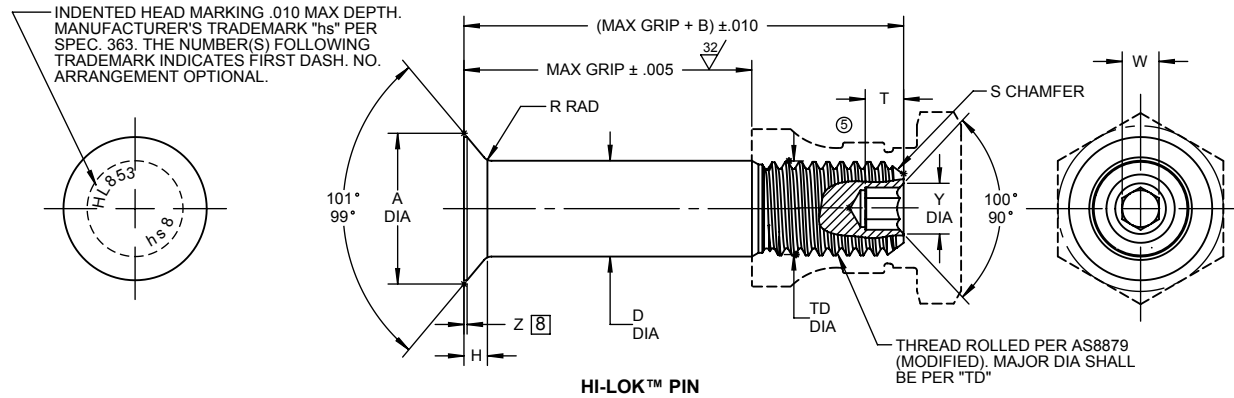
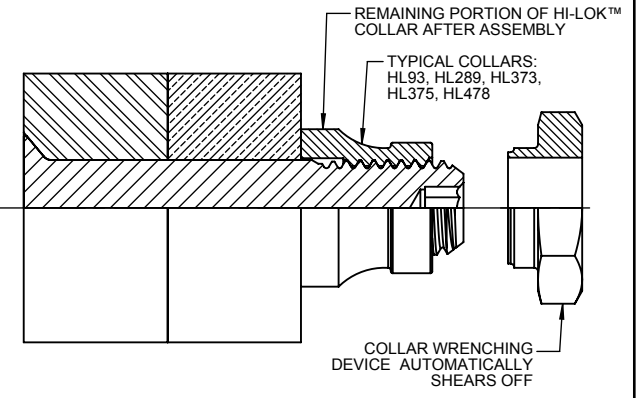


⑤



HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

7				1													
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 COATING OR SOLID FILM	AFTER COATING OR SOLID FILM								W HEX	T DEPTH	Y DIA		
5							NOTE: USE HL753( )6(- )										
6	7/32	.3813 .3765	.325	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0684 .0664	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,400	4,350
8	9/32	.5066 .5018	.395	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0948 .0928	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	15,500	7,750
10	11/32	.6335 .6287	.500	.3432 .3427	.3432 .3422	.3060 .3020	.007	.1218 .1198	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	23,200	12,300
12	13/32	.7604 .7556	.545	.4057 .4052	.4057 .4047	.3680 .3640	.008	.1488 .1468	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	32,400	19,100
14	15/32	.8884 .8812	.635	.4682 .4677	.4682 .4672	.4310 .4260	.009	.1763 .1733	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	43,100	25,800
16	17/32	1.0139 1.0068	.685	.5307 .5302	.5307 .5297	.4930 .4880	.010	.2027 .1997	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,400	34,300
18	19/32	1.1408 1.1337	.770	.5927 .5922	.5927 .5917	.5550 .5500	.010	.2300 .2270	.050 .040	.025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	69,200	43,500
20	21/32	1.2723 1.2651	.825	.6552 .6547	.6552 .6542	.6180 .6120	.010	.2589 .2559	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	84,500	54,600
24	25/32	1.5308 1.5236	1.050	.7802 .7797	.7802 .7792	.7430 .7370	.012	.3149 .3119	.050 .040	.025	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	120,000	79,200
28	29/32	1.7845 1.7773	1.210	.9052 .9047	.9052 .9042	.8680 .8610	.014	.3689 .3659	.050 .040	.025	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	161,000	117,000
32	1-1/32	2.0405 2.0310	1.390	1.0302 1.0297	1.0302 1.0292	.9930 .9860	.014	.4239 .4199	.050 .040	.025	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	209,000	143,000

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 J.F. OBISPO		DATE 2016-05-16		TITLE HI-LOK™ PIN	
VAN		1971-11-22		100° FLUSH MS24694 TENSION HEAD	
APPROVED R. TING		DATE 1971-11-23		PH13-8Mo STAINLESS STEEL	
REVISION ⑤		DATE F. CARINGELLA 2017-04-05		DRAWING NUMBER HL853	
				1 OF 2	

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
  - 2 Concentricity: Conical surface of head to "D" diameter within .005 FIM.
  - ⑤ 3. Dimensions are in inches and to be met after finish.
  - ⑤ 4. Surface texture per ASME B46.1.
  5. Hole preparation per NAS618.
  6. "H" is dimensioned from maximum "D" diameter.
  - 7 Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
  - 8 Curved or flat edge manufacturer's option.
  - ⑤ 9 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

**MATERIAL:** PH13-8Mo stainless steel per AMS5629.

**HEAT TREAT:** 125,000 psi shear minimum.

- FINISH:**
- HL853-( )-( ) = Solid film lube per AS5272, Type I.
  - ⑤ 9 HL853AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL853LL( )-( ) = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL853PB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL853TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - ⑤ HL853HK( )-( ) = 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 of the pin which HL853 oversize pin replaces.  
 Second dash number indicates maximum grip in 1/16ths.  
 See Finish note for explanation of code letters.

**HOW TO ORDER**

⑤ **EXAMPLE:** Pin Part Number  
 HL853PB8-8

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

HL853

DRAWING NUMBER

**HL853**

2 OF 2