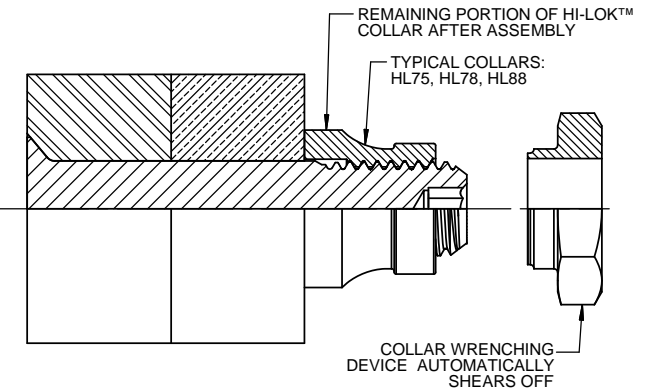
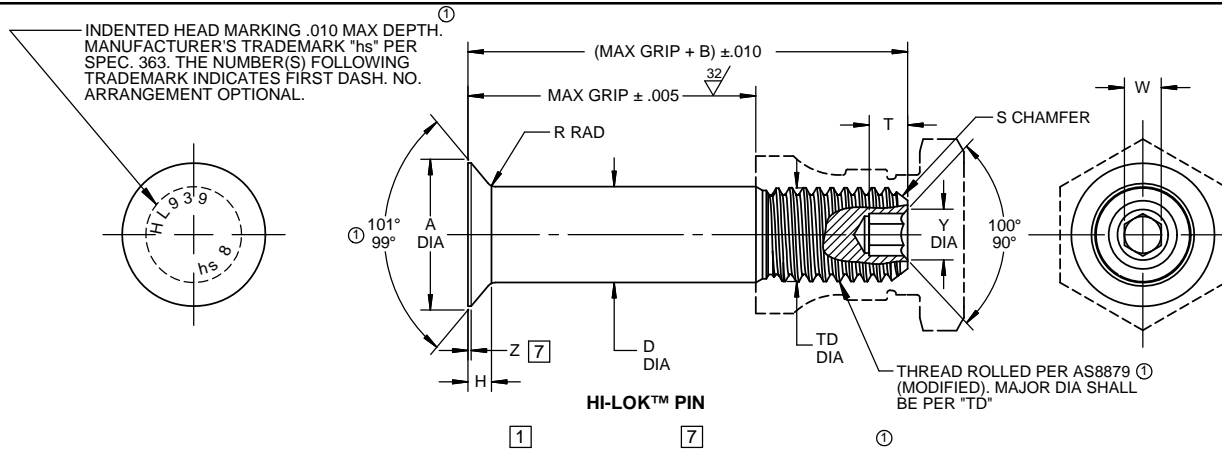


①

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 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	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR PLATING	WITH COATING OR PLATING								W HEX	T DEPTH	Y DIA		
5	5/32					NOTE: USE HL731-6- ( ).											
6	13/64	.3813 3765	.325	.2026 2021	.2026 2016	.1840 1810	.005	.0750 0730	.030 020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 0791	.135 115	.119 104	8,100	4,350
8	17/64	.5066 5018	.395	.2651 2646	.2651 2641	.2440 2410	.006	.1013 0993	.030 020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 0947	.150 130	.142 122	13,800	7,750
10	21/64	.6335 6287	.500	.3276 3271	.3276 3266	.3060 3020	.007	.1283 1263	.040 030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 1270	.170 150	.180 160	21,100	12,300
12	25/64	.7604 7556	.545	.3901 3896	.3901 3891	.3680 3640	.008	.1553 1533	.040 030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 1582	.200 180	.217 197	30,000	19,100
14	29/64	.8884 8812	.635	.4526 4521	.4526 4516	.4310 4260	.009	.1828 1798	.050 040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 1895	.230 210	.253 233	40,300	25,800
16	33/64	1.0139 1.0068	.685	.5151 5146	.5151 5141	.4930 4880	.010	.2093 2063	.050 040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 2207	.260 240	.289 269	52,500	34,300

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
  - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
  - "H" is dimensioned from maximum "D" diameter.
  - Dimensions are in inches and to be met after finish.
  - Surface texture per ASME B46.1.
  - Hole preparation per NAS618.
  - Curved or flat edge manufacturer's option.
  - Use HL949 for oversize replacement.
  - Non-lubed pin must be used with wet sealant or with lubed collars.
  - 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.

**CODE:**

First dash number indicates nominal diameter in 1/32nds of the pin which HL939 oversize pin replaces.  
Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER**

① **EXAMPLE:**

Pin Part Number  
HL939AP-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  
HL93986-8-8  
└─ Size and Grip Length, See Above Example  
└─ Collar Part Number  
└─ Pin Part Number

**MATERIAL:** Nickel base alloy per AMS5662.

**HEAT TREAT:** 125,000 psi shear minimum (210,000 psi tensile minimum).

- FINISH:**
- HL939-(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- ① 10 HL939AP(-)(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL939JT(-)(-) = Passivate per Hi-Shear Spec. 258, with light blue identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ① HL939PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ② HL939PY(-)(-) = Passivate per Hi-Shear Spec. 258.

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

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY J.FOBISPO	DATE 2000-06-05	TITLE HI-LOK™ PIN
APPROVED J.RAUSCH	DATE 2000-06-05	100° FLUSH MS24694 TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/64 OVERSIZE
REVISION ①	DATE M.BEARD 2017-09-26	DRAWING NUMBER <b>HL939</b>