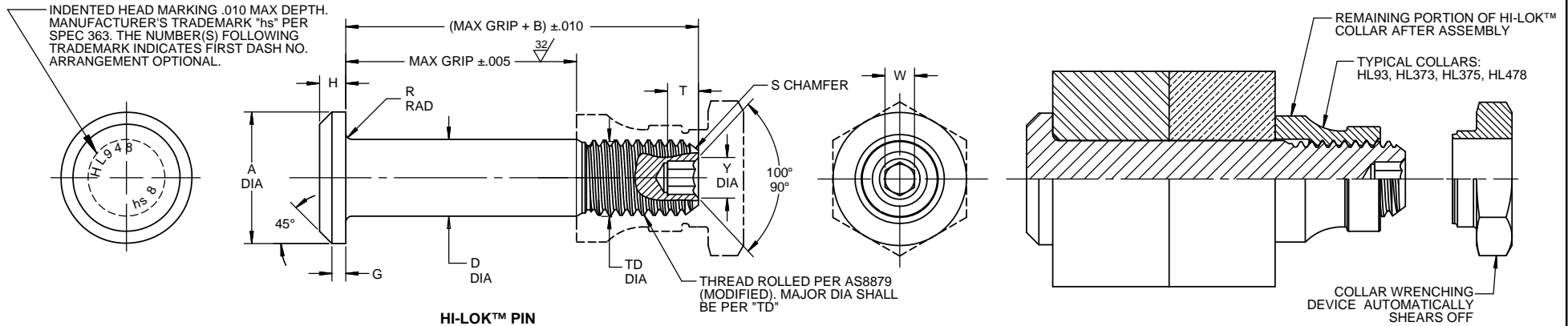


① For the current list of licensed manufacturers, please visit the
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HI-LOK™ PIN

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

| 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 PLATING | WITH COATING OR COATING | | | | | | | W HEX | T DEPTH | Y DIA | | | | |
| 5 | | | | NOTE: USE HL938-6-() | | | | | | | | | | | | | | |
| 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 | 9,400 | 4,350 | | |
| 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 | 15,500 | 7,750 | | |
| 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 | 23,200 | 12,300 | | |
| 12 | 13/32 | .620 585 | .545 | .4057 4052 | .4057 4047 | .3680 3640 | .075 | .140 .130 | .030 .020 | 3/64 x 45° | .3750-24 UNJF-3A | .1617 .1582 | .200 .180 | .217 .197 | 32,400 | 19,100 | | |
| 14 | 15/32 | .695 660 | .635 | .4682 4677 | .4682 4672 | .4310 4260 | .095 | .160 .150 | .030 .020 | 3/64 x 45° | .4375-20 UNJF-3A | .1930 .1895 | .230 .210 | .253 .233 | 43,100 | 25,800 | | |
| 16 | 17/32 | .790 755 | .685 | .5307 5302 | .5307 5297 | .4930 4880 | .095 | .188 .178 | .030 .020 | 3/64 x 45° | .5000-20 UNJF-3A | .2242 .2207 | .260 .240 | .289 .269 | 55,400 | 34,300 | | |

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.

① ⑤ 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: Nickel base alloy per AMS5662.

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

FINISH: HL948-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.

① ⑤ HL948AP()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.

HL948JT()-() = Passivate per Hi-Shear Spec. 258 with light blue identification on top of head and cetyl alcohol lube per Hi-Shear Spec. 305.

HL948PB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 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 of the pin which HL948 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
 HL948AP8-8
 8/16 or 1/2 Maximum Grip Length
 Replaces 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

"HI-LOK", "HL", AND "HI-KOTE",
 ARE TRADEMARKS OF HI-SHEAR CORPORATION

| | | | |
|------------------------|-------------------------------|--|--|
| DRAWN BY J.F.OBISPO | DATE 2010-10-20 | TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/32 OVERSIZE | |
| APPROVED JFO | DATE 2010-10-20 | DRAWING NUMBER HL948 | |
| REVISION ① | DATE M.BEARD 2017-08-01 | 1 OF 1 | |