



[5]

**HI-LOK™ PIN**

**HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY**

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
				BEFORE SOLID FILM LUBE	AFTER SOLID FILM LUBE							W HEX	T DEPTH	Y DIA		
4	1/8	.240 .225	.294	.1375 .1370	.1375 .1365	.1335 .1310	.020	.042 .032	.020 .010	1/32 x 45°	.1380-32 UNJC-3A	.0645 .0635	.100 .085	[7]	2,840	1,350
5	5/32	.262 .242	.312	.1635 .1630	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	[7]	4,010	1,940
6	3/16	.315 .295	.325	.1895 .1890	.1895 .1885	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	5,380	2,500
8	1/4	.412 .387	.395	.2495 .2490	.2495 .2485	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	9,300	4,300
10	5/16	.505 .475	.500	.3120 .3115	.3120 .3110	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	14,600	6,300
12	3/8	.600 .565	.545	.3745 .3740	.3745 .3735	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	21,000	8,700
14	7/16	.676 .641	.635	.4370 .4365	.4370 .4360	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	28,600	12,100
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	37,300	15,300
18	9/16	.864 .829	.770	.5615 .5610	.5615 .5605	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	47,200	19,000
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	58,300	23,000
24	3/4	1.108 1.066	1.050	.7490 .7485	.7490 .7480	.7430 .7370	.070	.151 .136	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	83,900	30,700

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
  2. Dimensions are in inches and to be met after finish and before application of solid film lubricant.
  3. Surface texture per ASME B46.1.
  4. Hole preparation per NAS618.
  5. Maximum "D" diameter may be increased by .0002 to allow for solid film application.
  6. Broach petals removed.
  7. Evidence of broken edge across points.
  8. Non-lubed pins must be used with lubed collars or wet sealant.
  9. Use HL140 for oversize replacement.

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

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

- FINISH:**
- HL40(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL40DL(-)(-) = KALGARD™ FA or EM620C solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL40DU(-)(-) = Solid film lube AS5272, Type I.
  - 8HL40GU(-)(-) = Silver plate per AMS2410.
  - 6HL40K(-)(-) = Solid film lubricant per LUBECO™ 905.

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

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

**HOW TO ORDER**

**EXAMPLE:**

Pin Part Number  
HL40DU8-8  
8/16 or 1/2 Maximum Grip Length  
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 C.E.K.	DATE 1962-10-17	TITLE <b>HI-LOK™ PIN</b> PROTRUDING SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION	
J.F.OBISPO	2015-12-08		
APPROVED M.E.C.	DATE 1962-10-17	DRAWING NUMBER <b>HL40</b>	
REVISION 27	DATE F.CARINGELLA 2017-03-29		