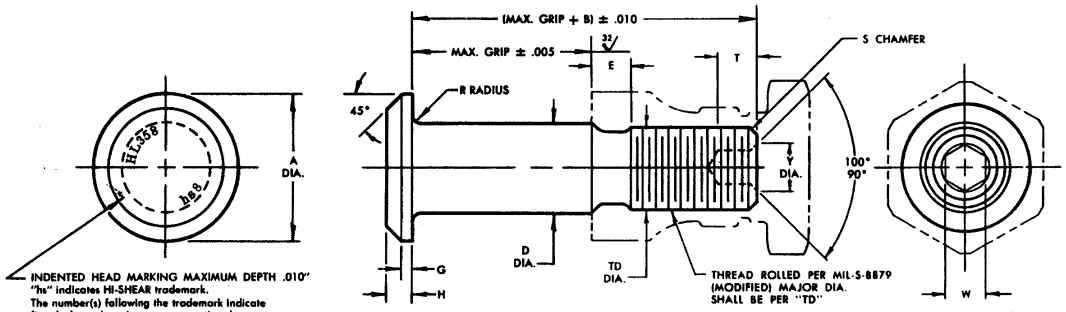
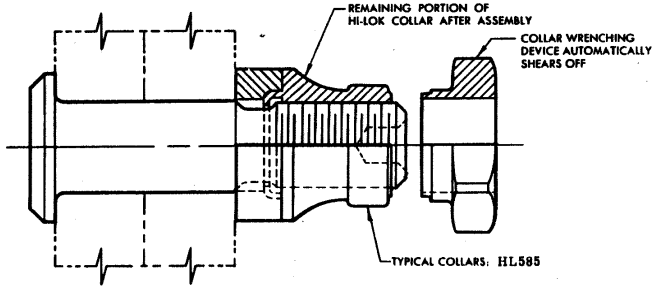
**hi-shear CORPORATION**
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110




HI-LOK PIN




HI-LOK PIN AND COLLAR AFTER ASSEMBLY

| FIRST DASH NO. | NOM. DIA. | A DIA. | B REF. | D DIA. | TD DIA. | E REF. | G REF. | H | R RAD. | S CHAMFER REF. | THREAD | SOCKET W HEX. | SOCKET T DEPTH | SOCKET Y DIA. | DOUBLE SHEAR POUNDS MINIMUM | TENSION POUNDS MINIMUM |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| -5 | 5/32 | .262<br>.242 | .395 | .1635<br>.1630 | .1595<br>.1570 | .125 | .020 | .047<br>.037 | .025<br>.015 | 1/32" x 37° | 8-32UNJC-3A<br>Modified | .0645<br>.0635 | .100<br>.080 | .090<br>.075 | 4,010 | 1,940 |
| -6 | 3/16 | .315<br>.295 | .410 | .1895<br>.1890 | .1840<br>.1810 | .130 | .025 | .055<br>.045 | .025<br>.015 | 1/32" x 37° | 10-32UNJF-3A<br>Modified | .0806<br>.0791 | .100<br>.080 | .119<br>.104 | 5,380 | 2,500 |
| -8 | 1/4 | .412<br>.387 | .495 | .2495<br>.2490 | .2440<br>.2410 | .140 | .030 | .069<br>.059 | .025<br>.015 | 1/32" x 37° | 1/4-28UNJF-3A<br>Modified | .0967<br>.0947 | .110<br>.090 | .142<br>.122 | 9,300 | 4,300 |
| -10 | 5/16 | .505<br>.475 | .560 | .3120<br>.3115 | .3060<br>.3020 | .160 | .035 | .078<br>.068 | .030<br>.020 | 3/64" x 37° | 5/16-24UNJF-3A<br>Modified | .1295<br>.1270 | .130<br>.110 | .180<br>.160 | 14,600 | 6,300 |
| -12 | 3/8 | .600<br>.565 | .625 | .3745<br>.3740 | .3680<br>.3640 | .170 | .040 | .088<br>.078 | .030<br>.020 | 3/64" x 37° | 3/8-24UNJF-3A<br>Modified | .1617<br>.1582 | .160<br>.140 | .217<br>.197 | 21,000 | 8,700 |
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GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIR.
2. Dimensions to be met after finish.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
5. Use HL528 for oversize replacement.

MATERIAL: 6Al-4V titanium alloy per Spec. AMS4928 or AMS4967.

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

FINISH: HL358-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.

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.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HL358-8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Pin Part Number

Pin and Collar Assembly Part Number Combination
HL358585-8-8
- Size and Grip Length, See Above Example
- Collar Part Number
- Pin Part Number

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| DRAWN | DATE | |
|---|---|---|
| D.P.S. | 6-24-87 | hi-lok® PIN<br>PROTRUDING SHEAR HEAD<br>TITANIUM<br>1/16" GRIP VARIATION<br>(MECHANICAL LOCK APPLICATION) |
| APPROVED | DATE | |
| JGWilcox | 6-25-87 | |
| REVISION | DATE | DRAWING NUMBER<br>HL358 |

HL358