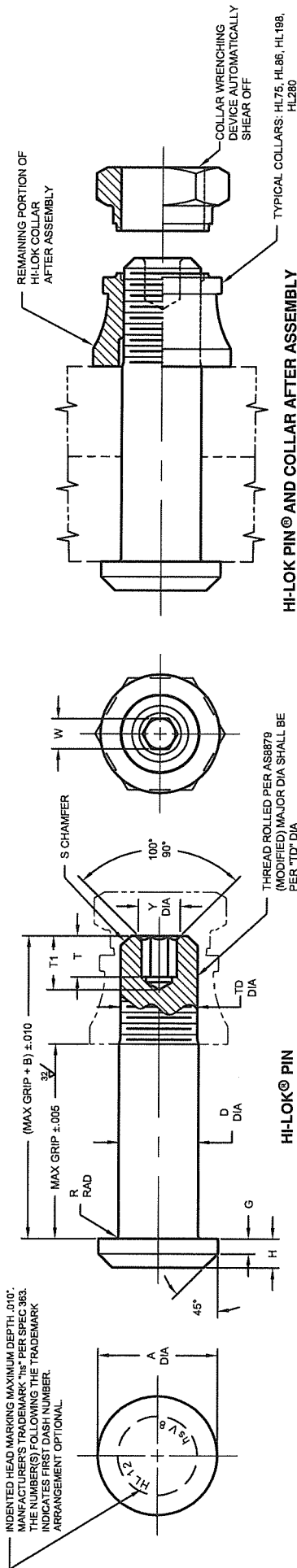


IDENTED HEAD MARKING MAXIMUM DEPTH, 0.01".
 MANUFACTURER'S TRADEMARK, "M" PER SPEC. 385.
 THE NUMBER(S) FOLLOWING THE TRADEMARK
 INDICATES FIRST DASH NUMBER.
 ARRANGEMENT OPTIONAL.



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	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	
		WITHOUT FILM	WITH FILM							W HEX	T DEPTH	T1 DEPTH MAX			Y DIA
5	5/32	.322	.312	.1635	.1635	.1595	.030	1/32" x 37°	8-32UNJ-C-3A Modified	.0645	.135	.160	.090	4,010	2,180
6	3/16	.377	.325	.1890	.1890	.1840	.035	1/32" x 37°	10-32UNJ-F-3A Modified	.0635	.115	.175	.119	5,380	3,180
8	1/4	.440	.395	.2495	.2495	.2440	.045	1/32" x 37°	1/4-28UNJ-F-3A Modified	.0867	.150	.200	.142	9,300	5,820
10	5/16	.505	.500	.3120	.3120	.3060	.055	3/64" x 37°	5/16-24UNJ-F-3A Modified	.1295	.170	.240	.180	14,600	9,200
12	3/8	.565	.545	.3745	.3745	.3680	.075	3/64" x 37°	3/8-24UNJ-F-3A Modified	.1617	.200	.275	.197	21,000	14,000
14	7/16	.641	.635	.4370	.4370	.4310	.095	3/64" x 37°	7/16-20UNJ-F-3A Modified	.1930	.230	.315	.253	28,600	18,900
16	1/2	.735	.685	.4995	.4995	.4930	.095	3/64" x 37°	1/2-20UNJ-F-3A Modified	.2242	.260	.360	.269	37,300	25,600
18	9/16	.842	.770	.5615	.5615	.5550	.125	1/16" x 37°	9/16-18UNJ-F-3A Modified	.2520	.270	.400	.306	47,200	32,400
20	5/8	.948	.825	.6240	.6240	.6180	.140	1/16" x 37°	5/8-18UNJ-F-3A Modified	.2555	.330	.440	.306	58,300	41,000
24	3/4	1.150	1.050	.7490	.7490	.7430	.200	1/16" x 37°	3/4-16UNJ-F-3A Modified	.3185	.330	.465	.398	83,900	59,500
28	7/8	1.330	1.210	.8740	.8740	.8680	.250	5/64" x 37°	7/8-14UNJ-F-3A Modified	.3820	.400	.560	.471	114,000	81,500
32	1	1.510	1.390	.9990	.9990	.9930	.300	5/64" x 37°	1-12UNJ-F-3A Modified	.5100	.520	.715	.618	149,000	106,000

"Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation.

DRAWN	DATE	TITLE
Marlin	11-19-63	HI-LOK® PIN
APPROVED	DATE	PROTRUDING TENSION HEAD
Cassina	7-23-63	TITANIUM
REVISION	DATE	1/16" GRIP VARIATION
(38)	J.F.O.	DRAWING NUMBER
	5-2-2012	HL12

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions to be met after finish.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
5. Use HL112 for oversize replacement.
6. Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
7. Dimensions to be met before finish for "VY" code only.
8. Broach petals removed.
9. Non-lubed pins must be used with lubed collars or wet sealant.

MATERIAL:

- 6AL-4V titanium alloy per AMS4928 or AMS4967.
 160,000 psi tensile minimum (95,000 psi shear minimum).

FINISH:

- HL12V(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 HL12VAP(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL12VAT(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294.
 HL12VAZ(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL12VBJ(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL12VBV(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, with color blue on thread end.
 HL12VDK(-) = Solid film lube per Kelgard FA.
 HL12VDF(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL12VLJ(-) = Surface coating per Hi-Shear Spec. 306, Type II, and solid film lube per AS5272.
 HL12VLV(-) = Phosphate fluoride treat and Esna-Lube No. 382 (Eventube Corp).
 HL12VMA(-) = Solid film lube per Kelgard RA.
 HL12VVR(-) = Surface coating per Hi-Shear Spec. 306, Type II, and solid film lube per "Electrofilm" 4396.
 HL12VRA(-) = Phosphate fluoride treat with color code red on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL12VSS(-) = Grip blast top of head with color light blue on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL12VSY(-) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color red on thread end.
 HL12VTV(-) = Surface coating per Hi-Shear Spec. 306, Type I, color pink, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL12VTA(-) = Anodize Ti-Shield III and Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL12VTB(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL12VTF(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
 HL12VTT(-) = Translube.
 HL12VU(-) = Bare, no lubricant.
 HL12VUE(-) = Surface coating per Hi-Shear Spec. 306, Type II, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL12VUU(-) = Surface coating per Hi-Shear Spec. 306, Type II, and solid film lube per "Lubeco" 2123, Type II.
 HL12VW(-) = Solid film lube per "Lubeco" 2123, Type II.
 HL12VY(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue, and solid film lubricant per M88. (British Aircraft Corporation Spec. MP-1071).
 HL12VYS(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 on threads only.

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 EXAMPLES:

