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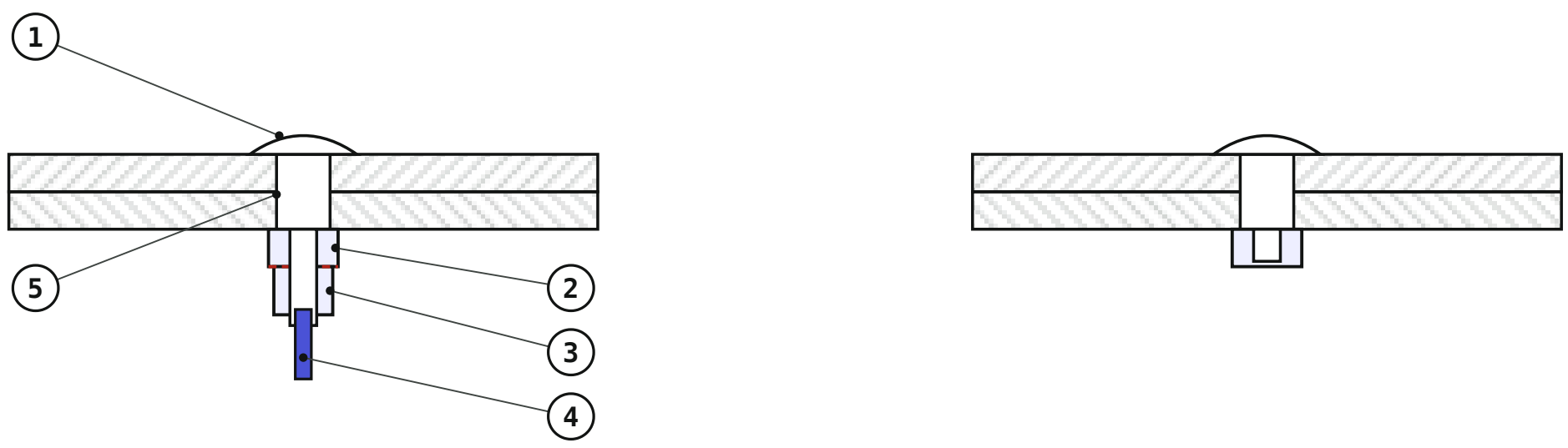
Installing a Hi-Lok

Fit · pin · collar · shear-off

REFERENCE DRAWING — NOT APPROVED DATA · THE SRM ALWAYS GOVERNS

SECTION A
COLLAR RUNNING DOWN

SECTION B
FLATS SHEARED OFF



PARTS LIST

#	PART	RULE	SOURCE
1	Pin	Alloy steel, CRES or titanium; countersunk or protruding, shear or tension head	H-8083-31B p. 4-50
2	Collar	Self-locking; counterbore takes up grip variation; recess acts as a washer	p. 4-50
3	Wrenching flats	Shear at the fracture point when the preset torque is reached	p. 4-50
4	Hex key	Holds the pin still while the collar turns	p. 4-50
5	Hole	Aluminium: interference fit, maximum 0.002 in; steel, Ti, composite: clearance	p. 4-50
—	Hi-Lite	Shorter thread; its collars do not interchange with Hi-Lok collars	p. 4-51

NOTES
1. Dimensions in inches. Do not scale: the SRM sets the values.
2. For reference. The applicable manual always governs.
3. Based on FAA-H-8083-31B ch. 4.

REVISIONS

REV	DESCRIPTION	DATE
A	First issue	2026-10-30

The Aviation Point.	Structural repair reference		
TITLE: Hi-Lok installation			
DRAWING NO.: TAP-DWG-061	REV: A	SCALE: NTS	SHEET: 1 OF 1
APPLIES TO: Two-piece fasteners			
DO NOT SCALE DRAWING			

After FAA-H-8083-31B pp. 4-50, 4-51 (Fig. 4-104). Typical only: fastener data give the hole, the grip and the tool.

Key points

- **Maximum interference 0.002 in.**
- **Cannot be overtorqued.**

Step by step

1. Data.
2. Hole, deburr.
3. Pin, collar.
4. Drive until flats shear.

SOURCES · FAA-H-8083-31B, Aviation Maintenance Technician Handbook: Airframe, Chapter 4

SCAN · OPEN THIS GUIDE
theaviationpoint.com/standard-practices/hi-lok-installation/

Educational reference only, not approved data. Always consult the applicable SRM, AMM, or AC 43.13-1B and your certifying authority.