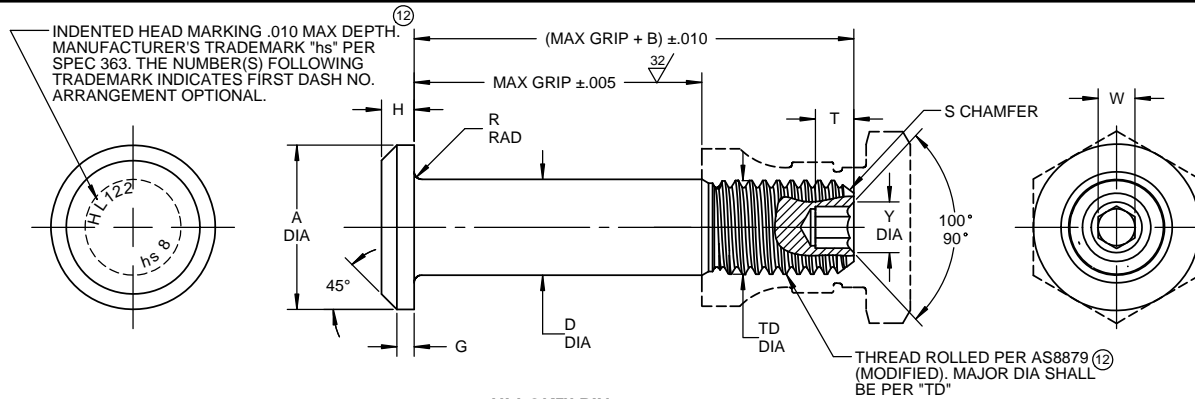
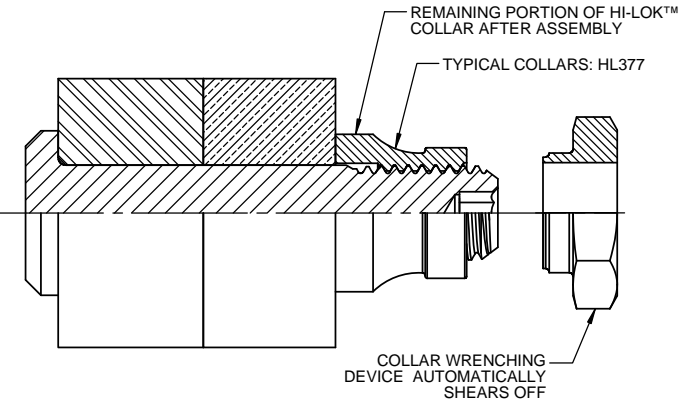


(12)

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HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

(12)

**

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
											W HEX	T DEPTH	Y DIA		
5	11/64	.262 .242	.312	.1770 .1760	.1595 .1570	.030	.060 .045	.025 .015	1/32 x 45°	.1640-32 UNJF-3A	.0645 .0635	.135 .115	.090 .075	2,200	940
6	13/64	.315 .295	.325	.2026 .2016	.1840 .1810	.035	.074 .055	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	2,900	1,240
8	17/64	.412 .387	.395	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	5,000	2,170
10	21/64	.505 .475	.500	.3276 .3266	.3060 .3020	.055	.110 .100	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	7,600	3,020
12	25/64	.600 .565	.545	.3901 .3891	.3680 .3640	.065	.135 .125	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	10,800	4,370
14	29/64	.676 .641	.635	.4526 .4516	.4310 .4260	.075	.155 .145	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	14,500	6,000
16	33/64	.770 .735	.685	.5151 .5141	.4930 .4880	.085	.180 .170	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	18,800	7,600

GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within .010 FIR.
(12) 2. Dimensions are in inches and to be met after finish.
(12) 3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Use HL258 for oversize replacement.

MATERIAL: (12) 7075-T6 aluminum alloy per Spec. AMS-QQ-A-225/9 or QQ-A-430.

HEAT TREAT: (12) Age to T6 condition per AMS2770.

FINISH: HL122-()-() = Anodize per Spec. MIL-A-8625, dye color natural, and cetyl alcohol lubricant per Hi-Shear Spec. 305

(12) HL122D-()-() = Anodize per MIL-A-8625, and solid film lubricant per Spec. AS5272.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds which HL122 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER
(12) **EXAMPLE:**

Pin Part Number
HL122D-8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ Replaces 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HL122D377-8-8

└─ Size and Grip Length, See Above-Example
└─ Collar Part Number
└─ Pin Finish
└─ Pin Part Number

* * The double shear values shown are based on cross sectional area for nominal diameter pin.

"HI-LOK", "HL", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY BRLEJ	DATE 1963-03-22	TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD ALUMINUM ALLOY 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED CESSNA	DATE 1963-03-22		
REVISION (12)	DATE M.BEARD 2017-11-07	DRAWING NUMBER HL122	

1 OF 1