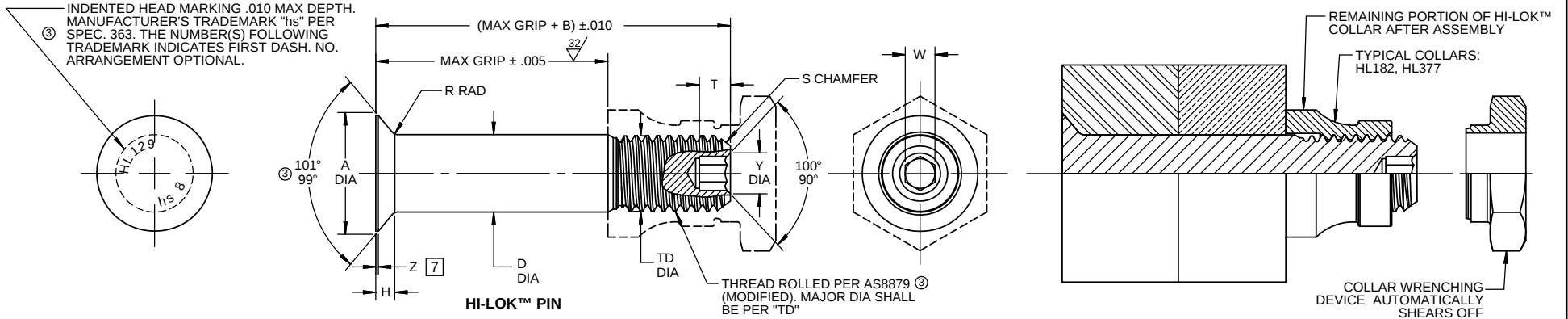


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FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
5	3/16			NOTE: Use HL29-6												
6	13/64	.3813 .3765	.325	.2026 .2016	.1840 .1810	.005	.0750 .0730	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	2,900	1,640
8	17/64	.5066 .5018	.395	.2651 .2641	.2440 .2410	.006	.1013 .0993	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	5,000	2,950
10	21/64	.6335 .6287	.500	.3276 .3266	.3060 .3020	.007	.1283 .1263	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	7,600	4,660
12	25/64	.7604 .7556	.545	.3901 .3891	.3680 .3640	.008	.1553 .1533	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	10,800	7,200
14	29/64	.8884 .8812	.635	.4526 .4516	.4310 .4260	.009	.1828 .1798	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	14,500	9,350
16	33/64	1.0139 1.0068	.685	.5151 .5141	.4930 .4880	.010	.2093 .2063	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	18,800	13,000

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - "H" dimensioned from maximum "D" diameter.
 - Dimensions are in inches and to be met after finish.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.

MATERIAL: ③ 7075 aluminum alloy per AMS-QQ-A-225/9 or QQ-A-430.

HEAT TREAT: ③ Age to T6 condition per Spec. AMS2770.

FINISH: HL129-(-)(-) = Anodize per Spec. MIL-A-8625, dye color natural.
Cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds which HL129 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.

HOW TO ORDER

③ EXAMPLE:

Pin Part Number
HL129-8-8
8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HL129377-8-8

Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY D.P.S.	DATE 1963-11-06	TITLE HI-LOK™ PIN 100° FLUSH MS24694 TENSION HEAD ALUMINUM ALLOY 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED CESSNA	DATE 1963-11-06	
REVISION ③	DATE M.BEARD 2017-11-09	DRAWING NUMBER HL129 1 OF 1