lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

Design Holder

CAGE No. 73197

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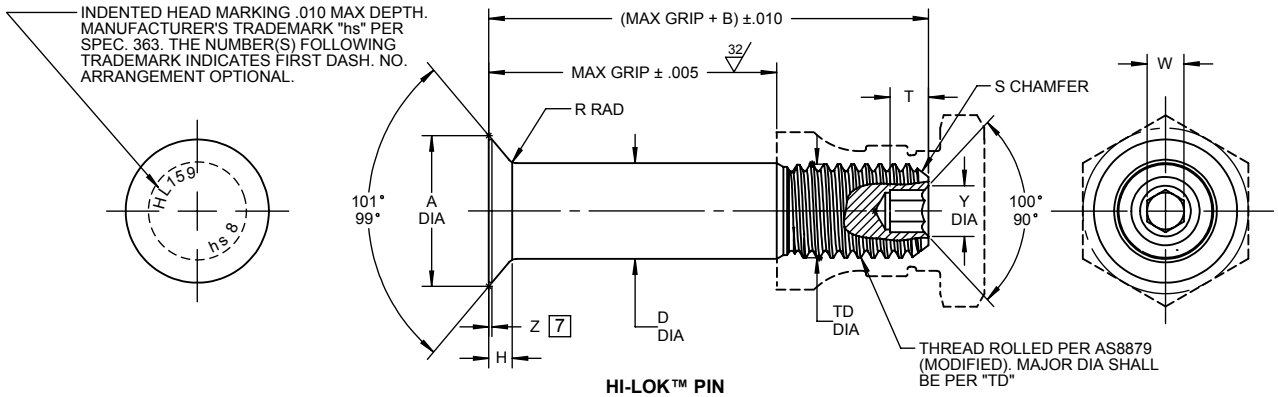
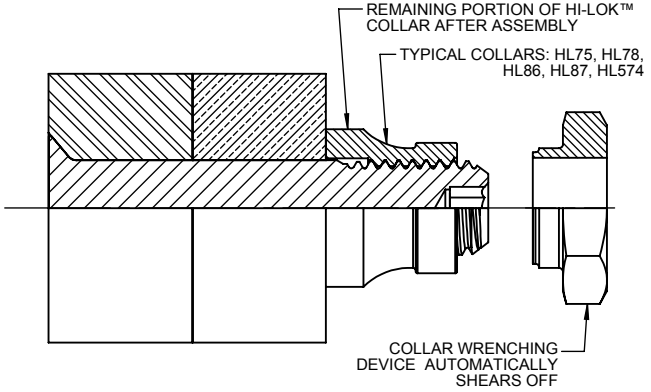
③



HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH

[1]

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F	H	R RAD	Z	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	5/32	.3304 .3256	.312	.1635 .1625	.1595 .1570	.004	.0700 .0680	.025 .015	.010 .005	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.080 .065	[7]	5,570	3,080
6	3/16	.3813 .3765	.325	.1895 .1885	.1840 .1810	.005	.0805 .0785	.030 .020	.015 .005	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.110 .080	.119 .104	7,480	4,550
8	1/4	.5066 .5018	.395	.2495 .2485	.2440 .2410	.006	.1080 .1060	.030 .020	.015 .005	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,000	8,100
10	5/16	.6335 .6287	.500	.3120 .3110	.3060 .3020	.007	.1350 .1330	.040 .030	.015 .005	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	20,200	12,900
12	3/8	.7604 .7556	.545	.3745 .3735	.3680 .3640	.008	.1620 .1600	.040 .030	.015 .005	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	29,200	20,000
14	7/16	.8884 .8812	.635	.4370 .4360	.4310 .4260	.009	.1895 .1865	.050 .040	.022 .005	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	39,700	26,900
16	1/2	1.0139 1.0068	.685	.4995 .4985	.4930 .4880	.010	.2160 .2130	.050 .040	.022 .005	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	51,800	36,000
18	9/16	1.1408 1.1337	.770	.5615 .5605	.5550 .5500	.010	.2430 .2400	.050 .040	.025 .005	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	65,600	45,600
20	5/8	1.2723 1.2651	.825	.6240 .6230	.6180 .6120	.010	.2720 .2690	.050 .040	.025 .005	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	81,000	57,200
24	3/4	1.5308 1.5236	1.050	.7490 .7480	.7430 .7370	.012	.3280 .3250	.050 .040	.025 .005	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	117,000	83,000

GENERAL NOTES:
[1] Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .003 FIM.
③ 3. Dimensions are in inches and to be met after finish.
③ 4. Surface texture per ASME B46.1.
5. Hole preparation per NAS618.
6. "H" is dimensioned from maximum "D" diameter.
[7] Evidence of broken edge across points.
[8] Curved or flat edge manufacturer's option.
9. Use HL1159 for oversize replacement.

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
③ **EXAMPLE:** Pin Part Number
HL159PB8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

MATERIAL: Multiphase MP35N per AMS5758 or AMS5844.

HEAT TREAT: 132,000 psi shear minimum.

FINISH: HL159-( )-( ) = LF31-35-8 solid film lubricant. (This finish no longer available, parts in stock are ok until depleted. Substituted with solid film lube per Everlube 382.)
HL159PB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ Product Specification 342.

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY	DATE
J.F. OBISPO	2016-02-22
VAN	1971-07-22
APPROVED	DATE
R. TING	1971-07-22
REVISION	DATE
③	KEVIN TRAN 2017-06-26

TITLE
HI-LOK™ PIN
100° FLUSH MS24694 TENSION HEAD
MP35N "MULTIPHASE"
1/16 GRIP VARIATION

DRAWING NUMBER
HL159

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HL159