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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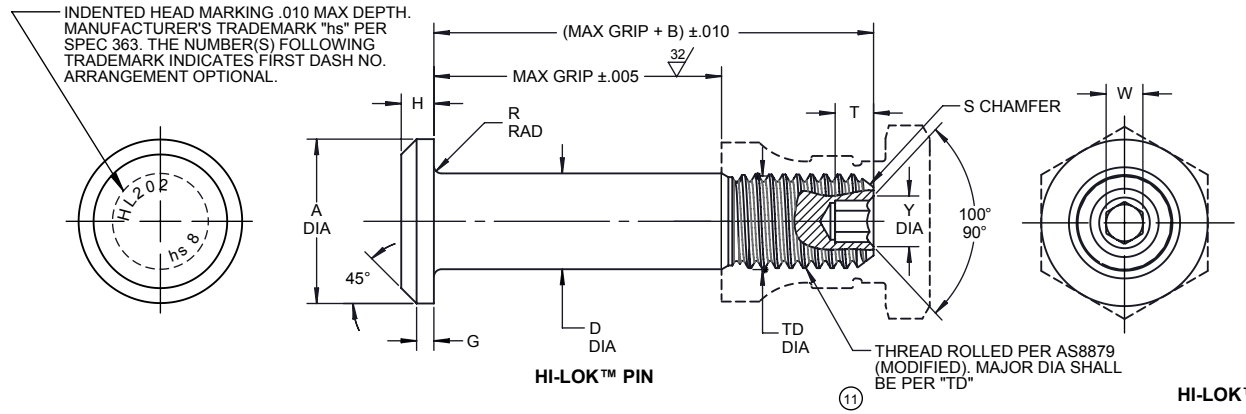
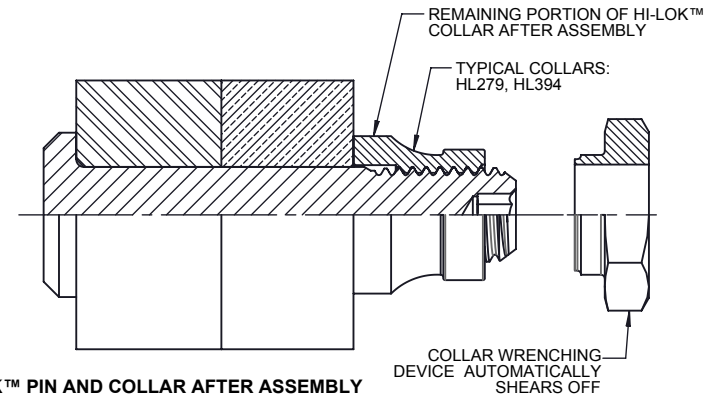


HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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 W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	7/32	NOTE: USE HL218-6-( )													
6	15/64	.340 .320	.360	.2339 .2329	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,160	2,500
8	19/64	.440 .415	.430	.2963 .2953	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,100	4,300
10	23/64	.535 .505	.530	.3589 .3579	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	19,200	6,300
12	27/64	.635 .600	.575	.4214 .4204	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	26,500	8,700
14	31/64	.710 .675	.660	.4839 .4829	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	34,900	12,100
16	35/64	.800 .765	.710	.5464 .5454	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	44,600	15,300
18	39/64	.894 .859	.795	.6084 .6074	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	55,300	19,000
20	43/64	.983 .948	.850	.6709 .6699	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	67,200	23,000
24	51/64	1.138 1.096	1.075	.7959 .7949	.7430 .7370	.070	.151 .136	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	94,500	30,700
28	59/64	1.315 1.271	1.235	.9209 .9199	.8680 .8610	.090	.187 .172	.050 .035	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.455 .425	.471 .451	127,000	45,000
32	1-3/64	1.498 1.454	1.145	1.0459 1.0449	.9930 .9860	.110	.218 .203	.060 .045	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.580 .550	.618 .598	163,000	60,900

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

GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIM.
(11) 2. Dimensions are in inches and to be met after finish.
(11) 3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.

MATERIAL: (11) Alloy steel per AMS6415, AMS6349 or AMS6322, AMS6325, AMS6327.

HEAT TREAT: 95,000 psi shear (160,000 - 180,000 psi tensile per AMS-H-6875).

FINISH: HL202-( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
(11) HL202AH( )-( ) = Cadmium plate per AMS2400-3 and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL202 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER
(11) **EXAMPLE:** Pin Part Number
HL202AH 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~~
~~HL202279-8-8~~
- ~~Size and Grip Length, See Above Example~~
- ~~Collar Part Number~~
- ~~Pin Basic Part Number~~

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

DRAWN BY	DATE
BRIEJ	1964-03-11
APPROVED	DATE
CESSNA	1964-03-11
REVISION (11)	DATE
K. TRAN	2017-09-26

TITLE
HI-LOK™ PIN
PROTRUDING SHEAR HEAD
ALLOY STEEL
1/16 GRIP VARIATION, 3/64 OVERSIZE

DRAWING NUMBER
HL202

1 OF 1

HL202