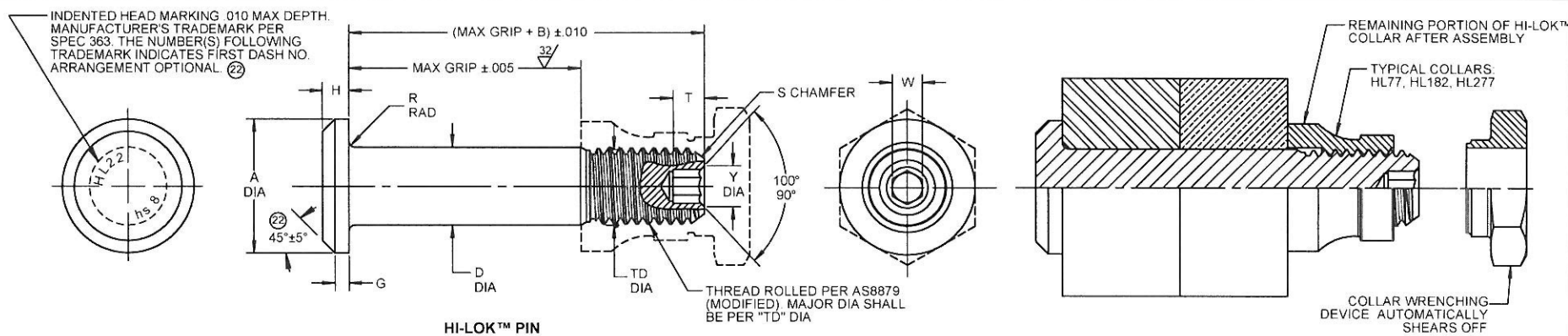




FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											W HEX	T DEPTH	Y DIA		
5	5/32	.262	.312	.1635	.1595	.030	.060	.025	1/32 x 45°	.1640-32 UNJC-3A	.0645	.135	.090	1.760	940
		.242		.1625	.1570		.045	.015			.0635	.115	.075		
6	3/16	.315	.325	.1895	.1840	.035	.074	.025	1/32 x 45°	.1900-32 UNJF-3A	.0806	.135	.119	2.550	1,240
		.295		.1885	.1810		.055	.015			.0791	.115	.104		
8	1/4	.412	.395	.2495	.2440	.045	.090	.025	1/32 x 45°	.2500-28 UNJF-3A	.0967	.150	.142	4.420	2,170
		.387		.2485	.2410		.080	.015			.0947	.130	.122		
10	5/16	.505	.500	.3120	.3060	.055	.110	.030	3/64 x 45°	.3125-24 UNJF-3A	.1295	.170	.180	6.900	3,020
		.475		.3110	.3020		.100	.020			.1270	.150	.160		
12	3/8	.600	.545	.3745	.3680	.065	.135	.030	3/64 x 45°	.3750-24 UNJF-3A	.1617	.200	.217	9.940	4,370
		.565		.3735	.3640		.125	.020			.1582	.180	.197		
14	7/16	.676	.635	.4370	.4310	.075	.155	.030	3/64 x 45°	.4375-20 UNJF-3A	.1930	.230	.253	13.800	6,000
		.641		.4360	.4260		.145	.020			.1895	.210	.233		
16	1/2	.770	.685	.4995	.4930	.085	.180	.030	3/64 x 45°	.5000-20 UNJF-3A	.2242	.260	.289	18,000	7,600
		.735		.4985	.4880		.170	.020			.2207	.240	.269		

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.
 2. Dimensions are in inches and to be met after finish.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 5. Use HL122 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 EXAMPLE:

Pin Part Number
HL22D8-8
8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Finish Code
Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HL22D778-8
Size and Grip Length-
See Above Example
Collar Part Number
Pin Finish
Pin Part Number

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

HEAT TREAT: Age to T6 condition per AMS2772.

FINISH: HL22(-)(-) = Anodize per AMS-A-8625, dye color natural and cetyl alcohol lube per Hi-Shear Spec. 305.
HL22D(-)(-) = Anodize per AMS-A-8625, and solid film lube per AS5272, Type I.
HL22TT(-)(-) = Anodize per AMS-A-8625, dye color natural and TRANSLUBE.

SPECIFICATION: HI-LOK™ Product Specification 342.

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

DRAWN BY R. K. L.	DATE 196205-08	TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD ALUMINUM 1/16 GRIP VARIATION
APPROVED CESSNA	DATE 1962-05-08	DRAWING NUMBER HL22
REVISION 22	DATE 2020-10-23	1 OF 1