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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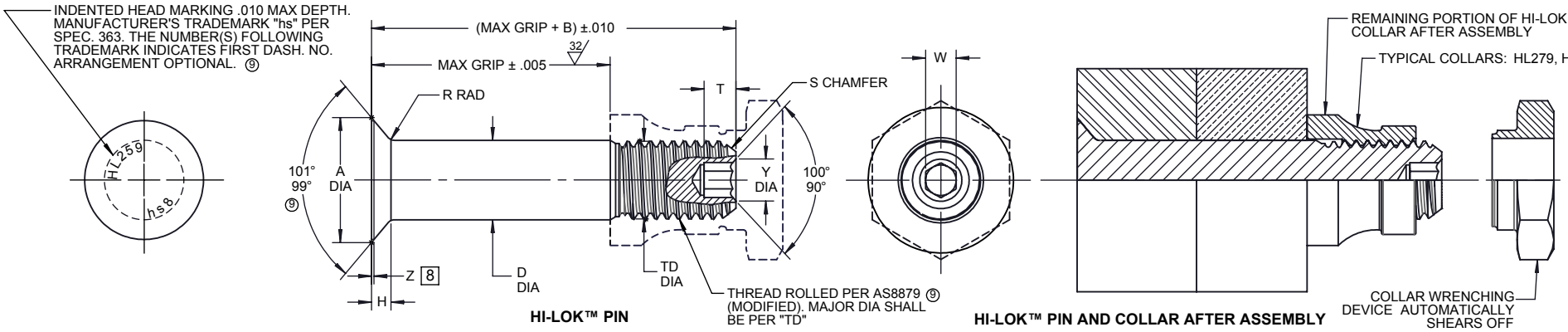

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F [1]	H	R RAD	Z [8] MAX	S CHAMFER REF	THREAD MODIFIED ⑨	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM **	TENSION POUNDS MINIMUM
5	13/64			NOTE: Use HL123-6												
6	7/32	.3536 .3486	.325	.2182 .2172	.1840 .1810	.005	.0568 .0547	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	3,400	1,150
8	9/32	.4732 .4682	.395	.2807 .2797	.2440 .2410	.006	.0807 .0786	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	5,600	2,000
10	11/32	.5619 .5569	.500	.3432 .3422	.3060 .3020	.007	.0917 .0896	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	8,300	2,800
12	13/32	.6912 .6862	.545	.4057 .4047	.3680 .3640	.008	.1198 .1177	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	11,700	3,900
14	15/32	.8041 .7969	.635	.4682 .4672	.4310 .4260	.009	.1409 .1379	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	15,500	6,000
16	17/32	.9166 .9095	.685	.5307 .5297	.4930 .4880	.010	.1619 .1589	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	19,900	7,600

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

GENERAL NOTES:
[1] Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
3. "H" dimensioned from maximum "D" diameter.
⑨ 4. Dimensions are in inches and to be met after finish.
⑨ 5. Surface texture per ASME B46.1.
6. Hole preparation per NAS618.
7. Use HL309 for oversize replacement.
[8] Curved or flat edge manufacturer's option.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL259 oversize pin replace. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER ⑨ EXAMPLE:
Pin Part Number
HL259D-8-8
- 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~~
~~HL259D377-8-8~~
- ~~Size and Grip Length, See Above Example~~
- ~~Collar Part Number~~
- ~~Pin Finish~~
- ~~Pin Part Number~~

** The Double Shear values shown are based on cross sctional area for nominal diameter pin.

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

HEAT TREAT: ⑨ Age to T6 condition per Spec. AMS2770.

FINISH: HL259-( )-( ) = Anodize per Spec. MIL-A-8625, dye color natural, and cetyl alcohol lubricant per Hi-shear Spec. 305.
HL259D-( )-( ) ⑨ = Anodize per Spec. MIL-A-8625 and solide film lubricant per Spec. AS5272.

SPECIFICATION: HI-LOK™ Product Specification 342.

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DRAWN BY	DATE	TITLE
M.M.	1963-09-06	HI-LOK™ PIN 100° FLUSH MS20426 SHEAR HEAD ALUMINUM ALLOY 1/16 GRIP VARIATION - 1/32 OVERSIZE
APPROVED CESSNA	DATE 1963-09-06	
REVISION ⑨	DATE K. TRAN 2017-11-09	DRAWING NUMBER HL259 1 OF 1

HL259