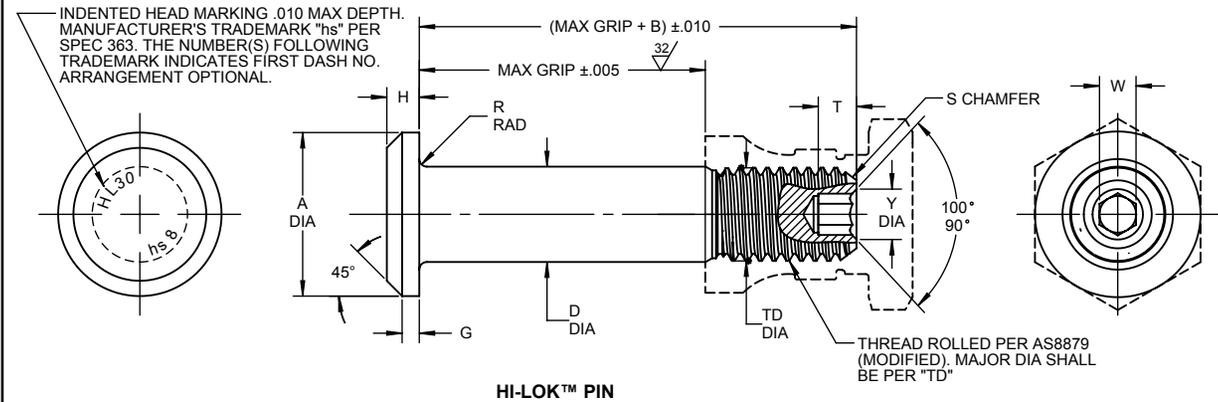
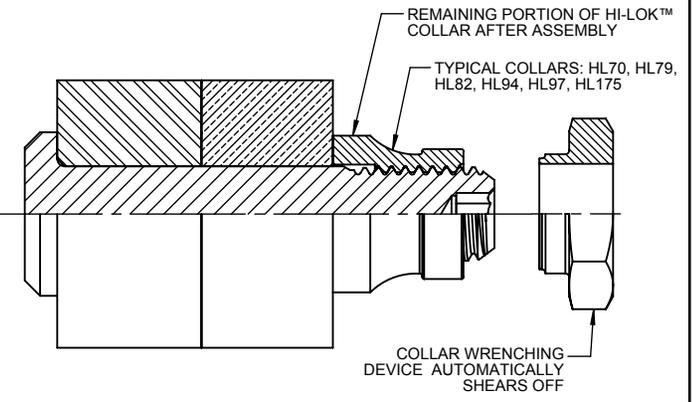


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HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

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
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
5	5/32	.262 .242	.312	.1635	.1635	.1595 .1570	.020	.047 .037	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801	.135	6	5,280	2,000
				.1630	.1625							.0791	.115			
6	3/16	.315 .295	.325	.1895	.1895	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806	.135	7,060	3,000	
				.1890	.1885							.0791	.115			
8	1/4	.412 .387	.395	.2495	.2495	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967	.160	12,260	5,100	
				.2490	.2485							.0947	.130			
10	5/16	.505 .475	.500	.3120	.3120	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295	.170	19,160	8,000	
				.3115	.3110							.1270	.150			
12	3/8	.600 .565	.545	.3745	.3745	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617	.220	27,600	11,300	
				.3740	.3735							.1582	.180			
14	7/16	.676 .641	.635	.4370	.4370	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930	.230	37,500	15,500	
				.4365	.4360							.1895	.210			
16	1/2	.770 .735	.685	.4995	.4995	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242	.260	49,100	20,000	
				.4990	.4985							.2207	.240			
18	9/16	.864 .829	.770	.5615	.5615	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555	.290	62,100	25,000	
				.5610	.5605							.2520	.270			
20	5/8	.953 .918	.825	.6240	.6240	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555	.330	76,700	30,200	
				.6235	.6230							.2520	.305			

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

DRAWN BY GARDINER	DATE 1960-12-22	TITLE HI-LOK™ PIN PROTRUDING SHEAR HEAD TYPE 431 STAINLESS STEEL 1/16 GRIP VARIATION
APPROVED CESSNA	DATE 1960-12-23	
REVISION 22	DATE KEVIN TRAN 2017-06-26	DRAWING NUMBER HL30

1 OF 2

- 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 HL66 for oversize replacement.
 6. Evidence of broken edge across points.
 7. After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: Type 431 stainless steel per AMS5628 and MIL-S-18732.

HEAT TREAT: 125,000 psi shear minimum.

- FINISH:**
- HL30(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 7 HL30AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL30BJ(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL30D(-)(-) = Solid film lube per Spec. AS5272, Type I.
 - HL30K(-)(-) = Solid film lube per Spec. "Lubeco" 905.
 - HL30UR(-)(-) = Passivate per Hi-Shear Spec. 258, red identification on top of heads, 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
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER

22 **EXAMPLE:**

