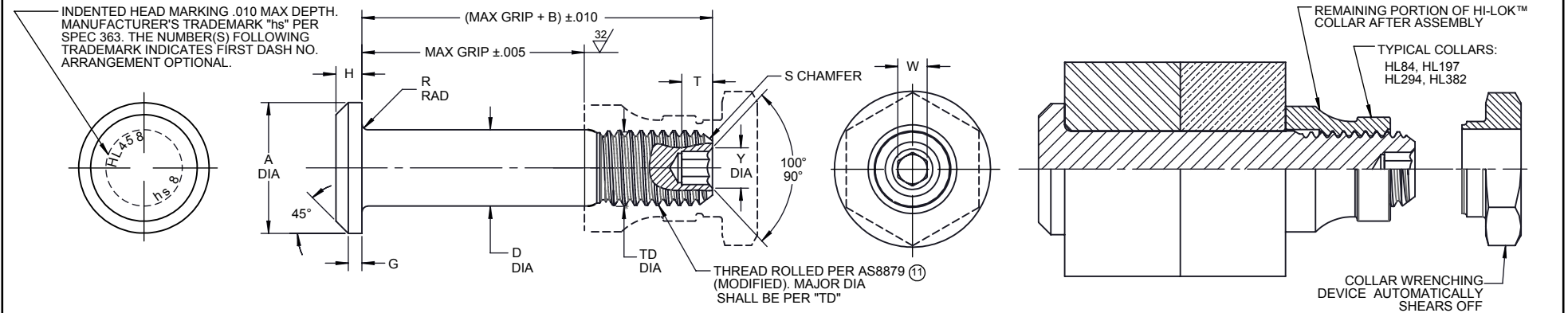


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HI-LOK™ PIN

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			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											W HEX	T DEPTH	Y DIA		
5	13/64			NOTE: Use HL52-6											
6	7/32	.315 295	.325	.2182 2172	.1840 1810	.025	.055 045	.025 015	1/32 x 45°	.1900-32 UNJF-3A	.0806 0791	.135 115	.119 104	9,400	3,000
8	9/32	.412 387	.395	.2807 2797	.2440 2410	.030	.069 059	.025 015	1/32 x 45°	.2500-28 UNJF-3A	.0967 0947	.150 130	.142 122	15,500	5,100
10	11/32	.505 475	.500	.3432 3422	.3060 3020	.035	.078 068	.030 020	3/64 x 45°	.3125-24 UNJF-3A	.1295 1270	.170 150	.180 160	23,200	8,000
12	13/32	.600 565	.545	.4057 4047	.3680 3640	.040	.088 078	.030 020	3/64 x 45°	.3750-24 UNJF-3A	.1617 1582	.200 180	.217 197	32,400	11,300
14	15/32	.676 641	.635	.4682 4672	.4310 4260	.045	.105 093	.030 020	3/64 x 45°	.4375-20 UNJF-3A	.1930 1895	.230 210	.253 233	43,100	15,500
16	17/32	.770 735	.685	.5307 5297	.4930 4880	.050	.115 103	.030 020	3/64 x 45°	.5000-20 UNJF-3A	.2242 2207	.260 240	.289 269	55,400	20,000

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

GENERAL NOTES:

1. Concentricity: Head to "D" diameter within .010 FIR.
2. Dimensions are in inches and to be met after plating.
3. Non-lubed pins must be used with wet sealant or with lubed collars.
4. Surface texture per ASME B46.1.
5. Hole preparation per NAS618.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HL458 oversize pin replace.
 Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

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

HEAT TREAT: 125,000 psi shear minimum.

FINISH: ⑪ HL458-()-() = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.

⑪ HL458KR-()-() = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2 with red identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.

⑪ HL458PN-()-() = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2 (See Note 3.)

SPECIFICATION: HI-LOK™ Product Specification 342.

HOW TO ORDER

⑪ **EXAMPLE:**

Pin Part Number
 HL458KR-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
 HL45884-8-8

Size and Grip Length,
 See Above Example

Collar Part Number

Pin Part Number

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

DRAWN BY
 BRLEJ

DATE
 1963-04-09

APPROVED
 CESSNA

DATE
 1963-04-09

REVISION
 ⑪

DATE
 2017-11-13

TITLE
 HI-LOK™ PIN
 PROTRUDING SHEAR HEAD
 TYPE 431 STAINLESS STEEL
 1/16 GRIP VARIATION, 1/32 OVERSIZE

DRAWING NUMBER
HL458

1 OF 1