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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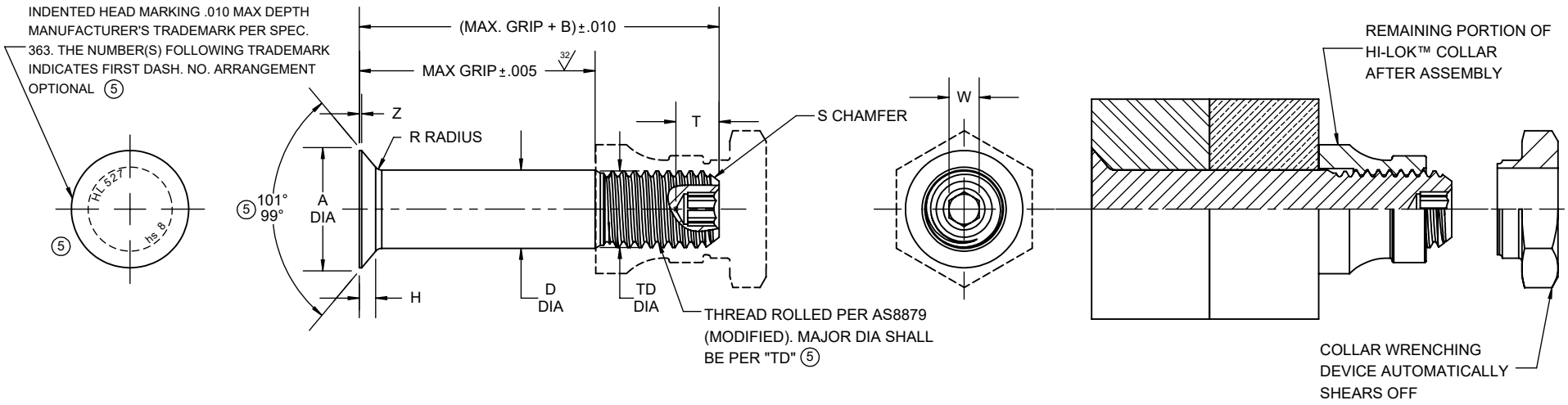

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA WITHOUT COATING OR SOLID FILM	D DIA AFTER COATING OR SOLID FILM	TD DIA	F REF	H	R RAD	Z	S CHAMFER REF	(5) THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	[9] DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM [8] HL79 HL82	TENSION POUNDS MINIMUM [8] HL94 HL175
5	3/16					NOTE: Use HL525-6											
6	13/64	.3536 .3486	.325	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0633 .0612	.030 .020	.015 .005	1/32" x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	6,130	1,600	2,000
8	17/64	.4732 .4682	.395	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0873 .0852	.030 .020	.015 .005	1/32" x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	10,490	3,000	3,700
10	21/64	.5619 .5569	.500	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0983 .0962	.040 .030	.015 .005	3/64" x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	16,000	5,000	5,000
12	25/64	.6912 .6862	.545	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1263 .1242	.040 .030	.015 .005	3/64" x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	22,700	7,000	7,200
14	29/64	.8041 .7969	.635	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1474 .1444	.050 .040	.022 .005	3/64" x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	30,600	9,500	10,000
16	33/64	.9166 .9095	.685	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1674 .1644	.050 .040	.022 .005	3/64" x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	39,600	12,500	13,500

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

DRAWN BY	DATE	TITLE
DMB	1963-07-10	HI-LOK™ PIN 100° FLUSH MS20426 HEAD ALLOY STEEL 1/16 GRIP VARIATION1/64 OVERSIZE
APPROVED	DATE	
CESSNA	1963-07-10	
REVISION	DATE	DRAWING NUMBER
(5)	B. CHAN 2021-09-09	HL527

1 OF 2

HL527

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GENERAL NOTES:

1. Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .005 TIR.
3. "H" Dimensioned from maximum "D" diameter.
4. Dimensions to be met after plating.
5. (5) Surface texture per ASME B46.1.
6. Hole preperation per NAS618.
7. Use HL255 for oversize replacement.
8. (5) [8.] See reference collar standards page for detail dimensions.
9. (5) [9.] The double shear values shown are based on cross sectional area for nominal diameter pin.

(5) **MATERIAL:** Alloy steel per Spec AMS6349, AMS6382, AMS-S-6049, AMS6322, AMS6325, AMS-S-6758.

(5) **HEAT TREAT:** 95,000 PSI shear minimum (160,000-180,000 PSI tensile per Spec. AMS-H-6875.)

(5) **FINISH:** HL527( )-( ) = Cadmium plate per spec. AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per HI-SHEAR Spec. 305.

(5) **SPECIFICATION:** HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds which HL527 oversize replaces.
Second dash number indicates maximum grip in 1/16ths.

(5) **HOW TO ORDER EXAMPLE:**

Pin Part Number

HL527 - 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 Part Number Combination~~

~~HL527 79 - 8 - 8~~

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

HL527

DRAWING NUMBER
HL527