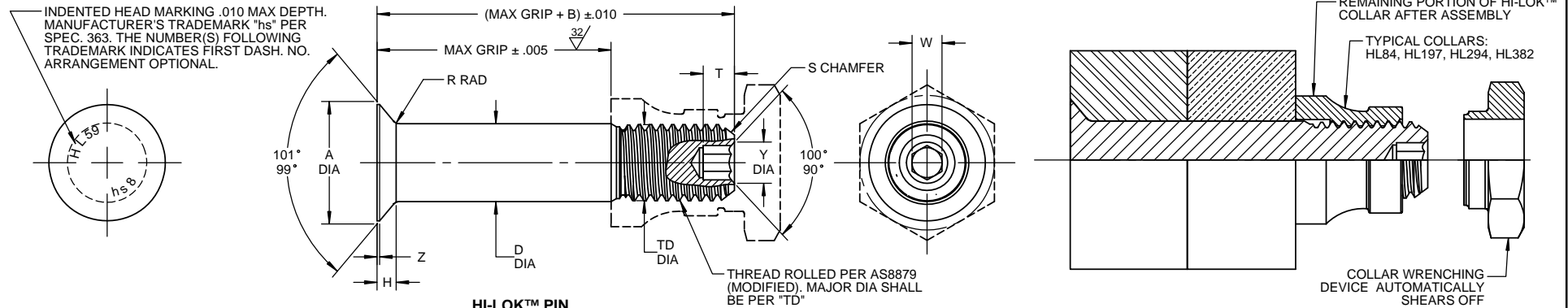


(12)

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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	F REF	H	R RAD	Z	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							NOTE: USE HL67( )6(-)										
6	7/32	.3308 .3253	.325	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0472 .0449	.030 .020	.015 .005	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	9,400	2,600
8	9/32	.4265 .4210	.395	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0612 .0589	.030 .020	.015 .005	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	15,500	4,400
10	11/32	.5056 .5001	.500	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0681 .0658	.040 .030	.015 .005	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	23,200	7,000
12	13/32	.5921 .5866	.545	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0782 .0759	.040 .030	.015 .005	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	32,400	10,000
14	15/32	.6997 .6932	.635	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0971 .0944	.040 .030	.022 .005	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	43,100	13,500
16	17/32	.7857 .7792	.685	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1070 .1043	.050 .040	.022 .005	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	55,400	18,000

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
  - Concentricity: Conical surface of head to "D" diameter within .003 FIM.
  - Dimensions are in inches and to be met after finish.
  - Surface texture per ASME B46.1.
  - Hole preparation per NAS618.
  - "H" is dimensioned from maximum "D" diameter.
  - 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:** (12) Type 431 stainless steel per AMS5628.

**HEAT TREAT:** 125,000 psi shear minimum.

**FINISH:** HL59(-)(-) = Passivate per Hi-Shear Spec. 258 and Cetyl alcohol lube per Hi-Shear Spec. 305.  
(7) HL59AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HL59D(-)(-) = Solid film lube per Spec. AS5272 Type I.  
HL59K(-)(-) = Solid film lubricant per "Lubeco" 905.

**SPECIFICATION:** HI-LOK™ Product Specification 342.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HL59 oversize pin replaces.  
Second dash number indicates maximum grip in 1/16ths.  
See Finish note for explanation of code letters.

**HOW TO ORDER**

(12) **EXAMPLE:**

Pin Part Number  
HL59AP8-8

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

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

DRAWN BY D.M.B.	DATE 1962-08-02	TITLE HI-LOK™ PIN 100° FLUSH SHEAR HEAD TYPE 431 STAINLESS STEEL 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED CESSNA	DATE 1982-08-02	DRAWING NUMBER <b>HL59</b>	
REVISION (12)	DATE M.BEARD 2017-06-26	1 OF 1	