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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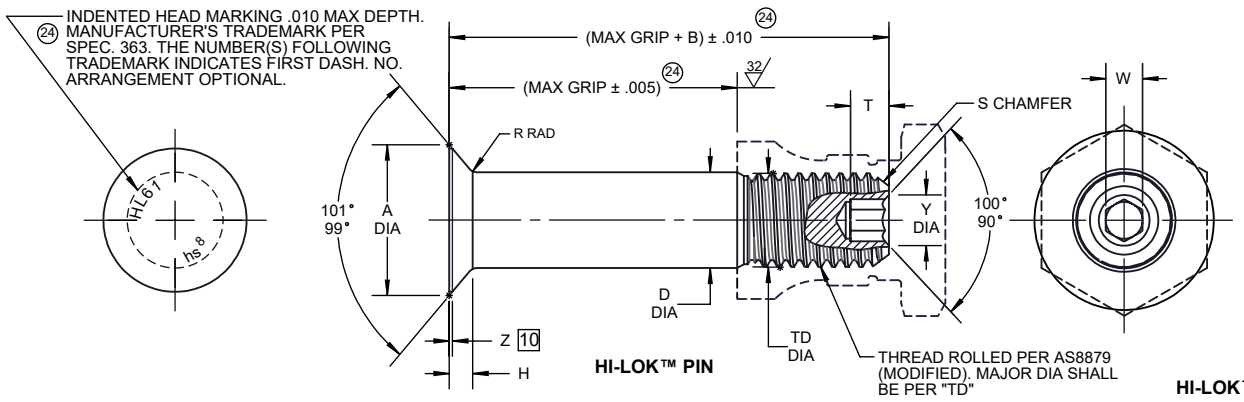
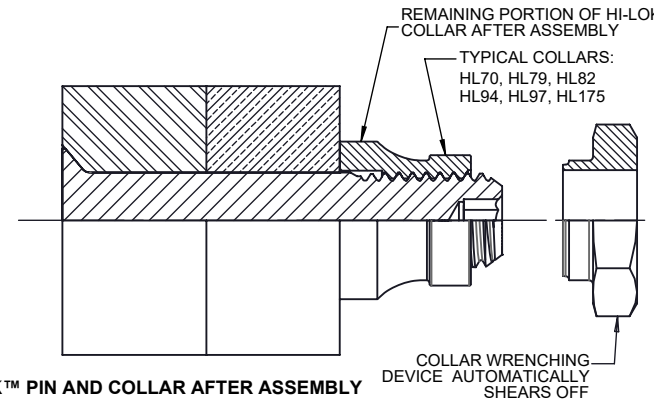


HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	5/32	.2612 .2564	.312	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	[9]	5,280	1,700
6	3/16	.3016 .2966	.325	.1895 .1885	.1840 .1810	.005	.0470 .0449	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	7,060	2,600
8	1/4	.3948 .3898	.395	.2495 .2485	.2440 .2410	.006	.0610 .0589	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	12,260	4,400
10	5/16	.4739 .4689	.500	.3120 .3110	.3060 .3020	.007	.0679 .0658	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	19,160	7,000
12	3/8	.5604 .5554	.545	.3745 .3735	.3680 .3640	.008	.0780 .0759	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	27,600	10,000
14	7/16	.6680 .6620	.635	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	37,500	13,500
16	1/2	.7540 .7480	.685	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	49,100	18,000

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.
4. Dimensions are in inches and to be met after plating.
[5] Non-lubed pins must be used with wet sealant or with lubed collars.
6. Surface texture per ASME B46.1.
7. Hole preparation per NAS618.
8. Use HL53 for oversize replacement.
[9] Evidence of broken edge across points.
[10] Curved or flat edge manufacturer's option.

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

HEAT TREAT: 125,000 psi shear mimimum.

FINISH:
HL61-( )-( ) = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
(24) HL61KR( )-( ) = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2, red identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.
(24) HL61PH( )-( ) = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2, black color, and cetyl alcohol lube per Hi-Shear Spec. 305.
(24) [5] HL61PK( )-( ) = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2, olive drab color.
(24) [5] HL61PN( )-( ) = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2.

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 EXAMPLE:
Pin Part Number
(24) HL61PK8-8
- 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~~
~~HL6179-8-8~~
- ~~Size and Grip Length, See Above Example~~
- ~~Collar Part Number~~
- ~~Pin Part Number~~

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

DRAWN BY	DATE	TITLE
R.K.L.	1961-06-30	HI-LOK™ PIN 100° FLUSH SHEAR HEAD TYPE 431 STAINLESS STEEL 1/16 GRIP VARIATION CADMIUM PLATED
APPROVED	DATE	
M.E.C.	1961-06-30	
REVISION	DATE	DRAWING NUMBER
(24)	K. MURKER 2020 / 1 / 7	HL61 1 OF 1

HL61