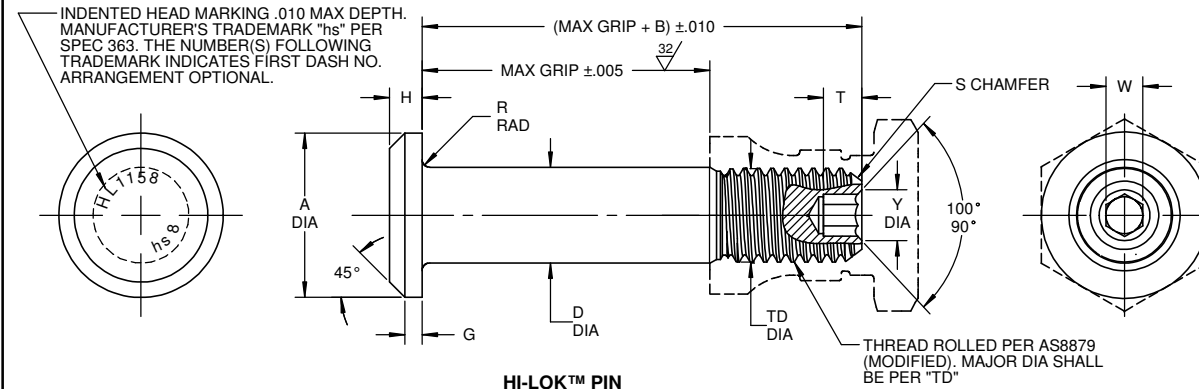
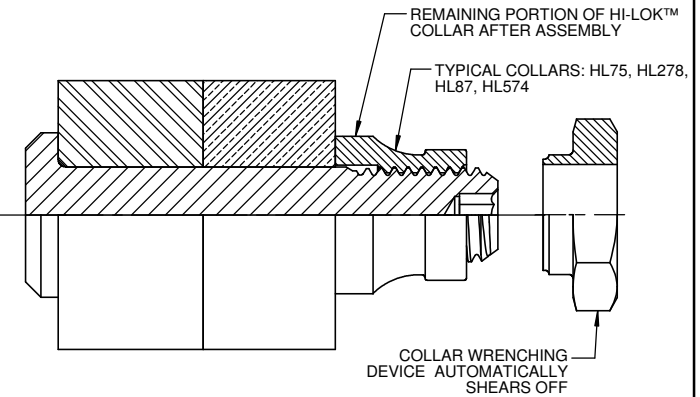


② For the current list of licensed manufacturers, please visit the
 LISI AEROSPACE website at:
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)



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
											W HEX	T DEPTH	Y DIA		
5					NOTE: USE HL158()6(-)										
6	13/64	.377 .357	.325	.2026 .2016	.1840 .1810	.040	.085 .075	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,500	4,550
8	17/64	.440 .415	.395	.2651 .2641	.2440 .2410	.055	.110 .100	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	14,600	8,100
10	21/64	.505 .475	.500	.3276 .3266	.3060 .3020	.080	.140 .130	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	22,300	12,900
12	25/64	.600 .565	.545	.3901 .3891	.3680 .3640	.110	.175 .165	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	31,600	20,000
14	29/64	.676 .641	.635	.4526 .4516	.4310 .4260	.135	.200 .190	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	42,500	26,900
16	33/64	.770 .735	.685	.5151 .5141	.4930 .4880	.145	.240 .230	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,100	36,000
18	37/64	.877 .842	.770	.5771 .5761	.5550 .5500	.245	.330 .320	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	69,100	45,600
20	41/64	.953 .918	.825	.6396 .6386	.6180 .6120	.260	.360 .350	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	84,900	57,200
24	49/64	1.150 1.110	1.050	.7646 .7636	.7430 .7370	.265	.390 .375	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	121,300	83,000

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions to be met after finish and before solid film lubricant.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
5. Use HL1258 for oversize replacement.

MATERIAL: Multiphase MP35N per AMS5758 and AMS5844.

HEAT TREAT: 132,000 psi tensile minimum.

② **FINISH:** HL1158(-)(-) = LF31-35-8 solid film lubricant.
 (This finish no longer available, parts in stock are ok until depleted. Substituted with solid film lube per Everlube 382.)
 HL1158KF(-)(-) = Passivate and solid film lube per Everlube 382.
 HL1158PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, 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 of the pin which HL1158 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER
 EXAMPLE:**

Pin Part Number
 HL1158PB8-8
 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 J.Obispo	DATE 1993-05-13	TITLE HI-LOK™ PIN
APPROVED E.E.Beeles	DATE 1993-05-20	PROTRUDING TENSION HEAD MP35 "MULTIPHASE" 1/16 GRIP VARIATION, 1/64 OVERSIZE
REVISION ②	DATE J.F.O. 2017-06-30	DRAWING NUMBER HL1158