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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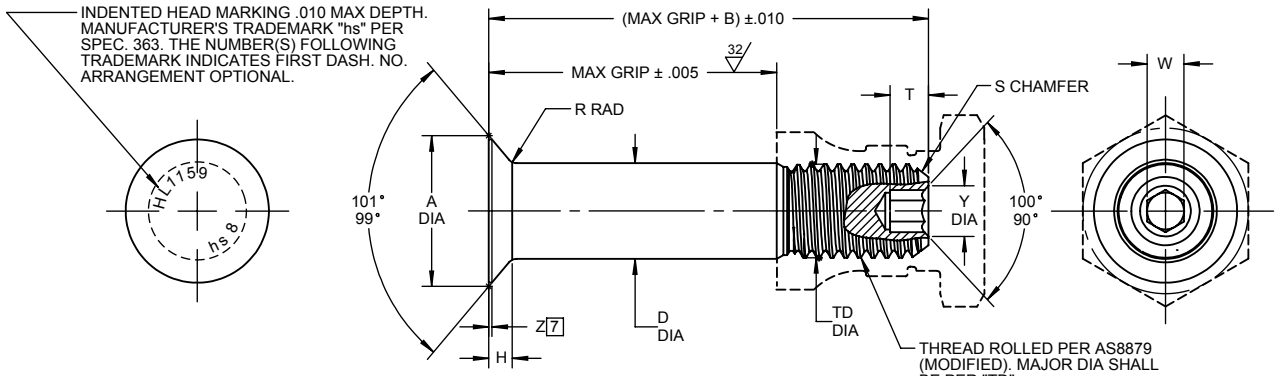
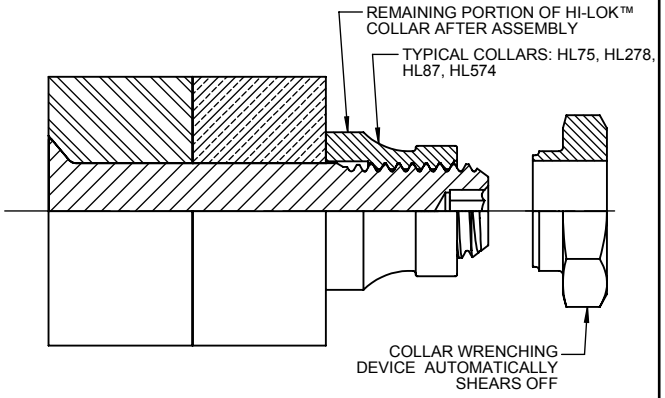


HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F [1]	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					NOTE: USE HL159( )6-( )											
6	13/64	.3813 .3765	.325	.2026 .2016	.1840 .1810	.005	.0750 .0730	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,500	4,550
8	17/64	.5066 .5018	.395	.2651 .2641	.2440 .2410	.006	.1013 .0993	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	14,600	8,100
10	21/64	.6335 .6287	.500	.3276 .3266	.3060 .3020	.007	.1283 .1263	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	22,300	12,900
12	25/64	.7604 .7556	.545	.3901 .3891	.3680 .3640	.008	.1553 .1533	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	31,600	20,000
14	29/64	.8884 .8812	.635	.4526 .4516	.4310 .4260	.009	.1828 .1798	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	42,500	26,900
16	33/64	1.0139 1.0068	.685	.5151 .5141	.4930 .4880	.010	.2093 .2063	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,100	36,000
18	37/64	1.1408 1.1337	.770	.5771 .5761	.5550 .5500	.010	.2365 .2335	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	69,100	45,600
20	41/64	1.2723 1.2651	.825	.6396 .6386	.6180 .6120	.010	.2654 .2624	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	84,900	57,200
24	49/64	1.5308 1.5236	1.050	.7646 .7636	.7430 .7370	.012	.3214 .3184	.050 .040	.025	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	121,300	83,000

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 .003 FIM.
② 3. Dimensions are in inches and to be met after finish and before solid film lubricant.
4. Surface texture per ASME B46.1.
5. Hole preparation per NAS618.
6. "H" is dimensioned from maximum "D" diameter.
[7] Curved or flat edge manufacturer's option.
8. Use HL1259 for oversize replacement.

MATERIAL: Multiphase MP35N per AMS5758 or AMS5844.

HEAT TREAT: 132,000 psi shear minimum.

FINISH: HL1159-( )-( ) = 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.)
HL1159PB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL1159KF( )-( ) = Passivate and solid film lube per Everlube 382.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL1159 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
HL1159PB8-8
- 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	DATE
T. CRAINE	1993-05-18
APPROVED	DATE
E.E. BEELES	1993-05-20
REVISION	DATE
②	K. TRAN 2017-11-02

TITLE
HI-LOK™ PIN
100° FLUSH MS24694 TENSION HEAD
MP35N "MULTIPHASE"
1/16 GRIP VARIATION, 1/64 OVERSIZE

DRAWING NUMBER
HL1159
1 OF 1

HL1159