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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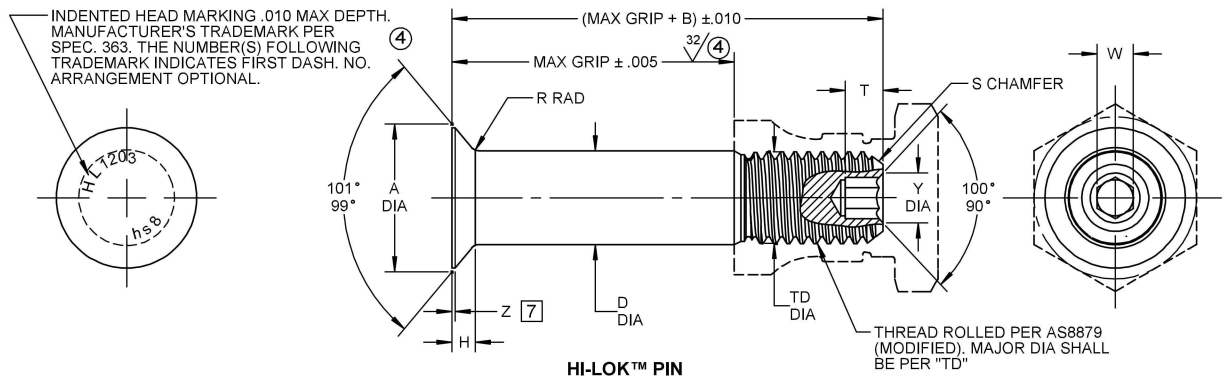
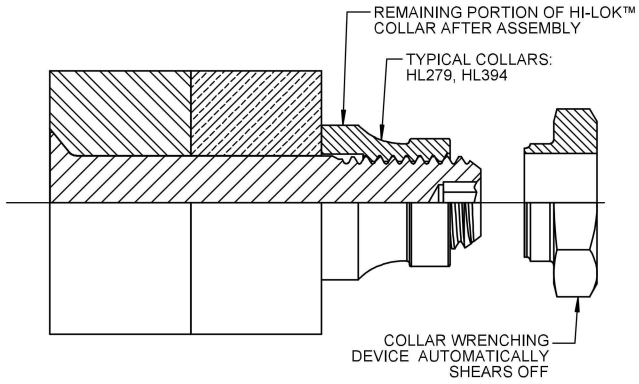


HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH

1 7

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 MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	7/32						NOTE: USE HL241( )6-( )										
6	15/64	.3460 .3410	.360	.2339 .2334	.2339 .2329	.1840 .1810	.005	.0470 .0449	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	8,160	2,000
8	19/64	.4416 .4366	.430	.2963 .2958	.2963 .2953	.2440 .2410	.006	.0610 .0589	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	13,100	3,700
10	23/64	.5208 .5158	.530	.3589 .3584	.3589 .3579	.3060 .3020	.007	.0679 .0658	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	19,200	5,000
12	27/64	.6073 .6023	.575	.4214 .4209	.4214 .4204	.3680 .3640	.008	.0780 .0759	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	26,500	7,200
14	31/64	.7148 .7088	.660	.4839 .4834	.4839 .4829	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	34,900	10,000
16	35/64	.8009 .7949	.710	.5464 .5459	.5464 .5454	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	44,600	13,500
18	39/64	.8849 .8780	.795	.6084 .6079	.6084 .6074	.5550 .5500	.010	.1160 .1131	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	55,300	19,000
20	43/64	.9712 .9641	.850	.6709 .6704	.6709 .6699	.6180 .6120	.010	.1260 .1230	.050 .040	.022	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	67,200	23,000
24	51/64	1.1439 1.1320	1.075	.7959 .7954	.7959 .7949	.7430 .7370	.012	.1460 .1410	.050 .040	.022	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	94,500	30,700

HL1203

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

DRAWN BY	DATE	TITLE
GC	1992-09-11	HI-LOK™ PIN 100° FLUSH SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 3/64 OVERSIZE
APPROVED	DATE	
A.BROWN	1992-09-30	
REVISION	DATE	DRAWING NUMBER
4	K. PHAM 2022-3-31	HL1203 1 OF 2

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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 .003 FIM.
3. Dimensions are in inches and to be met after finish.
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] Non-lubed pins must be used with lubed collars or wet sealant
④ [9] 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 UK and European Union.

MATERIAL: A-286 high temperature alloy per AMS5731 or AMS5737.

HEAT TREAT: 95,000 psi shear minimum at 70°F.

FINISH:
④HL1203-( )-( ) = Passivate per AMS2700, Method 1, Type 8, Class 1, and Cetyl alcohol lube per Hi-Shear Spec. 305.
④ [9]HL1203AZ( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL1203CG( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL1203DU( )-( ) = Solid film lube per AS5272, Type I.
[8]HL1203N( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, without lube (for use in LOX systems).
④ [8]HL1203PY( )-( ) = Passivate per AMS2700 Method 1 Type 8 Class 1.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL1203 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
HL1203AZ8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

HL1203

DRAWING NUMBER
HL1203