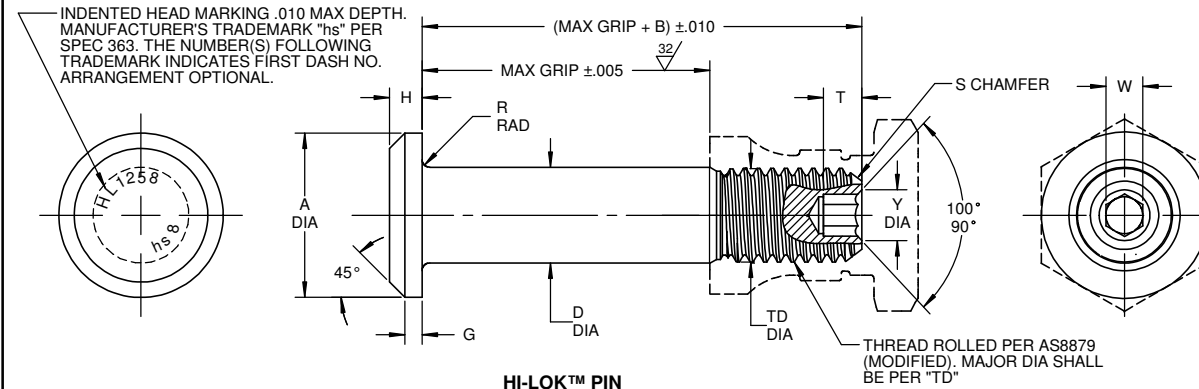
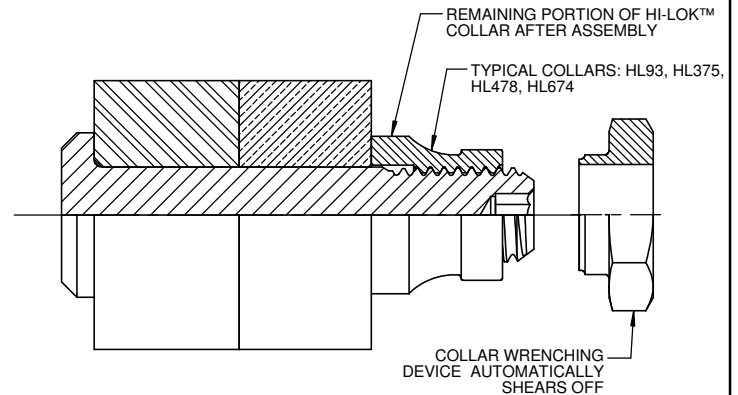


② For the current list of licensed manufacturers, please visit the
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HI-LOK™ PIN



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	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 HL1158() 6(-)										
6	7/32	.390 .370	.325	.2182 .2172	.1840 .1810	.040	.085 .075	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,900	4,550
8	9/32	.460 .435	.395	.2807 .2797	.2440 .2410	.055	.110 .100	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	16,400	8,100
10	11/32	.520 .490	.500	.3432 .3422	.3060 .3020	.080	.140 .130	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	24,500	12,900
12	13/32	.620 .550	.545	.4057 .4047	.3680 .3640	.110	.175 .165	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	34,200	20,000
14	15/32	.695 .615	.635	.4682 .4672	.4310 .4260	.135	.200 .190	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	45,500	26,900
16	17/32	.790 .740	.685	.5307 .5297	.4930 .4880	.145	.240 .230	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	58,400	36,000
18	19/32	.905 .870	.770	.5927 .5917	.5550 .5500	.245	.330 .320	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	72,900	45,600
20	21/32	.975 .940	.825	.6552 .6542	.6180 .6120	.260	.360 .350	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	82,100	57,200
24	25/32	1.185 1.145	1.050	.7802 .7792	.7430 .7370	.265	.390 .375	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	126,300	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. Oversize replacement for HL158 and HL1158.

MATERIAL: Multiphase MP35N per AMS5758 and AMS5844.

HEAT TREAT: 132,000 psi tensile minimum.

- ② **FINISH:** HL1258()-() = 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.)
HL1258KF()-() = Passivate and solid film lube per Everlube 382.
HL1258PB()-() = 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 HL1258 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
HL1258PB8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number

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are Trademarks of Hi-Shear Corporation

DRAWN BY J.Obispo	DATE 1993-08-23	TITLE HI-LOK™ PIN
APPROVED A.Brown	DATE 1993-08-24	PROTRUDING TENSION HEAD MP35 "MULTIPHASE" 1/16 GRIP VARIATION, 1/32 OVERSIZE
REVISION ②	DATE J.F.O. 2017-06-30	DRAWING NUMBER HL1258