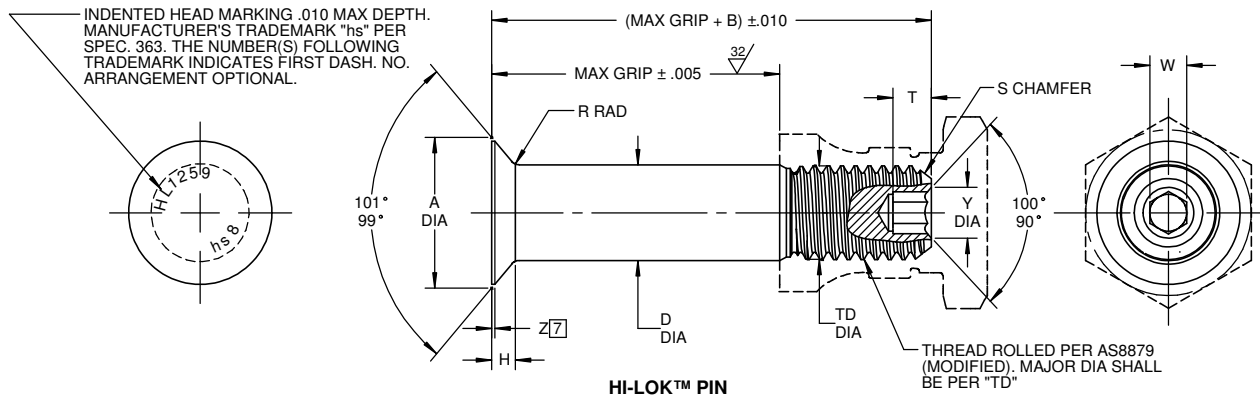
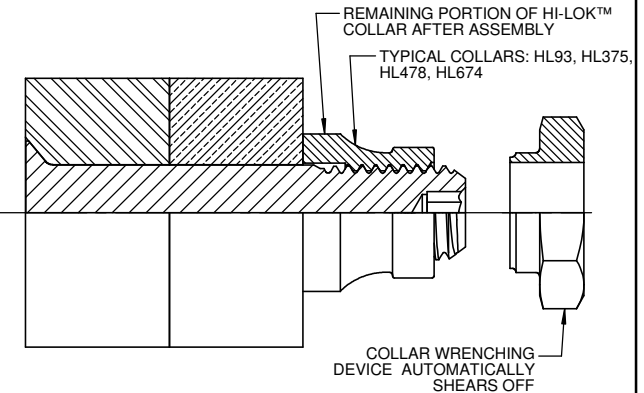


①

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

①																
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			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
5					NOTE: USE HL1159()6(-)											
6	7/32	.3813 .3765	.325	.2182 .2172	.1840 .1810	.005	.0684 .0664	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,900	4,550
8	9/32	.5066 .5018	.395	.2807 .2797	.2440 .2410	.006	.0948 .0928	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	16,400	8,100
10	11/32	.6335 .6287	.500	.3432 .3422	.3060 .3020	.007	.1218 .1198	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	24,500	12,900
12	13/32	.7604 .7556	.545	.4057 .4047	.3680 .3640	.008	.1488 .1468	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	34,200	20,000
14	15/32	.8884 .8812	.635	.4682 .4672	.4310 .4260	.009	.1763 .1733	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	45,500	26,900
16	17/32	1.0139 1.0068	.685	.5307 .5297	.4930 .4880	.010	.2027 .1997	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	58,400	36,000
18	19/32	1.1408 1.1337	.770	.5927 .5917	.5550 .5500	.010	.2300 .2270	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	72,900	45,600
20	21/32	1.2723 1.2651	.825	.6552 .6542	.6180 .6120	.010	.2584 .2559	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	89,100	57,200
24	25/32	1.5308 1.5236	1.050	.7802 .7792	.7430 .7370	.012	.3149 .3119	.050 .040	.025	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	126,300	83,000

- GENERAL NOTES:**
- ① Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .003 FIM.
 - Dimensions to be met after finish and before solid film lubricant.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - "H" is dimensioned from maximum "D" diameter.
 - [7] Curved or flat edge manufacturer's option.
 - Oversize replacement for HL159 and HL1159.

MATERIAL: Multiphase MP35N per AMS5758 or AMS5844.

HEAT TREAT: 132,000 psi shear minimum.

- ① **FINISH:** HL1259()-() = 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.)
- HL1259PB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1259KF()-() = 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 HL1259 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
HL1259PB8-8

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 T.Craigne	DATE 1994-01-11	TITLE HI-LOK™ PIN
APPROVED E.E.Beeles	DATE 1994-01-24	100° FLUSH MS24694 TENSION HEAD MP35N "MULTIPHASE" 1/16 GRIP VARIATION, 1/32 OVERSIZE
REVISION ①	DATE J.Obispo 2017-06-29	DRAWING NUMBER HL1259