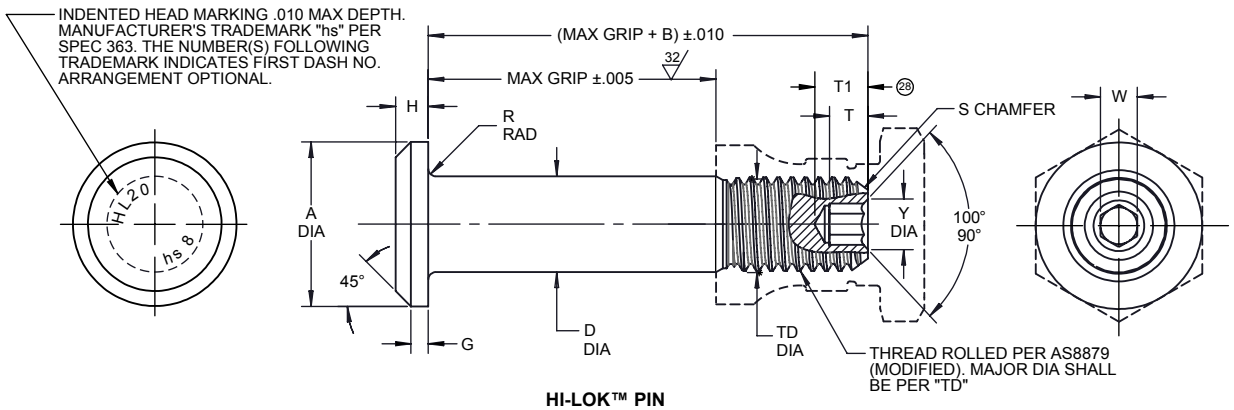
lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

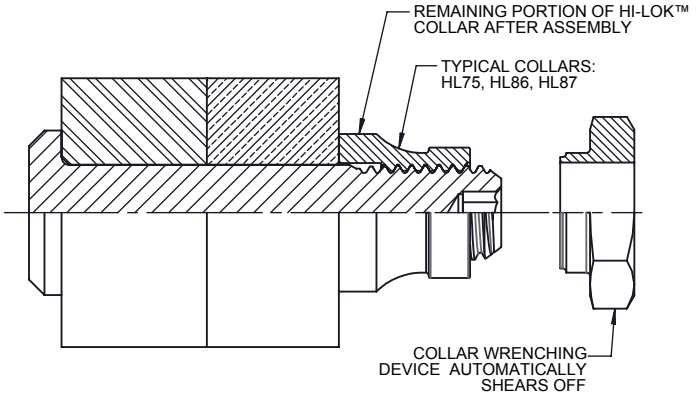
Design Holder

CAGE No. 73197

For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



HI-LOK™ PIN



HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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 W HEX	SOCKET T DEPTH	SOCKET T1 DEPTH MAX	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	5/32	.322 .306	.312	.1635 .1625	.1595 .1570	.030	.065 .055	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.135 .115	.165	[6]	4,010	2,180
6	3/16	.377 .357	.325	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.175	.119 .104	5,380	3,180
8	1/4	.440 .415	.395	.2495 .2485	.2440 .2410	.045	.090 .077	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.200	.142 .122	9,300	5,820
10	5/16	.502 .472	.500	.3120 .3110	.3060 .3020	.055	.112 .098	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.240	.180 .160	14,600	9,200
12	3/8	.565 .530	.545	.3745 .3735	.3680 .3640	.065	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.275	.217 .197	21,000	14,000
14	7/16	.627 .592	.635	.4370 .4360	.4310 .4260	.075	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.315	.253 .233	28,600	18,900
16	1/2	.752 .717	.685	.4995 .4985	.4930 .4880	.085	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.360	.289 .269	37,300	25,600
18	9/16	.877 .842	.770	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.400	.326 .306	47,200	32,400
20	5/8	.953 .918	.825	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.440	.326 .306	58,300	41,000
24	3/4	1.150 1.110	1.050	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.520	.398 .378	83,900	59,500
28	7/8	1.330 1.290	1.210	.8740 .8730	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.560	.471 .451	114,000	81,500
32	1	1.510 1.470	1.390	.9990 .9980	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.715	.618 .598	149,000	106,000

(28)

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

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

DRAWN BY	DATE	TITLE
RIC	1963-03-11	HI-LOK™ PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION
APPROVED CESSNA	DATE 1963-03-13	
REVISION (28)	DATE F.CARINGELLA 2018-10-11	DRAWING NUMBER **HL20**

1 OF 2

HL20

lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions are in inches and to be met after finish.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Non-lubed pins must be used with sealant or lubed collars.
6. Evidence of broken edge across points.
7. Use HL64 for oversize replacement.

MATERIAL: Alloy steel per AMS6415, AMS6349 or AMS6382, AMS6322.

HEAT TREAT: 160,000 - 180,000 psi tensile per AMS-H-6875.

FINISH:
HL20-( )-( ) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL20N( )-( ) = Diffused nickel-cadmium plate per AMS2416, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL20PB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
5 HL20PN( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
HL20RB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color violet to purple, 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
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:
Pin Part Number
HL20PB8-8
- HL20 — Pin Basic Part Number
- PB — Finish Code
- 8 — 8/32 or 1/4 Nominal Diameter Pin
- 8 — 8/16 or 1/2 Maximum Grip Length

HL20

DRAWING NUMBER
HL20