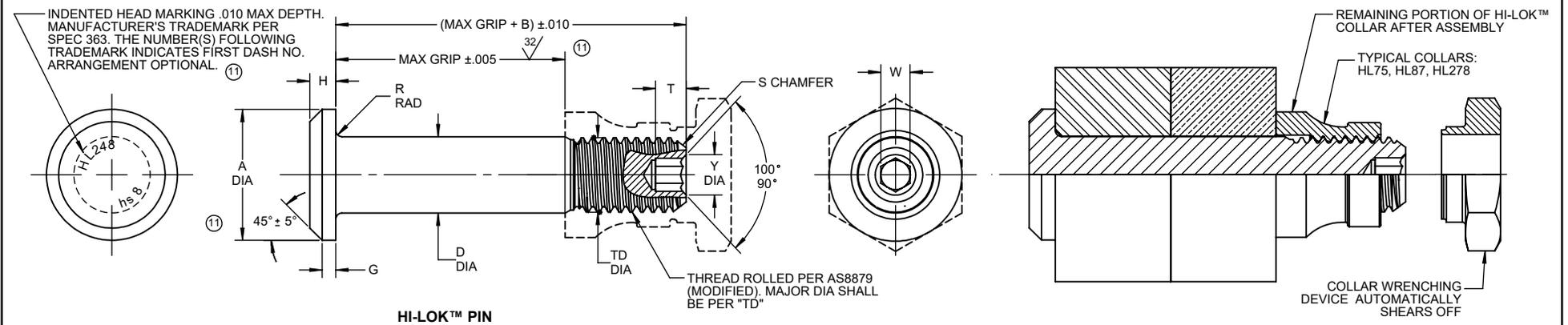


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HI-LOK™ PIN

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		
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA				
-5	3/16						NOTE: USE HL48-6(-)											
-6	13/64	.377 .357	.325	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	6,130	3,180		
-8	17/64	.440 .415	.395	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .077	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	10,490	5,820		
-10	21/64	.502 .472	.500	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .098	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	16,000	9,200		
-12	25/64	.565 .530	.545	.3901 .3896	.3901 .3891	.3680 .3640	.065	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	22,700	14,000		
-14	29/64	.627 .592	.635	.4526 .4521	.4526 .4516	.4310 .4260	.075	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	30,600	18,900		
-16	33/64	.752 .717	.685	.5151 .5146	.5151 .5141	.4930 .4880	.085	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	39,600	25,600		
-18	37/64	.877 .842	.770	.5771 .5766	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	49,700	32,400		
-20	41/64	.953 .918	.825	.6396 .6391	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	61,000	41,000		
-24	49/64	1.150 1.110	1.050	.7646 .7641	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	87,200	59,500		

** The double Shear values shown are based on cross sectional area for nominal diameter pin.

"HI-LOK", "HL", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY BRKJ	DATE 1963-05-28	TITLE HI-LOK™ PIN PROTRUDING TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED CESSNA	DATE 1963-05-28	DRAWING NUMBER HL248
REVISION 11	DATE A.CHAE 2022-05-24	1 OF 2

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIR.
 2. Dimensions are in inches and to be met after finish.
 - 3 Non-lubed pins must be used with lubed collars.
 4. Surface texture per ASME B46.1.
 5. Hole preparation per NAS618.
 6. Use HL748 for oversize replacement.
 - 7 Maximum "D" diameter may be increased by .0002 to allow for solid film or coating application.
 - 8 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in the UK and European Union.

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

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum) at 70°F.

- FINISH:**
- 1 HL248(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 8 HL248AZ(-)(-) = 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.
 - 1 HL248DL(-)(-) = Solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305
 - 1 HL248DU(-)(-) = Solid film lube per AS5272, Type I.
 - 3 HL248PY(-)(-) = Passivate per AMS2700, Method 1, Type 8, Class 1.
 - 1 HL248V(-)(-) = Solid film lube per "Lubeco" 2123, Type II.
 - 1 HL248HK(-)(-) = HI-KOTE™ 4 NC aluminum pigmented coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL248 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

**11 HOW TO ORDER
EXAMPLE:**

Pin Part Number
HL248 AZ 8 - 8
└─ 8/16 or 1/2 Maximum Grip Length
└─ Replaces 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HL24887-8-8
└─ Size and grip length, see above example
└─ Collar Part Number
└─ Pin Basic Part Number