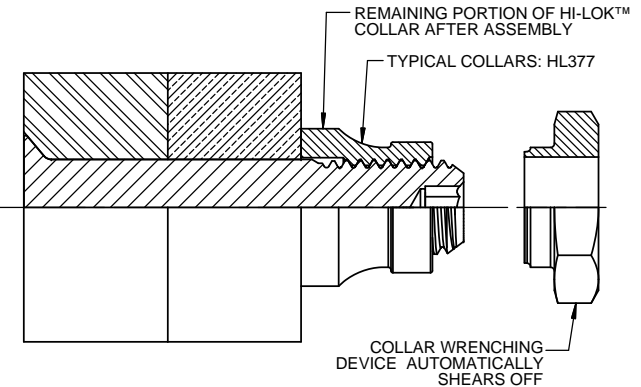
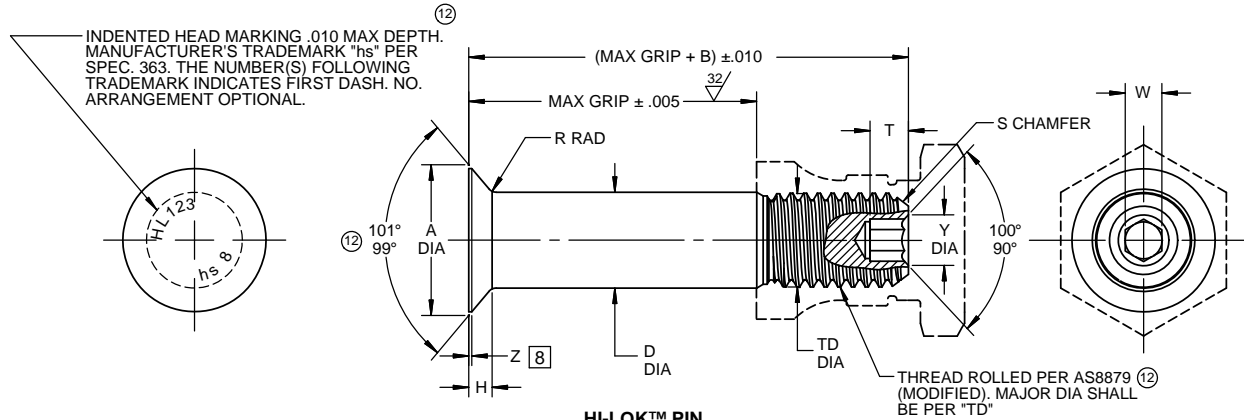


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HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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	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	11/64	.2922 .2874	.312	.1770 .1760	.1595 .1570	.004	.0483 .0463	.025 .015	.010	1/32 x 45°	.1640-32 UNJC-3A	.0645 .0635	.135 .115	.090 .075	2,200	860
6	13/64	.3536 .3486	.325	.2026 .2016	.1840 .1810	.005	.0633 .0612	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	2,900	1,150
8	17/64	.4732 .4682	.395	.2651 .2641	.2440 .2410	.006	.0873 .0852	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	5,000	2,000
10	21/64	.5619 .5569	.500	.3276 .3266	.3060 .3020	.007	.0983 .0962	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	7,600	2,800
12	25/64	.6912 .6862	.545	.3901 .3891	.3680 .3640	.008	.1263 .1242	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	10,800	3,900
14	29/64	.8041 .7969	.635	.4526 .4516	.4310 .4260	.009	.1475 .1445	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	14,500	6,000
16	33/64	.9166 .9095	.685	.5151 .5141	.4930 .4880	.010	.1685 .1655	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	18,800	7,600

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions are in inches and to be met after finish.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Use HL259 for oversize replacement.
 - Curved or flat edge manufacturer's option.

MATERIAL: 7075-T6 aluminum alloy per Spec. AMS-QQ-A-225/9 or QQ-A-430.

HEAT TREAT: Age to T6 condition per AMS2770.

FINISH: HL123-(-)(-) = Anodize per Spec. MIL-A-8625, dye color natural, and cetyl alcohol lubricant per Hi-Shear Spec. 305

HL123D-(-)(-) = Anodize per MIL-A-8625, and solid film lubricant per Spec. AS5272.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds which HL123 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
 HL123D-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
 HL123D377-8-8

Size and Grip Length, See Above Example
 Collar Part Number
 Pin Finish
 Pin Part Number

* * 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 BRLEJ	DATE 1963-03-22	TITLE HI-LOK™ PIN 100° FLUSH MS20426 SHEAR HEAD ALUMINUM ALLOY 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED CESSNA	DATE 1963-03-22		
REVISION 12	DATE M.BEARD 2017-11-07	DRAWING NUMBER HL123	
		1 OF 1	