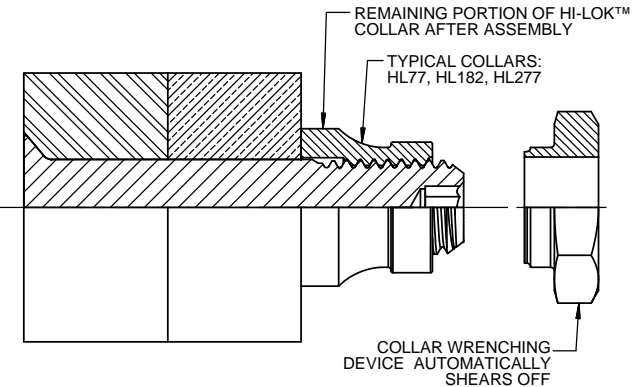
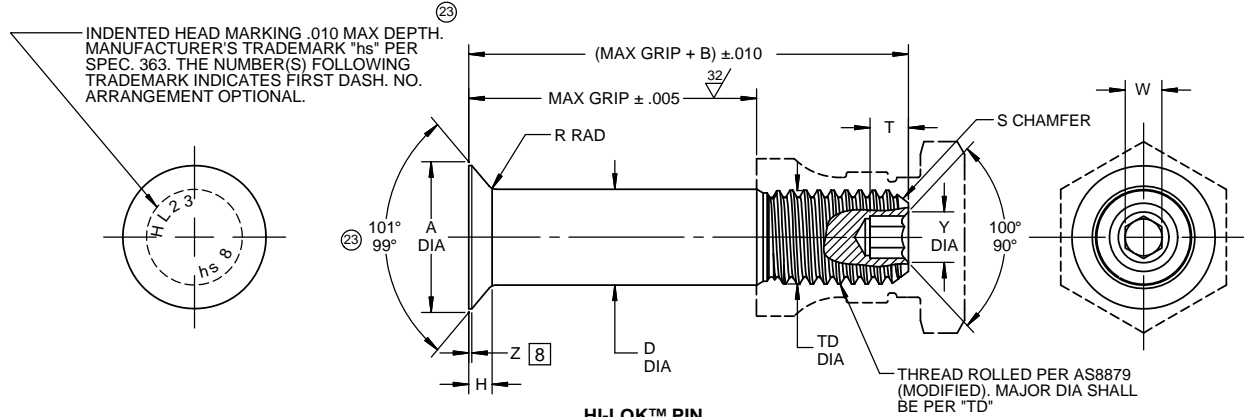


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HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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	5/32	.2922 .2874	.312	.1635 .1625	.1595 .1570	.004	.0540 .0520	.025 .015	.010	1/32 x 45°	.1640-32 UNJC-3A	.0645 .0635	.135 .115	.090 .075	1,760	860
6	3/16	.3536 .3486	.325	.1895 .1885	.1840 .1810	.005	.0688 .0667	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	2,550	1,150
8	1/4	.4732 .4682	.395	.2495 .2485	.2440 .2410	.006	.0939 .0918	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	4,420	2,000
10	5/16	.5619 .5569	.500	.3120 .3110	.3060 .3020	.007	.1048 .1027	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	6,900	2,800
12	3/8	.6912 .6862	.545	.3745 .3735	.3680 .3640	.008	.1329 .1308	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	9,940	3,900
14	7/16	.8041 .7969	.635	.4370 .4360	.4310 .4260	.009	.1540 .1510	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	13,800	6,000
16	1/2	.9166 .9095	.685	.4995 .4985	.4930 .4880	.010	.1750 .1720	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	18,000	7,600

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "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 HL123 for oversize replacement.
 - Curved or flat edge manufacturer's option.

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

HEAT TREAT: Age to T6 condition per AMS2770.

FINISH: HL23(-)(-) = Anodize per MIL-A-8625, dye color natural and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL23D(-)(-) = Anodize per MIL-A-8625, and solid film lube per AS5272, Type I.
 HL23TT(-)(-) = Anodize per MIL-A-8625, dye color natural and transluce.

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
 HL23TT8-8
 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 R.K.L.	DATE 1962-05-08	TITLE HI-LOK™ PIN 100° FLUSH MS20426 SHEAR HEAD ALUMINUM ALLOY 1/16 GRIP VARIATION	
APPROVED CESSNA	DATE 1962-05-08	DRAWING NUMBER HL23	
REVISION 23	DATE M.BEARD 2017-08-01	1 OF 1	