



FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	H	R RAD.	Z	S CHAMFER	THREAD MODIFIED	SOCKET		DOUBLE SHEAR POUNDS MINIMUM	UTS MIN. REQUIREMENT	
												W HEX	T DEPTH			
-5	13/64	NOTE: USE HL527-6														
-6	7/32	.3536 .3486	.325	.2182 .2172	.1840 .1810	.005	.0568 .0547	.030 .020	.015 .005	1/32" X 45°	.1900-32UNJF-3A	.0806 .0791	.135 .115	7,100	2,590	
-8	9/32	.4732 .4682	.395	.2807 .2797	.2440 .2410	.006	.0807 .0786	.030 .020	.015 .005	1/32" x 45°	.2500-28UNJF-3A	.0967 .0947	.150 .130	11,800	4,760	
-10	11/32	.5619 .5569	.500	.3432 .3422	.3060 .3020	.007	.0917 .0896	.040 .030	.015 .005	3/64" X 45°	.3125-24UNJF-3A	.1295 .1270	.170 .150	17,600	7,100	
-12	13/32	.6912 .6862	.545	.4057 .4047	.3680 .3640	.008	.1198 .1177	.040 .030	.015 .005	3/64 X45°	.3750-24UNJF-3A	.1617 .1582	.200 .180	24,600	10,600	
-14	15/32	.8041 .7969	.635	.4682 .4672	.4310 .4260	.009	.1409 .1379	.050 .040	.022 .005	3/64 x45°	.4375-20UNJF-3A	.1930 .1895	.230 .210	32,700	14,450	
-16	17/32	.9166 .9095	.685	.5307 .5297	.4930 .4880	.010	.1619 .1589	.050 .040	.022 .005	3/64 x45°	.5000-20UNJF-3A	.2242 .2207	.260 .240	42,000	19,550	

* See collar standards for collar strengths. Lower strength (pin or collar) determines system strength.

** The Double Shear Values Shown are based on cross sectional area for nominal diameter pin.

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of "A" to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions are in inches and to be met after plating.
 - Surface texture per ASME B46.1
 - Hole preparation per NAS618.
 - Use HL207 for oversize replacement

CODE: First dash number indicates nominal diameter in 1/32nds which HL255 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths.

HOW TO ORDER EXAMPLE:

Pin Part Number Only
HL255-8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ Replaces 8/32 or 1/4 Nominal Diameter Pin
└─ Pin Part Number with Type II Cadmium Plate

Pin and Collar Assembly Part Number Combination
HL25584-8-8
└─ Size and Grip Length, See Above Example
└─ Collar Part Number
└─ Pin Part Number

MATERIAL: Alloy steel per Spec. AMS6349, AMS6382, AMS-S-6049, AMS6322, AMS6325, AMS-S-6758

HEAT TREAT: 95,000 psi shear minimum (160,000-180,000 psi tensile per spec. AMS2759)

FINISH: Cadmium plate per Spec. QQ-P-416, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ Product Spec. 342

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY BRLEJ	DATE 1964-03-11	TITLE HI-LOK™ PIN	
APPROVED CESSNA	DATE 1964-03-11	100° FLUSH MS20426 HEAD ALLOY STEEL 1/16" GRIP VARIATION - 1/32" OVERSIZE	
REVISION ④	DATE C.CARTOS 2023-05-10	DRAWING NUMBER HL255	