2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

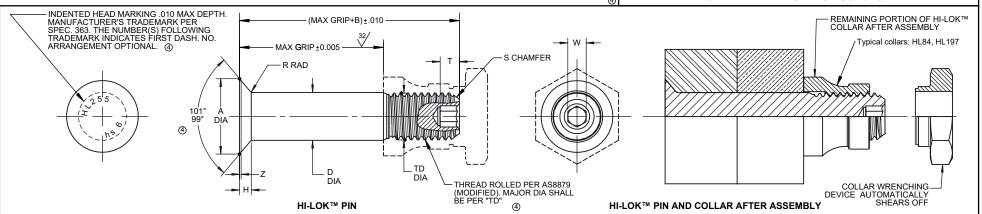
HI-SHEAR Corporation, USA a LISI AEROSPACE Company

Design Holder

CAGE No. 73197

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(4)

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	Н	R RAD.	Z	S CHAMFER	THREAD MODIFIED	SOCKET		DOUBLE SHEAR POUNDS	UTS MIN. REQUIREMENT
												W HEX	T DEPTH	MINIMUM	
-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

(4)

- * 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: 1 Head edge out of roundness shall not exceed "F".

2. Concentricity: Conical surface of "A" to "D" diameter within .005 FIM.

1

3. "H" is dimensioned from maximum "D" diameter.

4. Dimensions are in inches and to be met after plating

5. Surface texture per ASME B46.1

6. Hole preparation per NAS618. 7. 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:

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.

④ SPECIFICATION: HI-LOK™ Product Spec. 342

Pin Part Number Only HL255-8-8

> └8/16 or 1/2 Maxmium 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

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

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

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