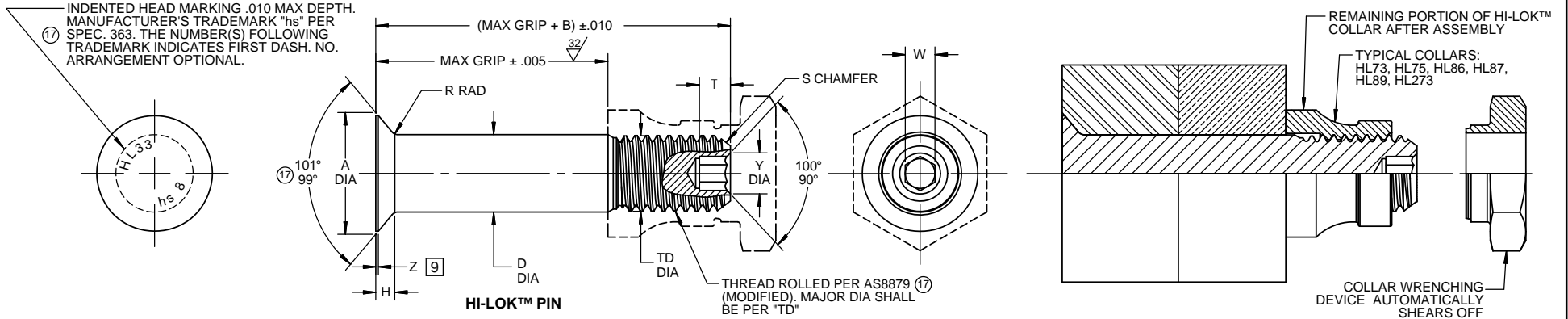


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HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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
				WITHOUT PLATING OR SOLID FILM LUBE	WITH PLATING OR SOLID FILM LUBE								W HEX	T DEPTH	Y DIA		
5	5/32	.3304	.312	.1635	.1635	.1595	.004	.0700	.025	.010	1/32 x 45°	.1640-32 UNJF-3A	.0645	.135	.090	5,280	2,940
		.3256		.1630	.1625	.1570		.0680					.0635	.115	.075		
6	3/16	.3813	.325	.1895	.1895	.1840	.005	.0805	.030	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806	.135	.119	7,060	4,350
		.3765		.1890	.1885	.1810		.0785					.0791	.115	.104		
8	1/4	.5066	.395	.2495	.2495	.2440	.006	.1080	.030	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967	.150	.142	12,260	7,750
		.5018		.2490	.2485	.2410		.1060					.0947	.130	.122		
10	5/16	.6335	.500	.3120	.3120	.3060	.007	.1350	.040	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295	.170	.180	19,160	12,300
		.6287		.3115	.3110	.3020		.1330					.1270	.150	.160		
12	3/8	.7604	.545	.3745	.3745	.3680	.008	.1620	.040	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617	.200	.217	27,600	19,100
		.7556		.3740	.3735	.3640		.1600					.1582	.180	.197		
14	7/16	.8884	.635	.4370	.4370	.4310	.009	.1895	.050	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930	.230	.253	37,500	25,800
		.8812		.4365	.4360	.4260		.1865					.1895	.210	.233		
16	1/2	1.0139	.685	.4995	.4995	.4930	.010	.2160	.050	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242	.260	.289	49,100	34,300
		1.0068		.4990	.4985	.4880		.2130					.2207	.240	.269		

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - "H" dimensioned from maximum "D" diameter.
 - Dimensions are in inches and to be met after finish.
 - Non-lubed pins must be used with wet sealant or with lubed collars.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Use HL37 for oversize replacement.
 - Curved or flat edge manufacturer's option.

MATERIAL: Type 431 stainless steel per AMS5628.

HEAT TREAT: 125,000 psi shear minimum.

- FINISH:**
- HL33-(-)(-) = Passivate per Hi-Shear Process Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL33D-(-)(-) = Solid film lube per Spec. AS5272.
 - HL33PB-(-)(-) = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL33PN-(-)(-) = Cadmium plate per Spec. AMS-QQ-P-416, Type II, Class 2.

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
 HL33D-8-8
 8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
 HL33D86-8-8

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

* * -5 size must be installed using a torque controlled hex key.

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

DRAWN BY SCHAD	DATE 1957-04-26	TITLE HI-LOK™ PIN 100° FLUSH MS24694 TENSION HEAD 431 STAINLESS STEEL 1/16 GRIP VARIATION
APPROVED CESSNA	DATE 1957-04-26	
REVISION 17	DATE M.BEARD 2017-11-09	DRAWING NUMBER HL33