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Hi-Lok and CherryMAX Grip Chart

Grip number = maximum grip in 1/16 in

Grip number against stack thickness

Grip no. (CherryMAX / Hi-Lok)	Max grip	Stack covered, in	Stack covered, mm
-01	1/16 in	.025 to .062	0.6 to 1.6
-02 / -2	1/8 in	.063 to .125	1.6 to 3.2
-03 / -3	3/16 in	.126 to .187	3.2 to 4.7
-04 / -4	1/4 in	.188 to .250	4.8 to 6.3
-05 / -5	5/16 in	.251 to .312	6.4 to 7.9
-06 / -6	3/8 in	.313 to .375	8.0 to 9.5
-07 / -7	7/16 in	.376 to .437	9.6 to 11.1
-08 / -8	1/2 in	.438 to .500	11.1 to 12.7
-09 / -9	9/16 in	.501 to .562	12.7 to 14.3
-10	5/8 in	.563 to .625	14.3 to 15.9
-11	11/16 in	.626 to .687	15.9 to 17.4
-12	3/4 in	.688 to .750	17.5 to 19.0

Key points

- **Stack in sixteenths, rounded up** gives the grip number.
- **CherryMAX:** 269C3 gauge; on a line, either number (CA-1015 p. 11).
- **Hi-Lok:** check protrusion after the collar shears off.
- **The drawing governs** one-step substitutions.

Step by step

1. Measure the stack at the hole.
2. Multiply by 16 and round up.
3. Find the number in the chart and the series in the data sheet.
4. Check minimum grip or protrusion, then order.

SOURCES · Cherry CA-1015, CherryMAX Process Manual, pp. 4 and 11 · Hi-Shear / LISI drawing HL18 rev. 28 · NASA PRC-9007C, section 6.2.3 and 6.3 Table 1 · FAA AC 43.13-1B CHG 1, Chapter 4, par. 4-57

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Educational reference only, not approved data. Always consult the applicable SRM, AMM, or AC 43.13-1B and your certifying authority.