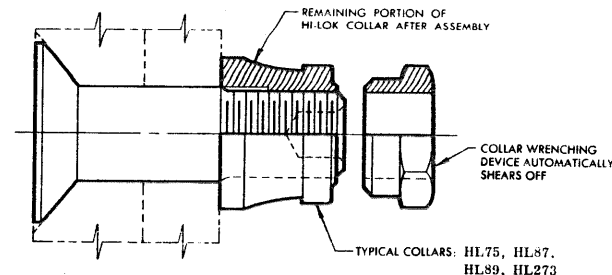
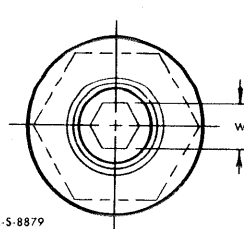
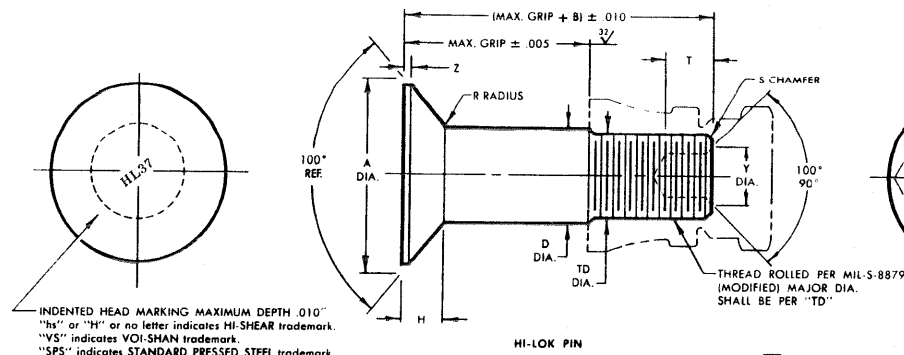


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder)	U.S. Federal Code No. 73197	HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee)
Division of Hi-Shear Industries Inc., U.S.A.		Division of Hi-Shear Industries Inc., U.S.A.
AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada)	U.S. Federal Code No. 04725	KAMAX-WERKE, Germany (Licensee - EEC Countries)
DEUTSCH FASTENER CO., INC. (Licensee)	U.S. Federal Code No. 97929	Rudolph Keilmann GmbH & Co. (Licensee - EEC Countries)
SPS TECHNOLOGIES, U.S.A. (Licensee)	U.S. Federal Code No. 58878	ST. CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee)	U.S. Federal Code No. 82215	SIMMONDS, S.A. France (Licensee - EEC Countries)
WEST COAST AEROSPACE INC., U.S.A. (Licensee)	U.S. Federal Code No. 80516	TOKYO SCREW COMPANY, Japan (Licensee - Japan)
Pins & Steel Collars		



FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	F	H	R RAD.	Z	S CHAMFER REF.	THREAD	SOCKET			* * DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT PLATING, COATING OR SOLID FILM LUBE	WITH PLATING, COATING OR SOLID FILM LUBE								W HEX.	T DEPTH	Y DIA.		
- 5	3/16			NOTE: Use HL33-G													
- 6	13/64	.3813 .3765	.325	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0750 .0730	.030 .020	.015 .005	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.135 .115	.119 .104	8,100	4,350
- 8	17/64	.5066 .5018	.395	.2651 .2646	.2651 .2641	.2440 .2410	.006	.1013 .0993	.030 .020	.015 .005	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	13,800	7,750
- 10	21/64	.6335 .6287	.500	.3276 .3271	.3276 .3266	.3060 .3020	.007	.1283 .1263	.040 .030	.015 .005	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	21,100	12,300
- 12	25/64	.7604 .7556	.545	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1553 .1533	.040 .030	.015 .005	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	30,000	19,100
- 14	29/64	.8884 .8812	.635	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1828 .1798	.050 .040	.022 .005	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	40,300	25,800
- 16	33/64	1.0139 1.0068	.685	.5151 .5146	.5151 .5141	.4930 .4880	.010	.2093 .2063	.050 .040	.022 .005	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	52,200	34,300

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Non-lubed pins must be used with wet sealant or with lubed collars.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Use HL137 for oversize replacement.

MATERIAL: Type 431 stainless steel per AMS5628 and MIL-S-18732.

HEAT TREAT: 125,000 psi shear minimum.

- FINISH:**
- HL37-(-)(-) = Passivate per Hi-Shear Process Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL37BJ-(-)(-) = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL37D-(-)(-) = Solid film lube per Spec. MIL-L-46010, Type I.
 - HL37PB-(-)(-) = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL37PN-(-)(-) = Cadmium plate per Spec. QQ-P-416, Type II, Class 2.

SPECIFICATION: Hi-Lok Product Specification 342.

**HOW TO ORDER
EXAMPLES:**

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL37 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See finish note for explanation of code letters.

Pin Part Number Only
HL37-8-8

8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HL3787-8-8

Size and grip length, see above example
Collar Part Number
Pin Part Number

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

"Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation

DRAWN	DATE	TITLE
Brleje	11-3-64	HI-LOK® PIN
APPROVED	DATE	100° FLUSH MS24694 TENSION HEAD
Miller	11-3-64	431 STAINLESS STEEL
REVISION	DATE	1/16" GRIP VARIATION - 1/64" OVERSIZE
9	D.P.S. 2-26-92	DRAWING NUMBER HL37