lisi AEROSPACE
hi-shear corporation
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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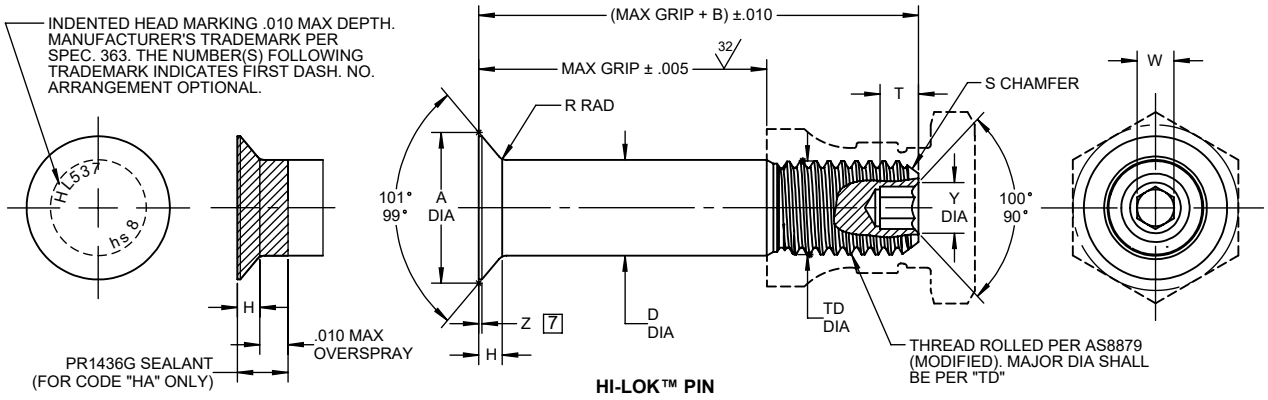
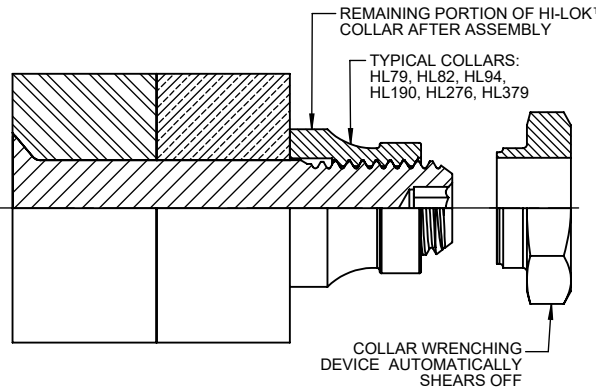


HI-LOK™ PIN



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 WITHOUT COATING OR SOLID FILM	D DIA WITH COATING OR SOLID FILM	TD DIA	F REF	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5							NOTE: USE HL523( )6-( )										
6	13/64	.3536 .3486	.325	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0633 .0612	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.135 .115	.119 .104	6,130	2,590
(13) 7	7/32	.4452 .4378	.355	.2338 .2333	.2338 .2328	.2100 .2070	.005	.0870 .0850	.030 .020	.015	1/32 x 37°	.2160-28 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,160	3,580
8	17/64	.4732 .4682	.395	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0873 .0852	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	10,490	4,760
10	21/64	.5619 .5569	.500	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0983 .0962	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	16,000	7,100
12	25/64	.6912 .6862	.545	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1263 .1242	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	22,700	10,600
14	29/64	.8041 .7969	.635	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1474 .1444	.050 .040	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	30,600	14,450
16	33/64	.9166 .9095	.685	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1685 .1655	.050 .040	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.260 240	.289 .269	39,600	19,550
18	37/64	1.0337 1.0266	.770	.5771 .5766	.5771 .5761	.5550 .5500	.010	.1916 .1886	.050 .040	.025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	49,700	24,700
20	41/64	1.1230 1.1158	.890	.6396 .6391	.6396 .6386	.6180 .6120	.010	.2028 .1998	.050 .040	.025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	61,000	29,600
24	49/64	1.3500 1.3428	1.115	.7646 .7641	.7646 .7636	.7430 .7370	.012	.2456 .2426	.050 .040	.025	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	87,200	42,900

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

DRAWN BY	DATE	TITLE
VAN	1968-06-10	HI-LOK™ PIN 100° FLUSH MS20426 SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED	DATE	
J.M.	1968-06-11	
REVISION	DATE	DRAWING NUMBER
(13)	C. ARTOS 2024-04-11	HL537 1 OF 2

HL537

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⑬ **GENERAL NOTES:**
1. Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .003 FIM.
3. "H" is dimensioned from maximum "D" diameter.
4. Dimensions are in inches and to be met after finish.
5. Surface texture per ASME B46.1.
6. Hole preparation per NAS618.
7. Curved or flat edge manufacturer's option.
8. Maximum "D" diameter may be increased by .0002 to allow for aluminum coating or solid film application.
9. Use HL823 for oversize replacement.

SPECIFICATION: HI-LOK™ Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HL537 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE: Pin Part Number
HL537AZ8-8
- 8/16 or 1/2 Maximum Grip Length
- Replaces 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

MATERIAL: 6Al-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

FINISH:
HL537-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.
HL537AP( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per lube per Hi-Shear Spec. 305.
HL537AZ( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on the thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL537HA( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on the thread end, and apply precoat No. PR1436G sealant (.002-.005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
HL537RA( )-( ) = Phosphate fluoride treat with color code red on the thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL537SY( )-( ) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color code red on the thread end.
HL537GM( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads (no overspray on the shank is allowed) and top of head only (.005 max overspray on the head bearing surface permissible) with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL537AD( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305. Top of head shall be painted in accordance with BAC5684, Type I. No overspray is allowed except in the "Z" land area.
HL537EF( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on top of head only (.005 max overspray on the head bearing surface permissible) with color blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL537NKJ( )-( ) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
HL537NKK( )-( ) = Sulfuric acid anodizing per ISO8080 and HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
HL537NKL( )-( ) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.