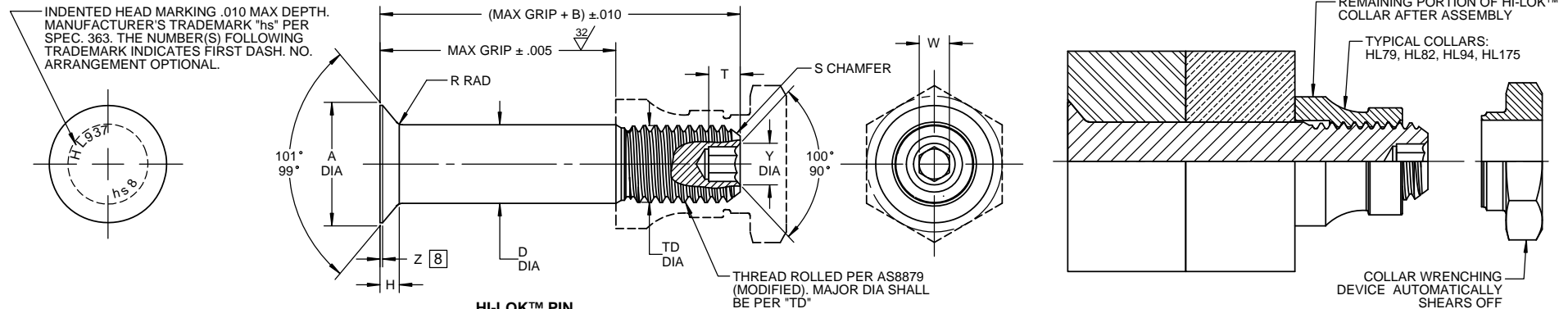


③

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HI-LOK™ PIN

①

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 COATING, PLATING	AFTER COATING, PLATING								W HEX	T DEPTH	Y DIA		
5							NOTE: USE HL701( )6-( )										
6	13/64	.3016 .2966	.325	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0415 .0394	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,100	2,600
8	17/64	.3948 .3898	.395	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0544 .0523	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,800	4,400
10	21/64	.4739 .4689	.500	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0614 .0593	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	21,000	7,000
12	25/64	.5604 .5554	.545	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0714 .0694	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	30,000	10,000
14	29/64	.6680 .6620	.635	.4526 .4521	.4526 .4516	.4310 .4260	.009	.0904 .0879	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	40,300	13,500
16	33/64	.7540 .7480	.685	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1002 .0977	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	52,500	18,000

- GENERAL NOTES:**
- ① Head edge out of roundness shall not exceed "F".
  2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
  3. "H" is dimensioned from maximum "D" diameter.
  - ④ 4. Dimensions are in inches and to be met after finish.
  - ⑤ 5. Surface texture per ASME B46.1.
  6. Hole preparation per NAS618.
  7. Use HL947 for oversize replacement.
  - ⑧ 8. Curved or flat edge manufacturer's option
  - ⑨ 9. After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

**MATERIAL:** Nickel base alloy per AMS5662.

**HEAT TREAT:** 125,000 psi shear minimum (220,000 psi tension minimum).

- FINISH:**
- HL937( )-( ) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - ⑨ HL937AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL937JT( )-( ) = Passivate per Hi-Shear Spec. 258, with light blue identification on top of head, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL937PB( )-( ) = Cadmium plating per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

**SPECIFICATION:** HI-LOK™ Product Specification 342.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HL937 oversize pin replaces.  
 Second dash number indicates maximum grip in 1/16ths.  
 See Finish note for explanation of code letters.

**HOW TO ORDER**  
 ③ **EXAMPLE:**

Pin Part Number  
 HL937AP8-8  
 — 8/16 or 1/2 Maximum Grip Length  
 — Replaces 8/32 or 1/4 Nominal Diameter Pin  
 — Finish Code  
 — Pin Basic Part Number

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

DRAWN BY D.P.S.	DATE 1987-02-03	TITLE HI-LOK™ PIN 100° FLUSH SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED JGWILCOX	DATE 1987-02-04		
REVISION ③	DATE M.BEARD 2017-06-27	DRAWING NUMBER <b>HL937</b>	

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