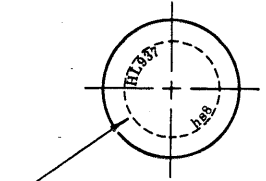


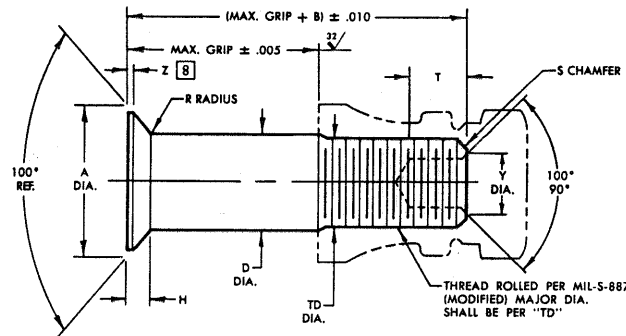
**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2800 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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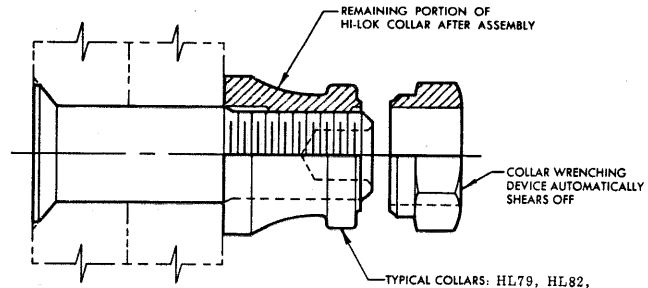
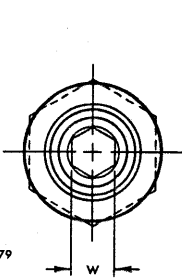
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INDENTED HEAD MARKING MAXIMUM DEPTH .010". Manufacturer's trademark per Hi-Shear Spec. 363. The number(s) following the trademark indicate first dash number. Arrangement optional.



HI-LOK PIN [1] [8]



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

TYPICAL COLLARS: HL79, HL82, HL94, HL175

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM		
				WITHOUT PLATING OR COATING	WITH PLATING OR COATING								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°	10-32UNJF-3A Modified	.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°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	13,500	4,400		
-10	21/64	.4739 .4689	.500	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0614 .0593	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	21,100	7,000		
-12	25/64	.5604 .5554	.545	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0714 .0694	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.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°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	40,300	13,500		
-16	33/64	.7540 ①.7480	.685	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1002 .0977	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	52,200	18,000		

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

- GENERAL NOTES: [1] Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 3. "H" is dimensioned from maximum "D" diameter.
 4. Dimensions to be met after finish.
 5. Surface texture per ANSI B46.1.
 6. Hole preparation per NAS618.
 7. Use HL947 for oversize replacement.
 8. Curved or flat edge manufacturer's option.

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.

- 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.
 HL937AP-()-() = Hi-Kote 1 aluminum 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 plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 342.

HOW TO ORDER EXAMPLES:
 Pin Part Number Only: HL937AP-8-8
 —8/16 or 1/2 Maximum Grip Length
 —Replaces 8/32 or 1/4 Nominal Diameter Pin
 —Pin Part Number with Hi-Kote 1

Pin and Collar Assembly Part Number Combination: HL937AP79-8-8
 —Size and Grip Length, See Above Example
 —Collar Part Number
 —Pin Part Number

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

DRAWN	DATE	
D. P. S.	2-3-87	
APPROVED	DATE	100° FLUSH SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION-1/64" OVERSIZE
<i>J. B. Wilcox</i>	2-4-87	
REVISION	DATE	DRAWING NUMBER
①	D. P. S. 4-9-87	HL937

HL937