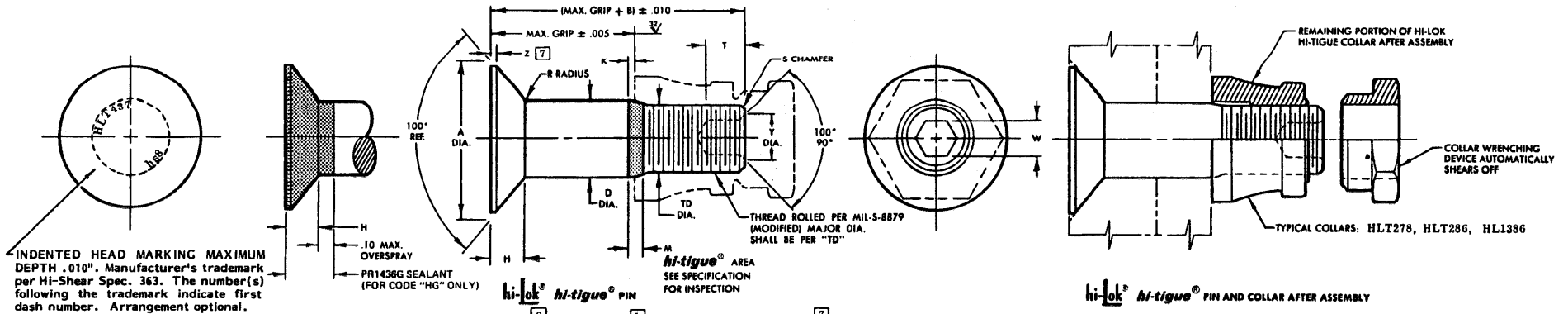


**STANDARDS COMMITTEE FOR
HI-LOK® HI-TIGUE® PRODUCTS**
2800 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197
 Division of Hi-Shear Industries Inc., U.S.A.
 AIR INDUSTRIES CO., INC. (Licensee) U.S. Federal Code I.D. No. 06725
 DEUTSCH FASTENER CO., INC. (Licensee) U.S. Federal Code I.D. No. 97328
 SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 56878
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 WEST COAST AEROSPACE INC., U.S.A. (Licensee) U.S. Federal Code I.D. No. 60516
 Pins & Steel Collars
 HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee)
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee-EEC Countries)
 KAMAX-WERKE, Germany (Licensee-EEC Countries)
 Rudolph Kellermann GmbH & Co. (Licensee-EEC Countries)
 ST. CHAMOND GRANAT, S.A. France (Licensee-EEC Countries)
 SIMMONDS, S.A. France (Licensee-EEC Countries)
 Collars (Licensee-EEC Countries)
 TOKYO SCREW COMPANY, Japan (Licensee-Japan)



FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	F	H	K REF.	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				CETYL ALCOHOL	COATING OR SOLID FILM LUBE									W HEX.	T DEPTH	Y DIA.		
-5																		
NOTE: USE HLT337-G OR HLT453-G																		
-6	13/64	.3813 .3765	.360	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0750 .0730	.020	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	2,750
-8	17/64	.5066 .5018	.435	.2651 .2616	.2651 .2641	.2440 .2410	.006	.1013 .0993	.025	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	5,820
-10	21/64	.6335 .6287	.545	.3276 .3271	.3276 .3266	.3060 .3020	.007	.1283 .1263	.031	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	9,200
-12	25/64	.7604 .7556	.590	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1553 .1533	.037	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	14,000
-14	29/64	.8884 .8812	.690	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1828 .1798	.039	.050 .040	.022	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	18,900
-16	33/64	1.0139 1.0068	.740	.5151 .5146	.5151 .5141	.4930 .4890	.010	.2093 .2063	.045	.050 .040	.022	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	39,600	25,500
-18	37/64	1.1408 1.1337	.825	.5771 .5766	.5771 .5761	.5550 .5500	.010	.2365 .2335	.043	.050 .040	.025	1/16" x 37°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	49,700	32,400
-20	41/64	1.2723 1.2651	.890	.6396 .6391	.6396 .6386	.6190 .6120	.010	.2654 .2624	.045	.050 .040	.025	1/16" x 37°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	61,000	41,000
-24	49/64	1.5308 1.5236	1.115	.7640 .7641	.7648 .7636	.7490 .7370	.012	.3214 .3184	.046	.050 .040	.025	1/16" x 37°	3/4-16UNJF-3A Modified	.3186 .3150	.330 .300	.396 .376	87,200	59,500

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

- 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.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Use HLT687 for oversize replacement.
 - Curved or flat edge manufacturer's option.
 - Maximum "D" diameter may be increased by .0002 to allow for coating application.

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

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

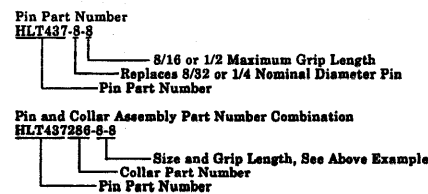
- FINISH:**
- HLT437(-)(-) = Bright clean per Hi-Shear Spec. 211, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT437AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT437BJ(-)(-) = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT437FB(-)(-) = Grit blast top of head and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT437FD(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT437FE(-)(-) = Grit blast top of head, with color red on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT437FU(-)(-) = Grit blast top of head, Hi-Kote 2 solid film lube on threads only per Hi-Shear Spec. 292, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT437HG(-)(-) = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and apply precoat No. PR1436G sealant (.002-.006 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.

- HLT437KM(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT437LL(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT437ST(-)(-) = Grit blast top of head, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT437TA(-)(-) = Ti-Shield IIIA or Tindize Type II, Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HLT437TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 342.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HLT437 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See finish note for explanation of code letters.

HOW TO ORDER EXAMPLES:



"HL", "Hi-Lok", "HLT", and "Hi-Tigue" are internationally registered trademarks of Hi-Shear Corporation.	
DRAWN Var	DATE 3-18-89
APPROVED Lon Miller	DATE 3-19-89
REVISION (15)	DATE D.P.S. 8-12-92
Hi-Lok® Hi-Tigue® PIN 100° FLUSH MS24694 TENSION HEAD TITANIUM 1/16" GRIP VARIATION - 1/64" OVERSIZE HLT437	