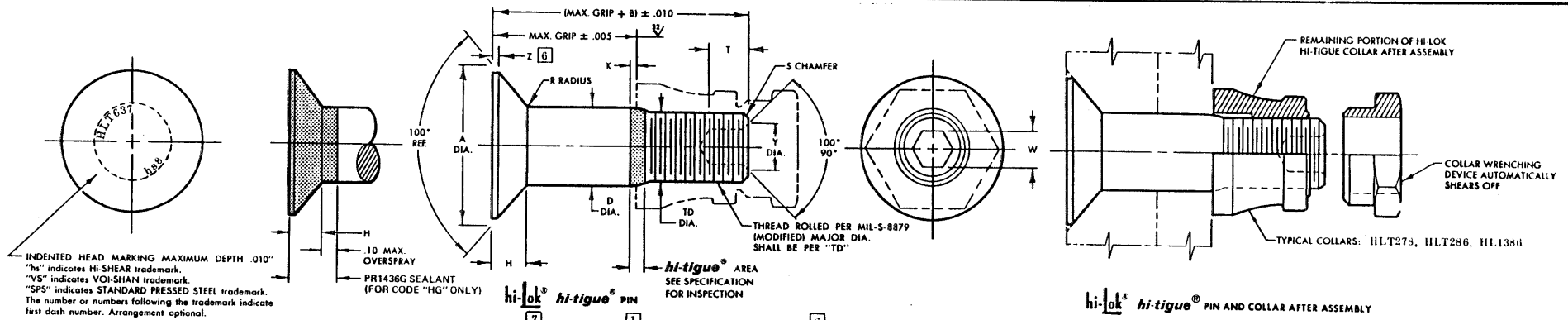


**STANDARDS COMMITTEE FOR
HI-LOK® HI-TIGUE® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION U.S.A. (Patent Holder) U.S. Federal Code 10 No. 72197	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. (Licensee-EEC Countries)
AIR INDUSTRIES CO. INC. (Licensee) U.S. Federal Code 10 No. 06725	RAMAX WERKE Germany (Licensee-EEC Countries)
DEUTSCH FASTENER CO. INC. (Licensee) U.S. Federal Code 10 No. 07923	Stalder Industrie-Handel GmbH & Co.
SPS TECHNOLOGIES U.S.A. (Licensee) U.S. Federal Code 10 No. 36678	ST. CHAMOND GRANAT, S.A. France (Licensee-EEC Countries)
VOI-SHAN Division of VCI Corp. U.S.A. (Licensee) U.S. Federal Code 10 No. 02215	SIMM-HDS S.A. France (Licensee-EEC Countries-Collars)
WEST COAST AEROSPACE INC. U.S.A. (Licensee) U.S. Federal Code 10 No. 00516	Pin & Stud Collars
	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 MAJ.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				CETYL ALCOHOL	COATING OF SOLID FILM LUBE									W HEX.	Y DEPTH	Y DIA.		
-5																		
NOTE: USE HLT337-6 OR HLT453-6																		
-6	7/32	.3813 .3765	.360	.2182 .2172	.2182 .2172	.1840 .1810	.005	.0684 .0664	.022	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,100	2,750
-8	9/32	.5066 .5018	.435	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0948 .0928	.027	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	11,800	5,820
-10	11/32	.6335 .6287	.545	.3432 .3427	.3432 .3422	.3060 .3020	.007	.1218 .1198	.032	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	17,600	9,200
-12	13/32	.7604 .7556	.590	.4057 .4052	.4057 .4047	.3680 .3640	.008	.1488 .1468	.036	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	24,600	14,000
-14	15/32	.8884 .8812	.690	.4682 .4677	.4682 .4672	.4310 .4260	.009	.1763 .1733	.035	.050 .040	.022	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	32,700	18,900
-16	17/32	1.0139 1.0068	.740	.5307 .5302	.5307 .5297	.4930 .4880	.010	.2027 .1997	.045	.050 .040	.022	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	42,000	25,500
-18	19/32	1.1408 1.1337	.825	.5927 .5922	.5927 .5917	.5550 .5500	.010	.2300 .2270	.041	.050 .040	.025	1/16" x 37°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	52,400	32,400
-20	21/32	1.2723 1.2651	.890	.6552 .6547	.6552 .6542	.6180 .6120	.010	.2589 .2559	.045	.050 .040	.025	1/16" x 37°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	64,100	41,000
-24	25/32	1.5308 1.5236	1.115	.7802 .7797	.7802 .7797	.7430 .7370	.012	.3149 .3119	.045	.050 .040	.025	1/16" x 37°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	90,900	69,500

- 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.
 - Curved or flat edge manufacturer's option.
 - Maximum "D" diameter may be increased by .0002 to allow for coating application.
 - Oversize pin for HLT453 and HLT437.

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

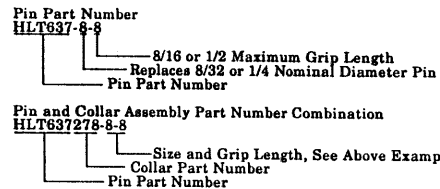
HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

- FINISH:**
- HLT637-()-() = Bright clean per Hi-Shear Spec. 211, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT637AP-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT637BJ-()-() = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT637FB-()-() = Grit blast top of head and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT637FU-()-() = 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.
 - HLT637HG-()-() = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and apply precoat No. PR1436G sealant (.002-.005 thick), 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 HLT637 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See finish note for explanation of code letters.

HOW TO ORDER EXAMPLES:



DRAWN Var		DATE 3-21-69	"HL", "Hi-Lok", "HLT", and "Hi-Tigue" are internationally registered trademarks of Hi-Shear Corporation.	
APPROVED [Signature]		DATE 3-21-69	hi-lok hi-tigue PIN 100° FLUSH MIS24694 TENSION HEAD TITANIUM 1/16" GRIP VARIATION - 1/32" OVERSIZE	
REVISION 13	DATE D.P.S. 8-12-92	DRAWING NUMBER HLT637		