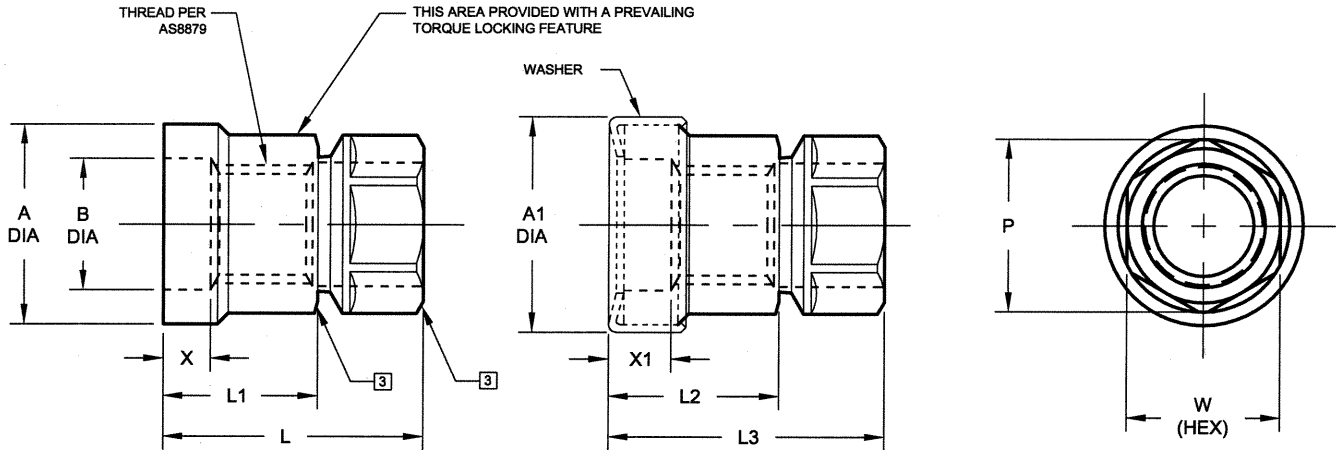


# STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197  
 a GFI AEROSPACE Company  
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725  
 HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928  
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878  
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516  
 (Pins & Steel Collars)

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68  
 a GFI AEROSPACE Company  
 HUCK S.A. France (Licensee - ECC Countries)  
 BLANC AERO S.A. France (Licensee - ECC Countries)  
 a GFI AEROSPACE Company  
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.287 .283	.320	.173 .169	.435 .415	.235	.250	.450	.250	.220 .213	.107	.120	2,300	25-35
6	13/64	10-32UNJF-3B	.307 .303	.340	.212 .208	.450 .430	.250	.265	.465	.280	.251 .244	.107	.120	2,750	30-40
8	17/64	1/4-28UNJF-3B	.412 .408	.440	.276 .272	.550 .530	.300	.315	.565	.350	.314 .302	.112	.125	5,000	80-95
10	21/64	5/16-24UNJF-3B	.518 .512	.550	.340 .334	.670 .650	.370	.385	.685	.420	.377 .365	.122	.135	8,300	150-200
12	25/64	3/8-24UNJF-3B	.628 .622	.660	.403 .397	.740 .720	.410	.425	.755	.490	.439 .425	.122	.135	12,700	260-360
14	29/64	7/16-20UNJF-3B	.735 .725	.775	.466 .460	.930 .910	.560	.575	.935	.573	.505 .490	.137	.150	19,000	390-480
16	33/64	1/2-20UNJF-3B	.850 .840	.895	.528 .522	1.020 1.000	.610	.625	1.025	.643	.565 .550	.137	.150	25,500	640-800

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
  - Dimensions apply after finish.
  - Burrs from cutoff process and cutting torque-off groove allowed.
  - HL1087N( ) collars are for use in special environments; to be lubricated with compatible materials by user.
  - Use HL93 for oversize replacement.

**MATERIAL:** Collar - S30430 (302HQ) stainless steel per ASTM A493, Type XM-7, or 302 or 305 stainless steel per AMS-QQ-S-763 and AMS5686, or 303Se series stainless steel per ASTM A582 (AMS5640).  
 Washer - 300 series stainless steel (.010 thick).  
 2024-T6 aluminum alloy (.020 thick) per AMS-QQ-A-250/4 or AMS-QQ-A-250/5 (sizes -5 through -12 only).

**FINISH:**

HL1087(-) = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL1087D( ) = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and solid film lube per AS5272, Type I.  
 HL1087DU( ) = Collar only with solid film lube per AS5272, Type I.  
 HL1087DUW( ) = Collar finish same as HL1087DU( ), and steel washer with cadmium plate per AMS-QQ-P-416 Type II, Class 2, no lube.  
 HL1087DUWU( ) = Collar finish same as HL1087DU( ), and steel washer passivated per Hi-Shear Spec. 258.  
 HL1087G( ) = Collar only with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL1087GGW( ) = Collar and steel washer both with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL1087MA( ) = Solid film lube per Kalgard RA.  
 [4] HL1087N( ) = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, no lube.  
 HL1087PBW( ) = Collar with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305. Steel washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and no lube.  
 HL1087TW( ) = Collar with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305. Aluminum washer anodize per MIL-A-8625, dye color blue (sizes -5 through -12 only).  
 [16] HL1087Y( ) = Collar only with Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.

**SPECIFICATION:** Hi-Lok Product Specification 345.

**CODE:** Dash number indicates nominal thread size in 1/32nds.  
 See finish note for explanation of code letters.

**EXAMPLE:** HL1087-8 = 1/4-28 Hi-Lok collar with Type II cadmium plate.

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

			TITLE	DRAWING NO.
DATE	BY		<b>HI-LOK® COLLAR</b> STAINLESS STEEL 1/16" GRIP VARIATION, TENSION APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LOK PINS	<b>HL1087</b>
DRAWN	6-26-80	D.P.S.		
APPROVED	8-6-80	JGWilcox		
[16] REVISION	3-23-05	J.F.Obispo		