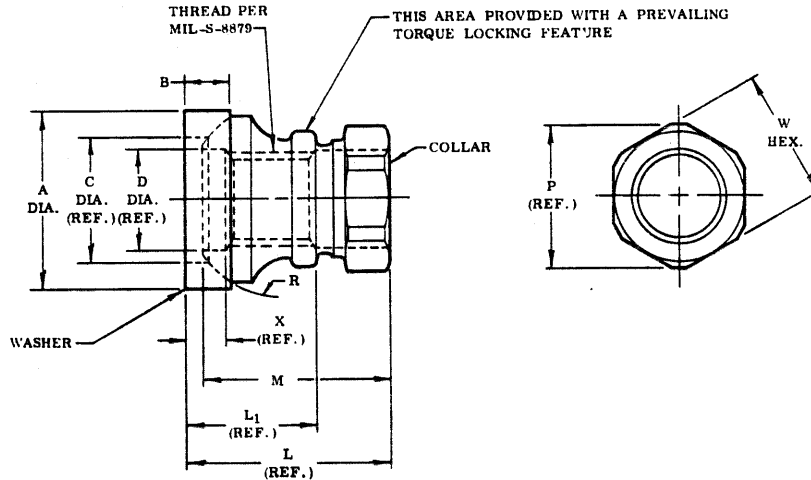


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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. (Licensee)
 AIRCRAFT FASTENERS (Foreign Parts) LTD., U.K. (Licensee)
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee)
 YOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 82215
 SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 56873

ST. CHAMOND-BRANAT, S.A. France (Licensee—EEC Countries)
 KAMAX-WERKE, Germany (Licensee—EEC Countries)
 Rudolph Kellerman GmbH & Co. (Licensee—EEC Countries—Collars)
 SIMMONDS, S.A. France (Licensee—Japan)
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—OverSize Pins & Steel Collars)
 U.S. Federal Code I.D. No. 80918



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B	C DIA. (REF.)	D DIA. (REF.)	L (REF.)	L1 (REF.)	M	P (REF.)	R SPHER. RAD.	W HEX.	X (MAX.)	TENSION PRELOAD POUNDS MIN.	UTS LBS. MIN.	TORQUE OFF IN. LBS.
-5	5/32	8-32UNJC-3B	.365 .355	.095 .085	.235	.184	.445	.272	.420 .400	.344	.20	.314 .302	.115	350	1,400	10-20
-6	3/16	10-32UNJF-3B	.365 .355	.095 .085	.255	.210	.445	.272	.420 .400	.344	.20	.314 .302	.115	500	1,600	20-30
-8	1/4	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.270	.570	.337	.540 .520	.484	.26	.440 .425	.121	1,000	3,000	55-70
-10	5/16	5/16-24UNJF-3B	.620 .610	.130 .120	.417	.333	.690	.427	.647 .627	.557	.34	.503 .488	.133	1,650	5,000	100-125
-12	3/8	3/8-24UNJF-3B	.685 .675	.145 .135	.490	.395	.730	.470	.677 .657	.624	.38	.565 .550	.133	2,300	7,000	170-200
-14	7/16	7/16-20UNJF-3B	.805 .795	.180 .170	.570	.456	.855	.562	.772 .752	.624	.45	.565 .550	.143	3,100	9,500	220-270
-16	1/2	1/2-20UNJF-3B	.915 .905	.205 .195	.649	.518	.925	.604	.842 .822	.763	.51	.690 .675	.146	4,100	12,500	310-370

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions apply after finish.
 3. For use on sloped surfaces up to 7° maximum on standard and 1/64 oversize aluminum alloy HI-Lok pins.

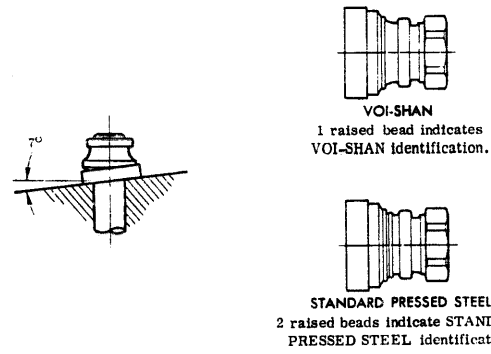
MATERIAL: Collar — 2024 aluminum alloy per QQ-A-430 or QQ-A-225/6.
 Washer — "W" = 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.
 "C" = A-286 high temperature alloy per AMS5731 or AMS5737.

HEAT TREAT: Collar — Age to T6 condition.
 Washer — "W" = Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and 15-7Mo per MIL-H-6875.
 "C" = 90,000 psi shear minimum.

FINISH: Collar — HL182-()A = Anodize per MIL-A-8625, color brown, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL182-()DA = Anodize per MIL-A-8625, color natural, and solid film lube per MIL-L-8937.
 HL182DR-()A = Anodize per MIL-A-8625, color natural, and solid film lube per "DriLube" 702.
 Washer — HL182-()W = Cadmium plate per QQ-P-416, Type I, Class 2.
 HL182-()DW = Solid film lube per MIL-L-8937.
 HL182-()PBC = Cadmium plate per QQ-P-416, Type II, Class 2.
 HL182-()PBW = Cadmium plate per QQ-P-416, Type II, Class 2.

SPECIFICATION: HI-Lok Product Specification 345, except tension preload as tabulated.
 CODE: Dash number indicates nominal thread size in 1/32nds.
 See "Finish" note for explanation of code letters.

EXAMPLE: HL182-8AW = Assembly of HL182-8A collar and HL182-8W washer.
 HL182-8DADW = Assembly of HL182-8DA collar and HL182-8DW washer.
 HL182-8APBW = Assembly of HL182-8A collar and HL182-8PBW washer.
 HL182DR-()APBC = Assembly of HL182DR-()A collar and HL182-()PBC washer.



U.S. patents 3,390,906; and foreign patents. "HI-Lok" and "HL" are Registered Trademarks of HI-Shear Corporation.

DRAWN	DATE	BY
	8-23-66	D. BRLEJ
APPROVED	8-23-66	J. MILLER
REVISION	6-21-85	D. P. S.

TITLE
hi-lok® COLLAR
 SELF-ALIGNING COLLAR ASSEMBLY
 ALUMINUM COLLAR — STAINLESS STEEL WASHER
 1/16" GRIP VARIATION
 FOR USE ON ALUMINUM ALLOY HI-LOK PINS

DRAWING NUMBER
HL182