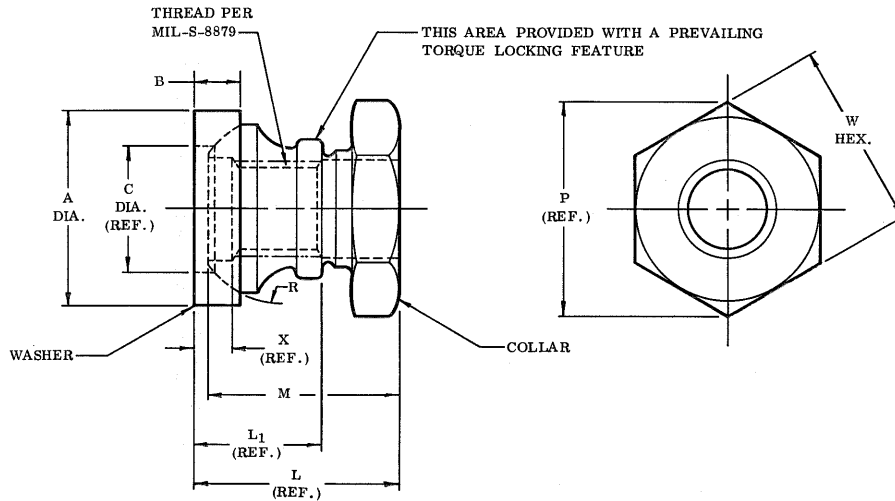


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

① HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197	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.
AIR INDUSTRIES CO., INC. (Licensee) U.S. Federal Code I.D. No. 05725	KAMAX-WERKE, Germany (Licensee-EEC Countries)
DEUTSCH FASTENER CO., INC. (Licensee) U.S. Federal Code I.D. No. 97828	Rudolph Kellerman GmbH & Co.
SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 58878	ST. CHAMOND GÉNÉRAL, S.A. France (Licensee-EEC Countries)
VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 32215	SIMPWONDS, S.A. France (Licensee-EEC Countries-Collars)
WEST COAST AEROSPACE INC., U.S.A. (Licensee) U.S. Federal Code I.D. No. 60516	TOKYO SCREW COMPANY, Japan (Licensee-Japan)
Pin & Steel Collars	



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B	C DIA. (REF.)	L (REF.)	L ₁ (REF.)	M	P (REF.)	R SPHER. RAD.	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE OFF IN. LBS.
-5	5/32"	8-32UNJC-3B	.365 .355	.095 .085	① .255	.455	.280	.420 .400	.420	.20	.378 .365	.107	1,940	22-32
-6	3/16"	10-32UNJF-3B	.365 .355	.095 .085	.255	.455	.280	.420 .400	.420	.20	.378 .365	.107	2,500	32-42
-8	1/4"	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.540	.340	.510 .490	.557	.26	.503 .488	.112	4,300	75-90
-10	5/16"	5/16-24UNJF-3B	.620 .600	.130 .120	.417	.660	.430	.617 .597	.624	.34	.565 .550	.122	6,300	140-170
-12	3/8"	3/8-24UNJF-3B	.685 .675	.145 .135	.490	.730	.470	.677 .657	.700	.38	.628 .613	.122	8,700	210-260
-14	7/16"	7/16-20UNJF-3B	.805 .795	.180 .170	.570	.855	.562	.772 .752	.840	.45	.753 .736	.137	12,100	310-370
-16	1/2"	1/2-20UNJF-3B	.915 .905	.205 .195	.648	.925	.612	.842 .822	.970	.51	.878 .861	.137	15,300	410-470

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. For use on sloped surfaces up to 70° maximum on standard and 1/4" oversize Hi-Lok shear head pins.
3. Dimensions apply after finish.

MATERIAL: Collar - A-286 high temperature alloy per AMS5731, AMS5734 or AMS5736.
Washer - A-286 high temperature alloy per AMS5731 or AMS5737.

HEAT TREAT: Collar - None.
Washer - 90,000 psi shear minimum.

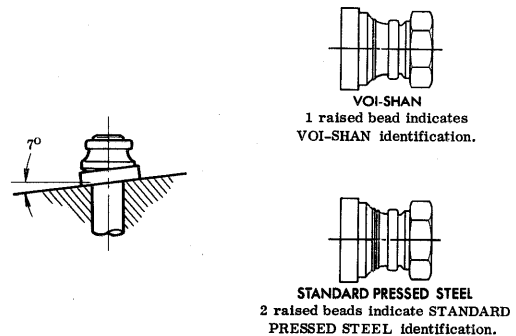
- ① FINISH: Collar - HL185-()A = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL185DU-()A = Solid film lube per MIL-L-46010, Type I.
HL185LP-()A = Solid film lube per MIL-L-46010, Type II.
HL185PB-()A = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL185TF-()A = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
Washer - HL185-()W = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL185-()DW = Solid film lube per MIL-L-46010, Type I.
HL185-()LPW = Solid film lube per MIL-L-46010, Type II.
HL185-()PBW = Cadmium plate per QQ-P-416, Type II, Class 2.
HL185-()WU = Passivate per Hi-Shear Spec. 258.

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: HL185-8AW = Assembly of HL185-8A collar and HL185-8W washer, both with silver plate and cetyl alcohol lube.



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

	DATE	BY
DRAWN	10-4-71	VAN
APPROVED	10-6-71	R. [Signature]
⑧ REVISION	1-7-91	D. P. S.

TITLE
hi-lok® COLLAR

SELF-ALIGNING COLLAR ASSEMBLY
A-286 HIGH TEMPERATURE ALLOY
1/16" GRIP VARIATION - SHEAR APPLICATION

DRAWING NUMBER

HL185