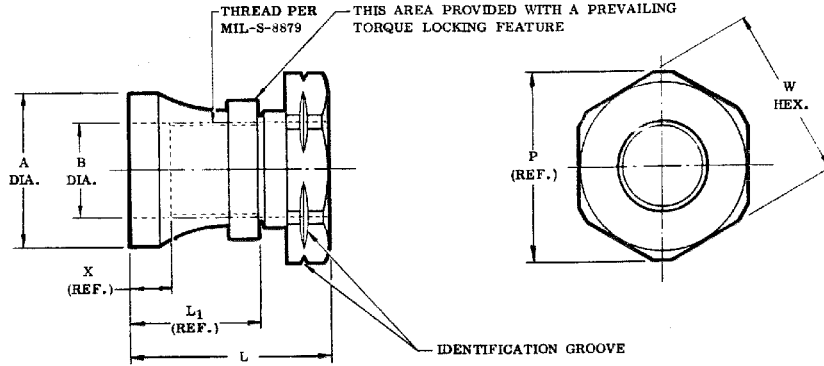


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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 (Forged Parts) LTD., U.K. (Licensee)
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215
 VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 56878
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 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. 60510



DASH NO.	PN NOM. DIA.	THREAD	A DIA.	B DIA.	L LENGTH	L ₁ (REF.)	P (REF.)	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE OFF IN. LBS.
-5	5/32"	8-32UNJC-3B	.292 .238	.173 .166	.447 .427	.270	.344	.314 .302	.107	3,050	30-40
-6	13/64"	10-32UNJF-3B	.322 .318	.212 .208	.457 .437	.280	.380	.346 .332	.107	4,000	40-50
-8	17/64"	1/4-28UNJF-3B	.422 .418	.272 .268	.552 .532	.340	.484	.440 .425	.112	7,500	115-130
-10	21/64"	5/16-24UNJF-3B	.538 .532	.336 .330	.672 .652	.430	.484	.440 .425	.122	11,750	200-250
-12	25/64"	3/8-24UNJF-3B	.648 .642	.398 .392	.744 .724	.470	.557	.503 .488	.122	18,000	360-420
-14	29/64"	7/16-20UNJF-3B	.743 .737	.466 .460	.862 .842	.560	.840	.753 .738	.137	23,750	525-600
-16	33/64"	1/2-20UNJF-3B	.865 .855	.528 .522	.942 .922	.610	.970	.878 .861	.137	30,000	725-825
-18	37/64"	9/16-18UNJF-3B	.915 .905	.598 .592	1.029 1.009	.670	.970	.878 .861	.145	39,000	1000-1150
-20	41/64"	5/8-18UNJF-3B	.985 .985	.661 .655	1.123 1.103	.735	1.120	.753 .986	.145	49,000	1350-1550
-24	49/64"	3/4-16UNJF-3B	1.120 1.110	.786 .780	1.371 1.351	.940	1.240	1.128 1.110	.156	70,000	1900-2200
-28	57/64"	7/8-14UNJF-3B	1.345 1.335	.911 .905	1.575 1.545	1.050	1.520	1.380 1.356	.169	95,000	3200-3600
-32	1-1/64"	1-12UNJF-3B	1.490 1.480	1.036 1.030	1.840 1.810	1.225	1.650	1.504 1.480	.186	124,000	4500-5000

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 2. Dimensions apply after finish.
 3. Use HL273 for oversize replacement.

MATERIAL: 17-4PH stainless steel per Spec. AMS5643.

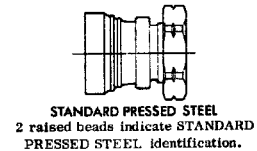
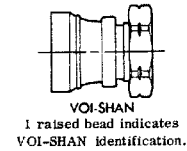
HEAT TREAT: To condition H1025 per MIL-H-6975.

- FINISH: HL273-() = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL273DU-() = Solid film lube per MIL-L-8937.
 HL273DY-() = Solid film lube per MIL-L-8937, and yellow paint on body of collar.
 HL273LP-() = Solid film lube per MIL-L-46010.
 HL273N-() = Diffused nickel-cadmium plating per AMS2416 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL273PB-() = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL273TE-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL273YL-() = Solid film lube per MIL-L-46010 and yellow paint.

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: HL273-8 = 1/4-28 Hi-Lok Collar.



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

			TITLE	DRAWING NUMBER
DRAWN	7-22-63	Martin	hi-Lok® COLLAR 17-4PH STAINLESS STEEL 1/16" GRIP VARIATION - TENSION APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LOK PINS	HL273
APPROVED	7-22-63	M. C.		
REVISION	12-14-64	D. P. S.		
13				