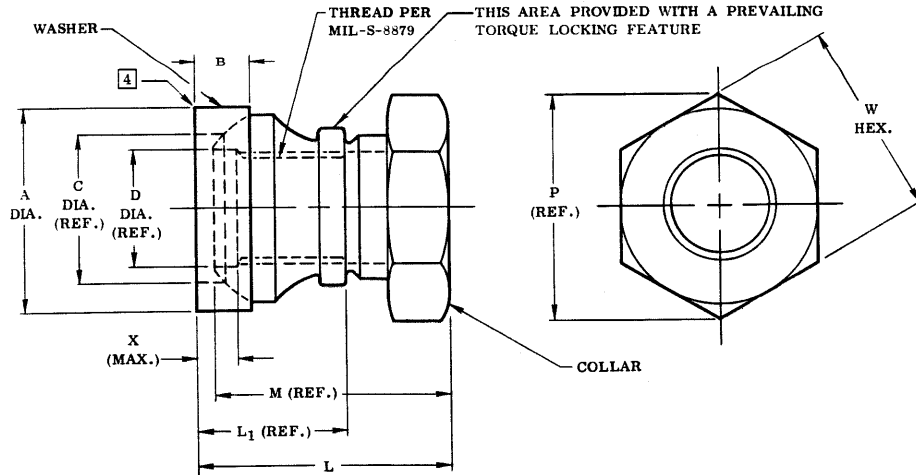


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 Division of Hi-Shear Industries Inc., U.S.A. CAGE No. 06725
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. Canada) CAGE No. 07928
 HLUK INTERNATIONAL, INC., Deutsch Operator, U.S.A. (Licensee) CAGE No. 56878
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 92215
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 80516
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) (Pins & Steel Collars) CAGE No. 80516

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) - CAGE No. CL888
 Division of Hi-Shear Industries Inc., U.S.A.
 HUKK INTERNATIONAL GMBH & CO., Germany (Licensee - EEC Countries)
 SAINT CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
 SIMMONDS S.A., France (Licensee - EEC Countries-Collars)
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B DIA.	C DIA. (REF.)	D DIA. (REF.)	L LENGTH	L ₁ (REF.)	M (REF.)	P (REF.)	W HEX.	X (MAX.)	UTS POUNDS MIN.	TORQUE OFF IN. LBS.
6	3/16	10-32UNJF-3B	.365 .355	.095 .085	.255	.210	.452 .432	.272	.410	.344	.314 .302	.115	2,750	35-45
8	1/4	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.270	.577 .557	.337	.530	.484	.440 .425	.121	5,000	80-95
10	5/16	5/16-24UNJF-3B	.620 .600	.130 .120	.417	.333	.697 .677	.427	.637	.557	.503 .488	.133	8,300	150-200
12	3/8	3/8-24UNJF-3B	.790 .780	.145 .135	.490	.395	.740 .720	.470	.667	.624	.565 .550	.133	12,700	270-330
14	7/16	7/16-20UNJF-3B	.895 .885	.180 .170	.570	.456	.862 .842	.562	.762	.624	.565 .550	.138	19,000	500-575
16	1/2	1/2-20UNJF-3B	1.005 .995	.205 .195	.648	.518	.934 .914	.604	.832	.763	.690 .675	.146	25,500	750-850

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
 - For use on sloped surfaces up to 7° maximum on standard and 1/64 oversize Hi-Lok pins.
 - Dimensions apply after solid film lube.
 - For -12, -14, and -16 washers, chamfer or radius .040-.050.

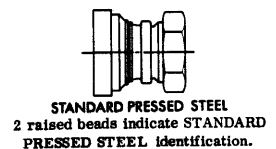
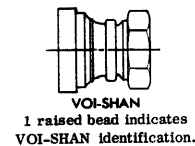
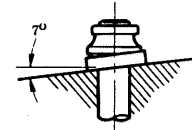
MATERIAL: Collar - 6Al-4V titanium alloy per AMS4928, AMS4967, or AMS4930, or 3Al-2.5V titanium alloy per AMS4943 (MIL-T-9047).
 Washer - 6Al-4V titanium alloy per AMS4928 or AMS4967.

FINISH: Collar - HL280-()A = Surface coating per Hi-Shear Spec. 306, Type II, and solid film lubricant per "Electrofilm" 4396.
 HL280SY-()A = Phosphate fluoride treat per BAC 5861 and solid film lube per MIL-L-46010, Type I.
 Washer - HL280-()W = Surface coating per Hi-Shear Spec. 306, Type II, and solid film lube per "Electrofilm" 4396.

SPECIFICATION: Hi-Lok Product Specification 345.

CODE: Dash number indicates nominal thread size in 1/32nds.
 Code letter "A" following dash number indicates Hi-Lok collar.
 See Finish note for explanation of other code letters.

EXAMPLE: HL280-8AW = Assembly of HL280-8A collar and HL280-8W washer.



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

	DATE	BY	TITLE	DRAWING NUMBER
DRAWN	6-17-70	Van	HI-LOK® COLLAR SELF-ALIGNING COLLAR ASSEMBLY © 6AL-4V OR 3AL-2.5V TITANIUM COLLAR, 6AL-4V TITANIUM WASHER 1/16" GRIP VARIATION, TENSION APPLICATION	HL280
APPROVED	6-23-70	R.Ting		
REVISION	12-8-94	J.F.Obispo		
⑥				