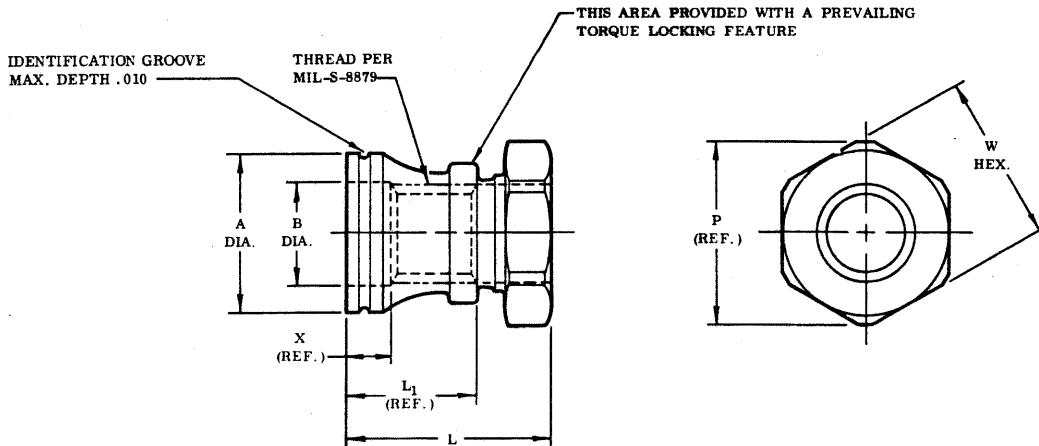


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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.
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. Canada) CAGE No. 06725
 HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 66678
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92216
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60616
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee) CAGE No. 0L868
 Division of Hi-Shear Industries Inc. U.S.A.
 HUCK INTERNATIONAL GMBH & CO., Germany (Licensee - EEC Countries)
 SAINT CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
 BMMONDS S.A., France (Licensee - EEC Countries-Collars)
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



DASH NO.	PIN DIA.	THREAD	A DIA.	B DIA.	L LENGTH	L ₁ (REF)	P (REF.)	W HEX.	X (REF.)	UTS POUNDS MIN.	TORQUE OFF IN. LBS.
5											
					NOTE: Use HL94-6						
6	7/32	10-32UNJF-3B	.332 .328	.227 .223	.470 .450	.290	.380	.346 .332	.122	2,750	25-35
8	9/32	1/4-28UNJF-3B	.427 .423	.290 .286	.565 .545	.355	.484	.440 .425	.127	5,000	60-80
10	11/32	5/16-24UNJF-3B	.548 .542	.356 .350	.685 .665	.445	.484	.440 .425	.137	8,300	130-160
12	13/32	3/8-24UNJF-3B	.658 .652	.419 .413	.755 .735	.485	.557	.503 .488	.137	12,700	200-240
14	15/32	7/16-20UNJF-3B	.775 .765	.481 .475	.862 .842	.565	.970	.878 .861	.152	19,000	270-330
16	17/32	1/2-20UNJF-3B	.880 .870	.543 .537	.942 .922	.615	1.120	1.003 .986	.152	25,500	370-430
18	19/32	9/16-18UNJF-3B	.925 .915	.613 .607	1.060 1.040	.700	1.120	1.003 .986	.165	29,500	500-575
20	21/32	5/8-18UNJF-3B	1.000 .990	.678 .672	1.145 1.125	.755	1.120	1.003 .986	.165	32,000	625-750
24	25/32	3/4-16UNJF-3B	1.185 1.175	.803 .797	1.415 1.385	.975	1.240	1.128 1.110	.175	42,000	900-1000
28	29/32	7/8-14UNJF-3B	1.360 1.350	.924 .918	1.615 1.585	1.100	1.520	1.380 1.356	.190	62,000	1200-1325
32	1-1/32	1-12UNJF-3B	1.530 1.520	1.055 1.045	1.915 1.885	1.300	1.650	1.504 1.480	.210	84,000	1450-1600

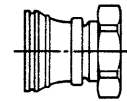
- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions apply after finish.
 3. Use HL394 for oversize replacement.

- Ⓞ MATERIAL: Collar - Type 303 Se stainless steel per ASTM A582.
- Ⓞ FINISH: HL294-() = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL294D-() = Cadmium plate per QQ-P-416, Type II, Class 2, and solid film lubricant per MIL-L-46010, Type I.
 HL294DU-() = Solid film lube per MIL-L-46010, Type I.

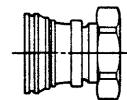
SPECIFICATION: Hi-Lok Product Specification 345.

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

EXAMPLE: HL294-8 = 1/4-28 Hi-Lok oversize collar with Type II cadmium plate.



VOI-SHAN
1 raised bead indicates
VOI-SHAN identification.



STANDARD PRESSED STEEL
2 raised beads indicate STANDARD
PRESSED STEEL identification.

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	5-11-70	Van	HI-LOK® COLLAR TYPE 303 Se STAINLESS STEEL 1/16" GRIP VARIATION - SHEAR APPLICATION FOR USE ON 1/32" OVERSIZE HI-LOK PINS	HL294
APPROVED	5-21-70	R.Ting		
⑥ REVISION	09-08-94	J.F.Obispo		