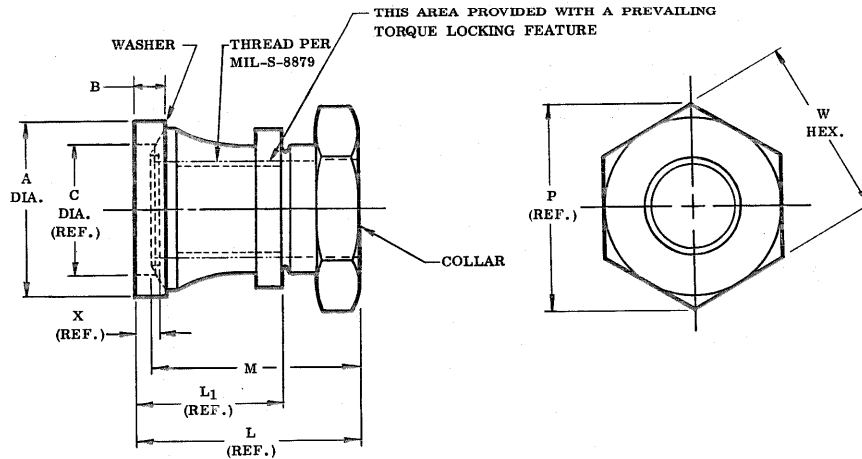


**STANDARDS COMMITTEE  
FOR HI-LOK® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73157  
 Division of HI-Shear Industries Inc., U.S.A.  
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)  
 Division of HI-Shear Industries Inc., U.S.A.  
 VOI-SHAN, Division of VOI 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. 56676

ST. CHAMOND-GRAMAT, S.A. France (Licensee—EEC Countries)  
 NAWAK-WERKE, Germany (Licensee—EEC Countries)  
 Rudolph Reiterman GmbH & Co.  
 SIMMONDS, S.A. France (Licensee—EEC Countries—Collars)  
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Sheet Collars)  
 U.S. Federal Code I.D. No. 60516



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B	C DIA. (REF.)	L (REF.)	L1 (REF.)	M	P (REF.)	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE-OFF IN.-LBS.
-6	3/16"	10-32UNJF-3B	.365 .355	.095 .085	.255	.455	.280	.420 .400	.420	.378 .365	.107	2,500	32-42
-8	1/4"	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.540	.340	.510 .490	.557	.503 .488	.112	4,300	75-90
-10	5/16"	5/16-24UNJF-3B	.620 .610	.130 .120	.417	.660	.430	.617 .597	.624	.565 .550	.122	6,300	140-170
-12	3/8"	3/8-24UNJF-3B	.685 .675	.145 .135	.490	.730	.470	.677 .657	.700	.628 .613	.122	8,700	220-260
-14	7/16"	7/16-20UNJF-3B	.805 .795	.180 .170	.570	.855	.562	.772 .752	.840	.753 .736	.137	12,100	310-370
-16	1/2"	1/2-20UNJF-3B	.915 .905	.205 .195	.648	.925	.612	.842 .822	.970	.878 .861	.137	15,300	410-470

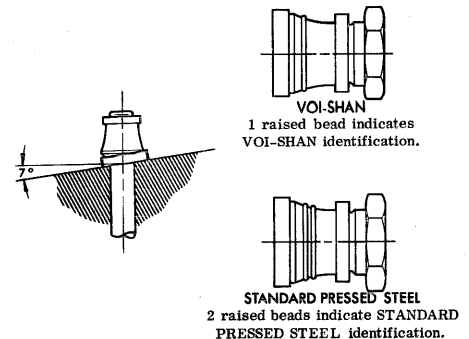
- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.  
 2. Dimensions apply after finish.  
 3. For use on sloped surfaces up to 7° maximum on standard and 1/64 oversize Hi-Lok shear head pins.

MATERIAL: Collar — A-286 high temperature alloy per AMS5731, AMS5734 or AMS5736.  
 Washer — 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

HEAT TREAT: Collar — None.  
 Washer — Age to H1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and 15-7Mo per MIL-H-6875.

- FINISH: Collar — HL297-( )A = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL297-( )DUA = Solid film lube per MIL-L-8937 plus yellow MIL-P-23377 identification on body of collar.  
 HL297-( )KA = Solid film lube per "Lubeco" 905.  
 HL297-( )PBA = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL297-( )TFA = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.  
 HL297-( )VA = Solid film lube per "Lubeco" 2123.  
 Washer — HL297-( )GW = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL297-( )KW = Solid film lube per "Lubeco" 905.  
 HL297-( )PBW = Cadmium plate per QQ-P-416, Type II, Class 2.  
 HL297-( )VW = Solid film lube per "Lubeco" 2123.  
 HL297-( )WU = No finish.

SPECIFICATION: Hi-Lok Product Specification 345.  
 CODE: Dash number indicates nominal thread size in 1/32nds.  
 See the "Finish" note for explanation of code letters.  
 EXAMPLE: HL297-8AWU = Assembly of HL297-8A collar and HL297-8WU washer.



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

	DATE	BY
DRAWN	5-10-66	BRLEJ
APPROVED	5-10-66	Jm
13 REVISION	7-10-85	D. P. S.

TITLE  
**hi-Lok COLLAR**  
 SELF-ALIGNING COLLAR ASSEMBLY  
 (A-286 COLLAR, 17-4 WASHER)  
 1/16" GRIP VARIATION — SHEAR APPLICATION

DRAWING NUMBER

**HL297**