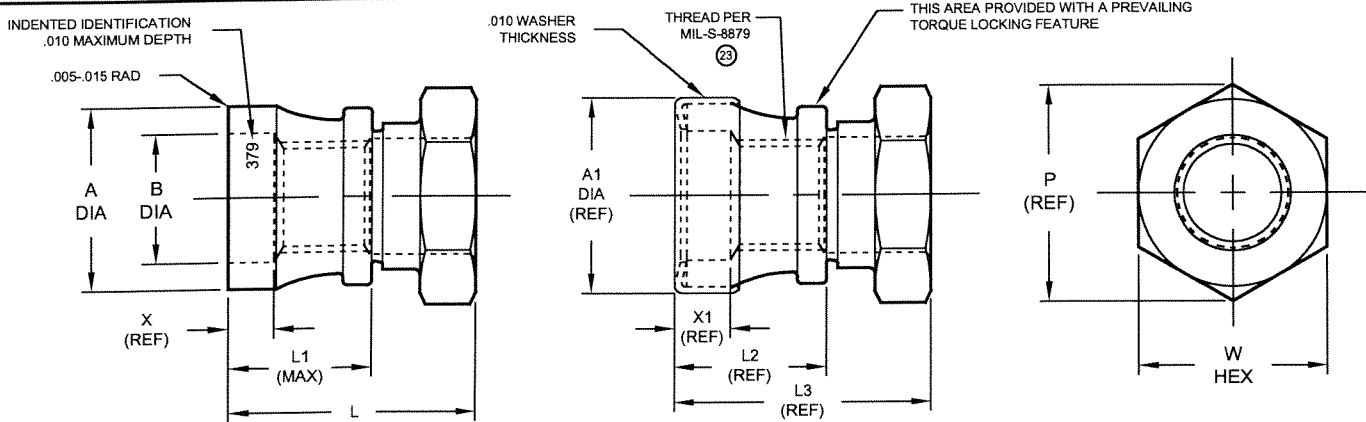


# STANDARDS COMMITTEE FOR HI-LOK<sup>®</sup> PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197  
 a GFI AEROSPACE Company  
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725  
 HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928  
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878  
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516  
 (Pins & Steel Collars)

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68  
 a GFI AEROSPACE Company  
 HUCK S.A. France (Licensee - ECC Countries)  
 BLANC AERO S.A. France (Licensee - ECC Countries)  
 a GFI AEROSPACE Company  
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L	L1 (MAX)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.287 .283	.325	.173 .166	.447 .427	.272	.290	.460	.344	.314 .302	.107	.125	2,300	15-25
6	3/16	10-32UNJF-3B	.307 .303	.345	.212 .208	.457 .437	.292	.295	.470	.344	.314 .302	.107	.125	2,750	22-32
8	1/4	1/4-28UNJF-3B	.412 .408	.450	.272 .268	.552 .532	.347	.360	.565	.484	.440 .425	.112	.130	5,000	50-70
10	5/16	5/16-24UNJF-3B	.518 .512	.560	.336 .330	.672 .652	.437	.460	.685	.624	.565 .550	.122	.145	8,300	80-110
12	3/8	3/8-24UNJF-3B	.620 .614	.670	.398 .392	.744 .724	.479	.500	.760	.700	.628 .613	.122	.150	12,700	140-180

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
  - Dimensions apply after finish.

**MATERIAL:** Collar - 6Al-4V titanium alloy per AMS4928, AMS4930 or AMS4967, or 3Al-2.5V titanium alloy per AMS4943 (MIL-T-9047).  
 Washer - 300 series stainless steel.

**FINISH:** Collar - HL379-() = Surface coating per Hi-Shear Spec. 306, Type II and general purpose solid film lube.  
 HL379DL() = Solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL379EG() = Solid film lubricant per Everlube 620C.  
 HL379TA() = Pretreat per Hi-Shear Ti-Shield III, Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL379V() = Pretreat Ticermet B and solid film lubricant per Lubeco 2123, Type II.  
 Collar & Washer - HL379VW() = Both with solid film lube per Lubeco 2123, Type II.  
 HL379W() = Collar finish same as HL379-() and washer is passivate.

**SPECIFICATION:** Hi-Lok Product Specification 345. Use shear collar tension preload requirements.  
**CODE:** Dash number indicates nominal thread size in 1/32nds. See Finish note for explanation of code letters.

**EXAMPLES:** HL379V8 = 1/4-28 Hi-Lok collar, finish is Lubeco 2123.  
 HL379VW8 = 1/4-28 Hi-Lok collar and washer, finish is Lubeco 2123 on both collar and washer.

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

	DATE	BY	TITLE	DRAWING NO.
DRAWN	1-20-67	Shrode	<b>HI-LOK<sup>®</sup> COLLAR</b> TITANIUM ALLOY 1/16" GRIP VARIATION, SPECIAL APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LOK PINS	<b>HL379</b>
APPROVED	1-24-67	J.Miller		
REVISION	8-20-01	J.F.Obispo		
(23)				