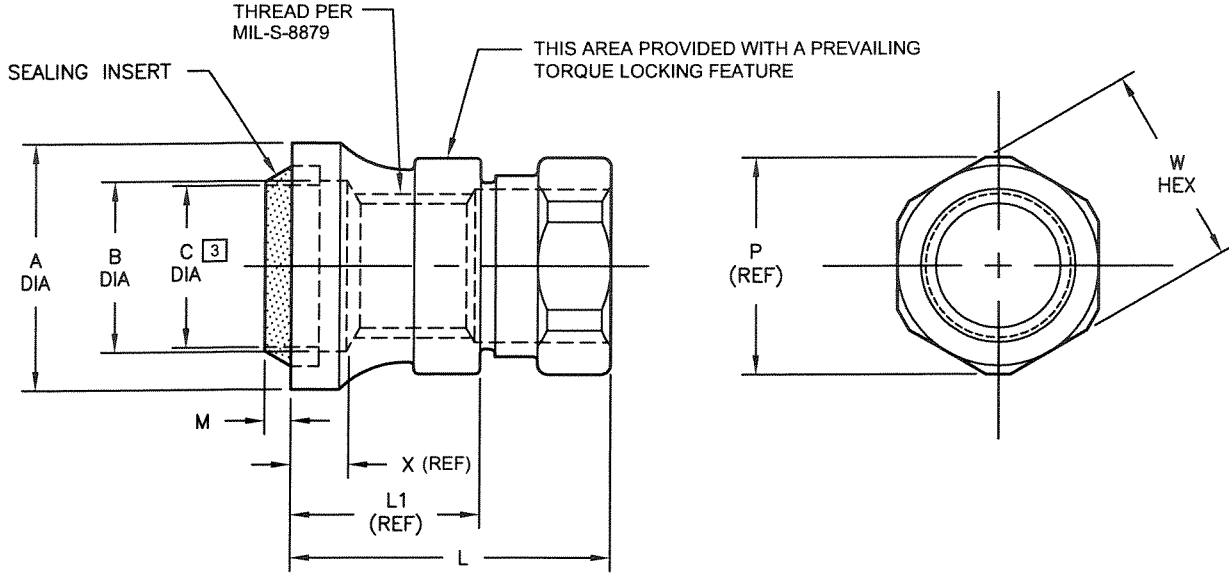


# STANDARDS COMMITTEE FOR HI-LOK<sup>®</sup> PRODUCTS

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. 58878  
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 82215  
 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	B DIA	C DIA MIN	L	L1 (REF)	M MAX	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.352 .348	.173 .169	.164	.447 .427	.265	.045	.344	.314 .302	.107	1,400	15-25
6	3/16	10-32UNJF-3B	.388 .384	.212 .208	.188	.457 .437	.275	.045	.344	.314 .302	.107	1,600	25-35
8	1/4	1/4-28UNJF-3B	.509 .505	.272 .268	.248	.552 .532	.340	.055	.380	.346 .332	.112	3,000	60-80
10	5/16	5/16-24UNJF-3B	.636 .630	.366 .330	.310	.672 .652	.430	.055	.484	.440 .425	.122	5,000	130-160
12	3/8	3/8-24UNJF-3B	.720 .714	.398 .392	.372	.744 .724	.475	.060	.557	.503 .488	.122	7,000	200-240
14	7/16	7/16-20UNJF-3B	.861 .855	.463 .457	.435	.862 .842	.560	.060	.624	.565 .550	.137	9,500	270-330
16	1/2	1/2-20UNJF-3B	.990 .982	.528 .522	.498	.942 .922	.610	.060	.763	.690 .675	.137	12,500	370-430

- ② NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.  
 2. Dimensions to be met after finish.  
 ③ "C" diameter is the inner diameter of the Teflon insert.

MATERIAL: Collar - 2024 aluminum alloy per AMS-QQ-A-430 or AMS-QQ-A-225/6.  
 Insert - Teflon per ASTM-D-1710.

HEAT TREAT: Collar - Age to T6 condition per AMS2772.

FINISH: Collar - Anodize per AMS-A-8625, dye color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 Insert - None.

SPECIFICATION: Hi-Lok Product Specification 345.

CODE: Dash number indicates nominal thread size in 1/32nds.

EXAMPLE: HL384-8 = 1/4-28 Hi-Lok sealing collar with Teflon insert.

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

			TITLE	DRAWING NO.
DATE	BY		<b>HI-LOK<sup>®</sup> COLLAR (SEALING TYPE)</b>  2024-T6 ALUMINUM ALLOY 1/16" GRIP VARIATION, SHEAR APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LOK PINS	<b>HL384</b>
DRAWN	VAN			
APPROVED	R. TING			
② REVISION	S.KIM	4-10-02		