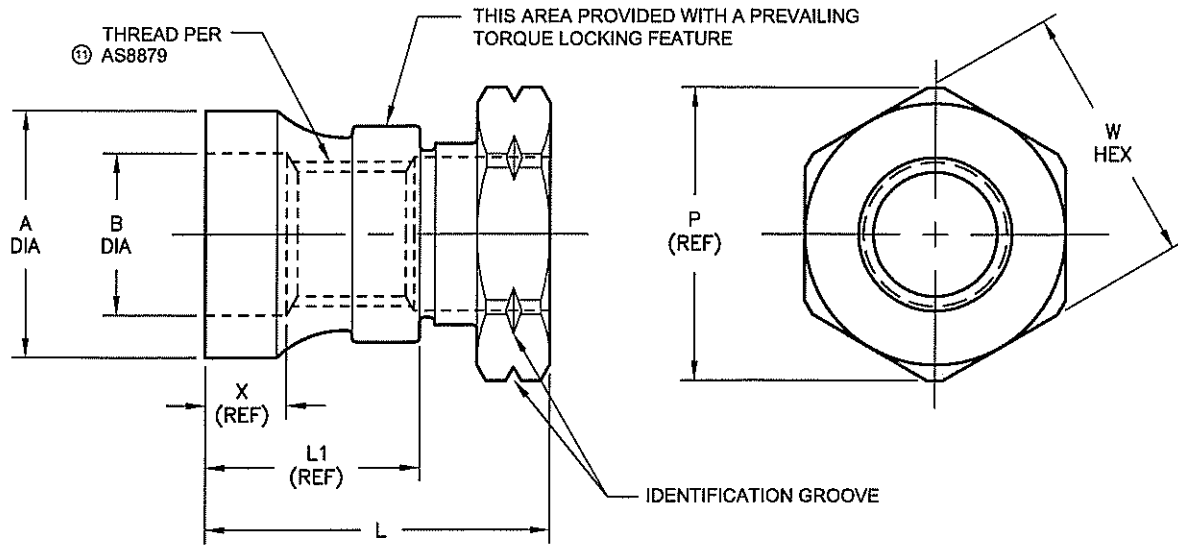


# STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197  
 a LISI 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. 97626  
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 59378  
 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. CLB66  
 a LISI AEROSPACE Company  
 HUCK S.A. France (Licensee - ECC Countries)  
 BLANC AERO S.A. France (Licensee - ECC Countries)  
 a LISI AEROSPACE Company  
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN
5MC	5/32	8-32UNJC-3B	.287 .283	.179 .175	.385 .365	.255	.280	.254 .244	.118	1,400
6MC	3/16	10-32UNJF-3B	.307 .303	.205 .201	.395 .375	.265	.320	.285 .274	.118	1,600
8MC	1/4	1/4-28UNJF-3B	.412 .408	.265 .261	.490 .470	.335	.380	.346 .332	.127	3,000
10MC	5/16	5/16-24UNJF-3B	.518 .512	.330 .324	.590 .570	.410	.484	.440 .425	.139	5,000
12MC	3/8	3/8-24UNJF-3B	.628 .622	.393 .387	.660 .640	.465	.557	.503 .488	.139	7,000
14MC	7/16	7/16-20UNJF-3B	.713 .707	.456 .450	.862 .842	.560	.715	.627 .615	.157	9,500
16MC	1/2	1/2-20UNJF-3B	.815 .809	.519 .513	.942 .922	.610	.763	.690 .675	.157	12,500

- NOTES: 1. Dimensions apply after finish.  
 2. Use TB32VTB test bolts for lot acceptance tests.

MATERIAL: 2024 aluminum alloy per QQ-A-430 or AMS-QQ-A225/6.

HEAT TREAT: Age to T6 condition per AMS-H-6088.

FINISH: HL570-( JMC = Anodize per AMS-A-8625, dye color orange, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Boeing Specification 23M117.

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

EXAMPLE: HL570-8MC = 1/4-28 Hi-Lok Collar.

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

			TITLE	DRAWING NO.
DRAWN	3-22-71	Van	<b>HI-LOK® COLLAR</b> 2024-T6 ALUMINUM ALLOY 1/16" GRIP VARIATION, SHEAR APPLICATION (SPECIAL FOR BOEING ST. LOUIS)	<b>HL570</b>
APPROVED	3-22-71	R.Ting		
REVISION	5-28-2003	J.F.Obispo		
(11)				