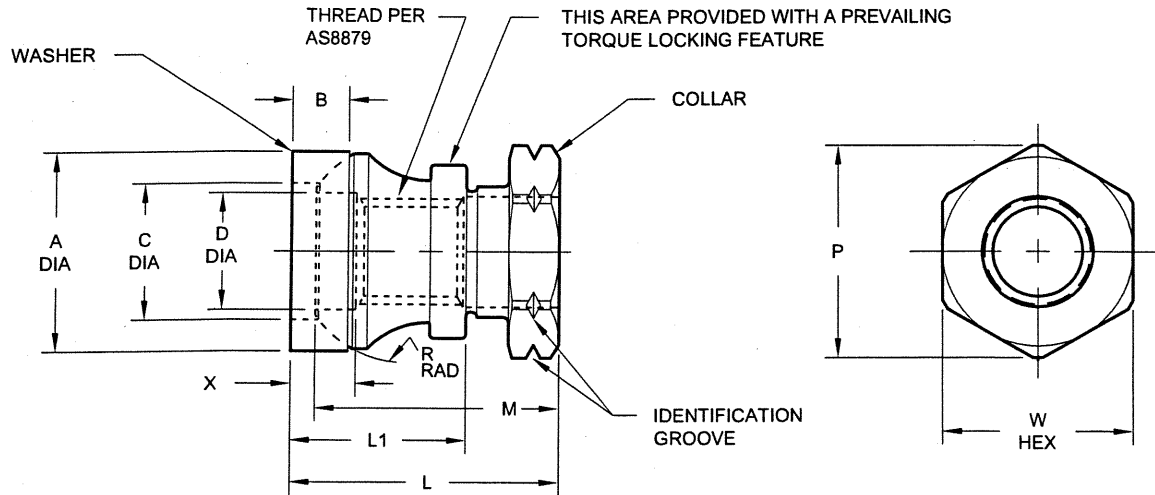


# STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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. 97528  
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56678  
 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 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	C DIA (REF)	D DIA	L	L1 (REF)	M (REF)	P (REF)	R SPHER. RAD	W HEX	X (REF)	UTS LBS. MIN
5MC	5/32	8-32UNJC-3B	.365 .355	.095 .085	.255	.186 .182	.385 .365	.255	.340	.280	.20	.254 .244	.118	1,400
6MC	3/16	10-32UNJF-3B	.365 .355	.095 .085	.255	.212 .208	.395 .375	.265	.350	.320	.20	.285 .274	.118	1,600
8MC	1/4	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.272 .268	.490 .470	.335	.435	.380	.26	.346 .332	.127	3,000
10MC	5/16	5/16-24UNJF-3B	.620 .610	.130 .120	.417	.335 .331	.590 .570	.410	.525	.484	.34	.440 .425	.139	5,000
12MC	3/8	3/8-24UNJF-3B	.685 .675	.145 .135	.490	.398 .392	.660 .640	.465	.580	.557	.38	.503 .488	.139	7,000
14MC	7/16	7/16-20UNJF-3B	.895 .885	.180 .170	.570	.459 .453	.865 .840	.560	.762	.715	.45	.627 .615	.157	9,500
16MC	1/2	1/2-20UNJF-3B	1.005 .995	.205 .195	.648	.521 .515	.940 .910	.610	.832	.763	.51	.690 .675	.157	12,500

- NOTES:**
1. For use on sloped surfaces up to 8° maximum on standard Hi-Lok pins.
  2. Dimensions apply after finish.
  3. Use TB32VTB test pins for lot acceptance tests.

**MATERIAL:** Collar - 2024 aluminum alloy per QQ-A-430 or AMS-QQ-A-225/6.  
 Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

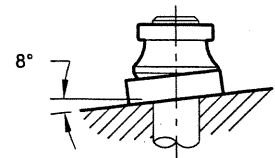
**HEAT TREAT:** Collar - Age to T6 condition per AMS-H-6088. ①  
 Washer - Age to H1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per AMS-H-6875.

**FINISH:** Collar - HL582-( )MCA = Anodize per AMS-A-8625, Type II, Class 2, dye color orange, and cetyl alcohol lube per Hi-Shear Spec. 305.

Washer - HL582-( )W = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.

**SPECIFICATION:** Boeing Specification 23M117.

**CODE:** Dash number indicates nominal thread size in 1/32nds.  
 Code letter "A" following dash number and letters "MC" indicates Hi-Lok self-aligning collar.  
 See "Finish" note for explanation of code letters.



**EXAMPLE:** HL582-8MCAW = Assembly of HL582-8MCA collar and HL582-8W washer.

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

			TITLE	DRAWING NO.
DRAWN	DATE	BY	<b>HI-LOK® COLLAR</b> SELF-ALIGNING COLLAR ASSEMBLY (ALUMINUM COLLAR AND STAINLESS STEEL WASHER) 1/16" GRIP VARIATION, SHEAR APPLICATION (SPECIAL FOR BOEING ST. LOUIS)	<b>HL582</b>
APPROVED	7-14-71	VAN		
	7-15-71	R.Ting		
① REVISION	1-13-2004	J.F.Obispo		