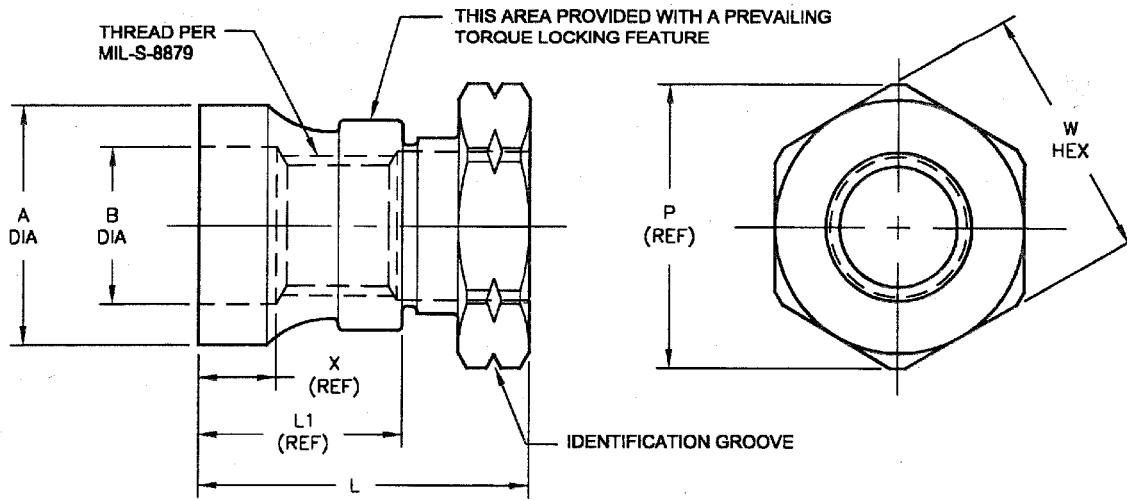


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 a GFI AEROSPACE Company
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada) CAGE No. 08725
 HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 87928
 SP8 TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 58873
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 82215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 80516
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0LB65
 a GFI AEROSPACE Company
 HUCK S.A. France (Licensee - EEC Countries)
 BLANC AERO S.A. France (Licensee - EEC Countries)
 a GFI 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	TORQUE-OFF INCH-POUNDS
5	5/32										
NOTE: For -5 diameter pin, use HL70-5.											
6	13/64	10-32UNJF-3B	.322 .318	.212 .208	.457 .437	.280	.380	.348 .332	.107	1,600	25-35
8	17/64	1/4-28UNJF-3B	.422 .418	.272 .268	.552 .532	.340	.484	.440 .425	.112	3,000	60-80
10	21/64	5/16-24UNJF-3B	.538 .532	.336 .330	.672 .652	.430	.484	.440 .425	.122	5,000	130-160
12	25/64	3/8-24UNJF-3B	.649 .642	.388 .392	.744 .724	.470	.557	.503 .488	.122	7,000	200-240
14	29/64	7/16-20UNJF-3B	.743 .737	.463 .457	.862 .842	.565	.624	.565 .550	.137	9,500	270-330
16	33/64	1/2-20UNJF-3B	.865 .855	.528 .522	.942 .922	.615	.763	.690 .675	.137	12,500	370-430
18	37/64	9/16-18UNJF-3B	.880 .870	.568 .592	1.029 1.009	.670	.970	.878 .861	.145	14,500	500-575
20	41/64	5/8-18UNJF-3B	1.005 .995	.661 .655	1.123 1.103	.735	1.120	1.003 .986	.145	18,000	625-700
24	49/64	3/4-16UNJF-3B	1.105 1.095	.786 .780	1.370 1.351	.940	1.240	1.128 1.110	.156	27,500	900-1000
28	57/64	7/8-14UNJF-3B	1.295 1.285	.911 .905	1.575 1.545	1.060	1.450	1.315 1.292	.169	37,500	1200-1325
32	1-1/64	1-12UNJF-3B	1.475 1.465	1.036 1.030	1.840 1.810	1.225	1.650	1.504 1.480	.186	50,000	1450-1600

- NOTES:
- Go thread gage penetration shall be 3/4 of one revolution minimum.
 - Dimensions apply after finish.
 - Use HL84 for oversize replacement.

MATERIAL: 2024 aluminum alloy per QQ-A-430 or QQ-A-225/6.

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

FINISH: HL79() = Anodize per MIL-A-8625, dye color red, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL79D() = Anodize per MIL-A-8625 and solid film lube per AS5272, Type I.
 HL79GG() = Anodize per MIL-A-8625, dye color green, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HK79K() = Anodize per MIL-A-8625 and Lubeco 905 solid film lube.

SPECIFICATION: Hi-Lok Product Specification 345.

CODE: Dash number indicates nominal thread size in 1/32nds.
 See "Finish" note for explanation of code letters.

EXAMPLE: HL79-8 = 1/4-28 Hi-Lok Collar with cetyl alcohol lube.

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

	DATE	BY
DRAWN	11-31-60	R.K.L.
APPROVED	11-31-60	M.C.
REVISION	9-23-99	J.F.Obispo

TITLE
HI-LOK® COLLAR
 2024-T6 ALUMINUM ALLOY
 1/16" GRIP VARIATION, SHEAR APPLICATION
 FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LOK PINS

DRAWING NO.
HL79