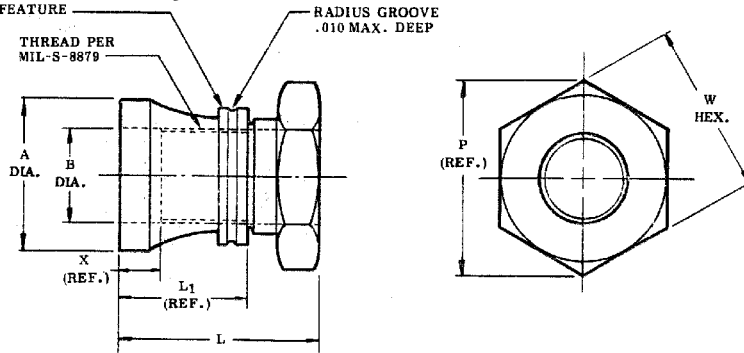


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

| | |
|--|---|
| HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code 19, No. 73197 | HI-SHEAR FASTENERS EUROPE, LTD. U.K. (Licensor) |
| Division of Hi-Shear Industries Inc. U.S.A. | Division of Hi-Shear Industries Inc. U.S.A. |
| AIR INDUSTRIES CO., INC. (Licensor) U.S. Federal Code 19, No. 96725 | KAMAX-WERKE Germany (Licensor—EEC Countries) |
| DEUTSCH FACTORY CO., INC. (Licensor) U.S. Federal Code 19, No. 97326 | Technische Industrie GmbH & Co. |
| EPS TECHNOLOGIES, U.S.A. (Licensor) U.S. Federal Code 19, No. 69678 | ST. CHAMONDY GRANAT, S.A. France (Licensor—EEC Countries) |
| VOI-SHAN, Division of VSI Corp., U.S.A. (Licensor) U.S. Federal Code 19, No. 82218 | SHIMBROS, S.A. France (Licensor—EEC Countries—Canada) |
| WEST COAST BENCHSPACE INC., U.S.A. (Licensor) U.S. Federal Code 19, No. 96518 | TOKYO GCREW COMPANY, Japan (Licensor—Japan) |
| Pin & Steel Collar | |

THIS AREA PROVIDED WITH A PREVAILING TORQUE LOCKING FEATURE



| DASH NO. | PIN NOM. DIA. | THREAD | A DIA. | B DIA. | L | L1 (REF.) | P (REF.) | W HEX. | X (REF.) | UTS LBS. MIN. | TORQUE OFF IN. LBS. |
|----------|---------------|----------------|----------------|--------------|----------------|-----------|----------|----------------|----------|---------------|---------------------|
| -5 | 5/32" | 8-32UNJC-3B | .287 .283 | .173 .166 | .447 .427 | .265 | .344 | .314 .302 | .107 | 2,300 | 30-40 |
| -6 | 3/16" | 10-32UNJF-3B | .307 .303 | .200 .192 | .437 .437 | .275 | .344 | .314 .302 | .107 | 2,750 | 40-50 |
| -8 | 1/4" | 1/4-28UNJF-3B | .412 .408 | .261 .252 | .552 .532 | .340 | .380 | .346 .332 | .112 | 5,000 | 115-130 |
| -10 | 5/16" | 5/16-24UNJF-3B | .518 .512 | .325 .314 | .672 .652 | .430 | .494 | .440 .425 | .122 | 8,300 | 200-250 |
| -12 | 3/8" | 3/8-24UNJF-3B | .628 .622 | .388 .376 | .744 .724 | .475 | .557 | .503 .498 | .122 | 12,700 | 360-420 |
| -14 | 7/16" | 7/16-20UNJF-3B | .733 .727 | .463 .442 | .862 .842 | .560 | .840 | .753 .736 | .137 | 19,000 | 525-675 |
| -16 | 1/2" | 1/2-20UNJF-3B | .848 .842 | .528 .501 | .942 .922 | .610 | .970 | .878 .861 | .137 | 25,500 | 725-1000 |
| -18 | 9/16" | 9/16-18UNJF-3B | .915 .905 | .598 .570 | 1.029 1.009 | .670 | .970 | .878 .861 | .145 | 29,000 | 1000-1150 |
| -20 | 5/8" | 5/8-18UNJF-3B | .985 .985 | .661 .634 | 1.123 1.103 | .735 | 1.120 | 1.003 .986 | .145 | 32,000 | 1350-1550 |
| -24 | 3/4" | 3/4-16UNJF-3B | 1.120 1.110 | .786 .762 | 1.371 1.351 | .940 | 1.240 | 1.128 1.110 | .156 | 42,000 | 1900-2200 |

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. Dimensions apply after finish.
3. Use HL93FN for oversize replacement.

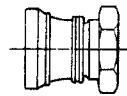
MATERIAL: 303 Se stainless steel per ASTM A-582 (AMS5640).

FINISH: HL86FN(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, white MIL-C-83286 (identification with splotch of red on body of collar).

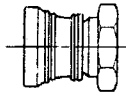
SPECIFICATION: Hi-Lok Product Specification 345.

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

EXAMPLE: HL86FN-8 = 1/4-28 Hi-Lok collar.



VOI-SHAN
1 raised bead indicates VOI-SHAN identification.



STANDARD PRESSED STEEL
2 raised beads indicate STANDARD PRESSED STEEL identification.

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

| | DATE | BY |
|----------|---------|-------------|
| DRAWN | 5-9-91 | D.P.S. |
| APPROVED | 8-12-91 | J. Williams |
| REVISION | | |

hi-Lok® COLLAR

TYPE 303 Se STAINLESS STEEL
1/16" GRIP VARIATION
TENSION APPLICATION

DRAWING NUMBER

HL86FN