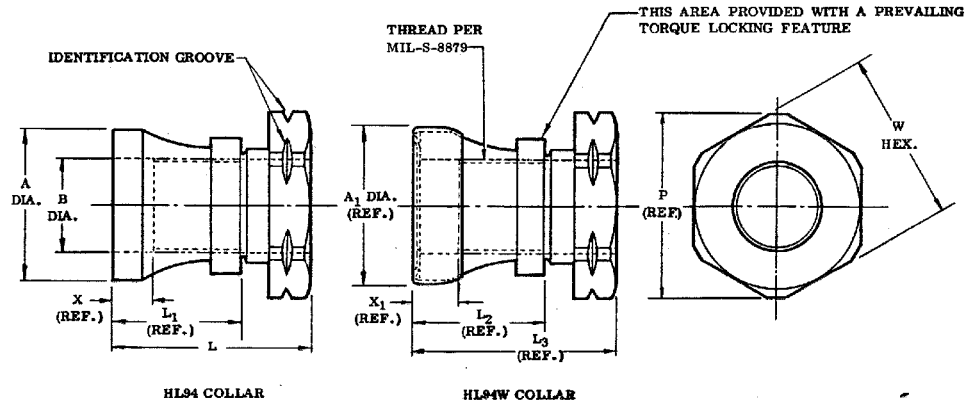


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 Division of Hi-Shear Industries Inc., U.S.A.
 AIR INDUSTRIES CO., INC. U.S.A. (Licensee - U.S.A. Canada) CAGE No. 00725
 HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 97626
 SFS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 98078
 FAIRCHILD Aerospace Services Division, U.S.A. (Licensee) CAGE No. 92211
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 80616
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee) - CAGE NO. 01866
 Division of Hi-Shear Industries Inc., U.S.A.
 HUCK INTERNATIONAL GMBH & CO., Germany (Licensee - EEC Countries)
 SAINT CHAMOND GRAMAT, S.A. France (Licensee - EEC Countries)
 SIRMACOS S.A., France (Licensee - EEC Countries-Collars)
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	A ₁ DIA (REF)	B DIA.	L LENGTH	L ₁ (REF)	L ₂ (REF)	L ₃ (REF)	P (REF.)	W HEX.	X (REF.)	X ₁ (REF)	UTS POUNDS MIN.	TORQUE OFF IN. LBS.
5	5/32	8-32UNJC-3B	.292 .288	.320	.173 .166	.447 .427	.270	.285	.460	.344	.314 .302	.107	.120	2,300	15-25 (30)
6	13/64	10-32UNJF-3B	.322 .318	.355	.212 .208	.457 .437	.280	.295	.470	.380	.346 .332	.107	.120	2,750	25-35
8	17/64	1/4-28UNJF-3B	.422 .418	.455	.272 .258	.552 .532	.340	.355	.565	.484	.440 .425	.112	.125	5,000	60-80
10	21/64	5/16-24UNJF-3B	.538 .532	.570	.336 .330	.672 .652	.430	.445	.685	.484	.440 .425	.122	.135	8,300	130-160
12	25/64	3/8-24UNJF-3B	.649 .642	.685	.398 .392	.744 .724	.470	.485	.755	.557	.503 .488	.122	.135	12,700	200-240
14	29/64	7/16-20UNJF-3B	.740 .730	.775	.463 .457	.862 .842	.560	.575	.875	.840	.753 .736	.137	.150	19,000	270-330
16	33/64	1/2-20UNJF-3B	.860 .850	.895	.528 .522	.942 .922	.610	.625	.955	.970	.878 .861	.137	.150	25,500	370-430
18	37/64	9/16-18UNJF-3B	.915 .905	.950	.588 .592	1.029 1.009	.670	.685	1.042	.970	.878 .861	.145	.158	29,500	500-575
20	41/64	5/8-18UNJF-3B	.995 .985	1.050	.661 .655	1.123 1.103	.735	.750	1.136	1.120	1.003 .986	.145	.158	32,000	625-750
24	49/64	3/4-16UNJF-3B	1.120 1.110	1.150	.786 .780	1.371 1.351	.940	.955	1.384	1.240	1.128 1.110	.156	.169	42,000	900-1000
28	57/64	7/8-14UNJF-3B	1.345 1.335	1.380	.911 .905	1.571 1.551	1.060	1.075	1.584	1.520	1.380 1.356	.169	.182	62,000	1200-1325
32	1-1/64	1-12UNJF-3B	1.490 1.480	1.530	1.036 1.030	1.836 1.815	1.225	1.240	1.849	1.650	1.504 1.480	.186	.199	84,000	1450-1600

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
 - Dimensions apply after finish.
 - Use HL294 to oversize replacement.

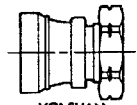
MATERIAL: Collar - Type 303 Se stainless steel per ASTM A582.
 Washer - 300 series stainless steel.

FINISH: Collar - HL94-() = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL94DU-() = Solid film lube per MIL-L-46010, Type I.
 HL94G-() = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL94K-() = Solid film lube per Lubeco 905.
 HL94LP-() = Solid film lube per MIL-L-46010, Type II.
 HL94PK-() = Cadmium plate per QQ-P-416 (olive drab color), Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL94TB-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL94TF-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
 HL94V-() = Solid film lube per Lubeco 2123.
 Collar & Washer -
 HL94W-() = Collar finish same as HL94-(), and washer with cadmium plate per QQ-P-416, Type I, Class 2.
 HL94DUW-() = Collar and washer both with solid film lube per MIL-L-46010, Type I.
 HL94GW-() = Collar and washer both with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL94GNW-() = Collar finish same as HL94G-(), and washer passivated per Hi-Shear Spec. 258.
 HL94GVW-() = Collar finish same as HL94G-(), and washer with solid film lube per Lubeco 2123.

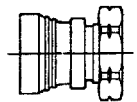
SPECIFICATION: Hi-Lok Product Specification 345.

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

EXAMPLE: HL94K-8 = 1/4-28 Hi-Lok collar; finish is Lubeco 905.



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



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

U.S. patents 3,390,906; and foreign patents.
 "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

			TITLE	DRAWING NUMBER
DATE	BY		HI-LOK® COLLAR TYPE 303 Se STAINLESS STEEL 1/16" GRIP VARIATION - SHEAR APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LOK PINS	HL94
DRAWN	5-15-63	Brlej		
APPROVED	5-15-63	M.C.		
REVISION	12-23-94	J.F.Obispo		