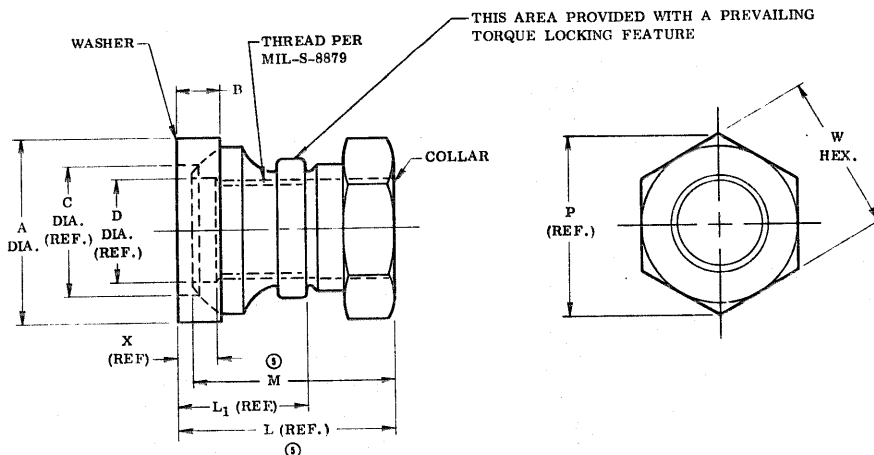


**STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

① HI-SHEAR CORPORATION, U.S.A. (Patent Holder) — U.S. Federal Code I.D. No. 73197  
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee)  
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)  
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee)  
 VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) — U.S. Federal Code I.D. No. 92215  
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ST. CHAMOND-GRANAT, S.A. France (Licensee—EEC Countries)  
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 Rudolph Kellerman GmbH & Co. (Licensee—EEC Countries—Collars)  
 SIMMONDS, S.A. France (Licensee—EEC Countries—Collars)  
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Stair Collars)  
 U.S. Federal Code I.D. No. 60516



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B	C DIA. (REF.)	D DIA. (REF.)	L (REF.)	L <sub>1</sub> (REF.)	M	P (REF.)	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE-OFF IN.-LBS.
-6	7/32"	10-32UNJF-3B	.400 .390	.145 .135	.305	.226	.505	.330	.418 .398	.380	.346 .332	.149	2,750	40-50
-8	9/32"	1/4-28UNJF-3B	.505 .495	.205 .195	.385	.289	.695	.400	.492 .472	.484	.440 .425	.163	5,000	115-130
-10	11/32"	5/16-24UNJF-3B	.645 .635	.210 .200	.465	.352	.730	.500	.610 .590	.484	.440 .425	.181	8,300	200-250
-12	13/32"	3/8-24UNJF-3B	.715 .705	.230 .220	.540	.416	.800	.545	.660 .640	.557	.503 .488	.181	12,700	360-440
-14	15/32"	7/16-20UNJF-3B	.835 .825	.280 .270	.625	.479	.935	.645	.753 .733	.624	.565 .550	.207	19,000	525-625
-16	17/32"	1/2-20UNJF-3B	.945 .935	.310 .300	.705	.542	1.015	.705	.833 .813	.763	.690 .675	.207	25,500	725-825
-18	19/32"	9/16-18UNJF-3B	1.185 1.175	.335 .325	.830	.610	1.125	.785	.930 .910	.970	.878 .861	.227	29,000	950-1075

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.  
 2. For use on sloped surfaces up to 7° maximum.  
 3. Dimensions apply after finish.

MATERIAL: Collar — Type 303 Se stainless steel per QQ-5-764.  
 Washer — 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

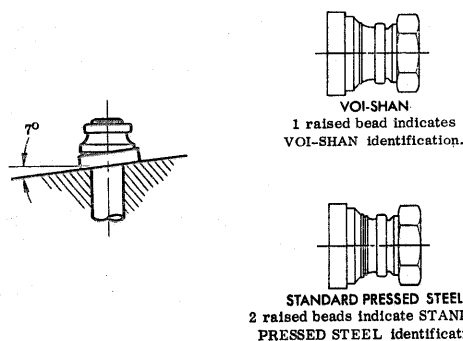
HEAT TREAT: Collar — None.  
 Washer — Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and 15-7Mo per MIL-H-6875.

FINISH: Collar — HLT288-( )A = Cadmium plate per QQ-P-416, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT288LP-( )A = Solid film lube per MIL-L-46010.  
 Washer — HLT288-( )W = Cadmium plate per QQ-P-416, Type II, Class 3.

SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 345.

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

EXAMPLE: HLT288-8AW = Assembly of HLT288-8A Collar and HLT288-8W Washer.  
 HLT288LP-8AW = Assembly of HLT288LP-8A Collar and HLT288-8W Washer.



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

	DATE	BY
DRAWN	10-3-69	Van
APPROVED	10-6-69	SPW/ldf K. TING
⑤ REVISION	6-21-85	D. P. S.

TITLE

**hi-lok® hi-tigue® COLLAR**

SELF-ALIGNING COLLAR ASSEMBLY  
 303 STAINLESS STEEL  
 1/16" GRIP VARIATION — TENSION APPLICATION  
 FOR USE ON 1/64" AND 1/32" OVERSIZE HI-TIGUE PINS

DRAWING NUMBER

**HLT288**