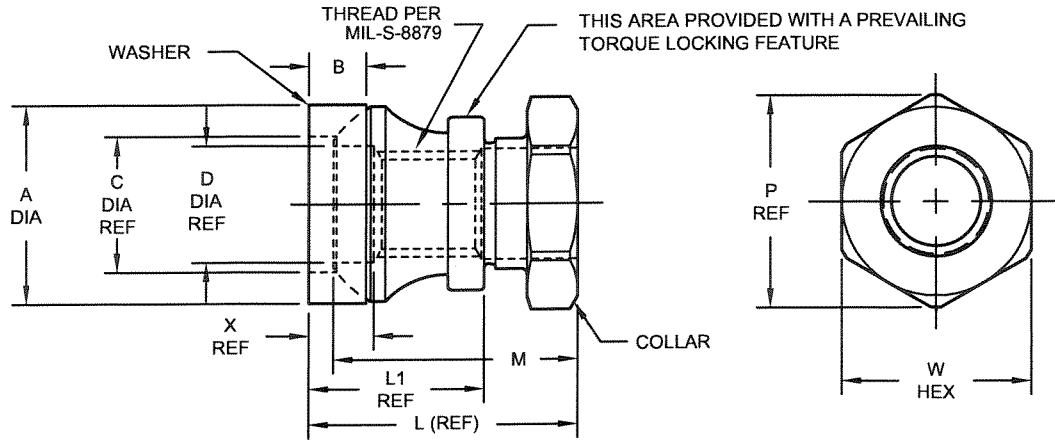


STANDARDS COMMITTEE FOR HI-LOK[®] PRODUCTS

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. 06725
 HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 58878
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
 (Pins & Steel Collars)

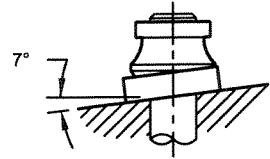
BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. OLB68
 a LISI AEROSPACE Company
 HUCK S.A. France (Licensee - ECC Countries)
 BLANC AERO S.A. France (Licensee - ECC Countries)
 a LISI AEROSPACE Company
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



DASH NO.	PIN NOM DIA	THREAD	A DIA (C)	B	C DIA (REF)	D DIA (REF)	L (REF)	L1 (REF)	M (REF)	P (REF)	W HEX	X (REF)	LOCKING TORQUE MAX	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	11/64	8-32UNJC-3B	.365 .355	.135 .125	.261	.192	.530 .510	.345	.480	.344	.314 .302	.185	10	1,400	22-32
6	7/32	10-32UNJF-3B	.400 .390	.120 .110	.295	.232	.560 .540	.375	.490	.344	.314 .302	.205	15	1,600	32-42
8	9/32	1/4-28UNJF-3B	.505 .495	.170 .160	.370	.292	.660 .640	.455	.570	.380	.346 .332	.225	20	3,000	75-90
10	11/32	5/16-24UNJF-3B	.645 .635	.170 .160	.453	.357	.800 .780	.560	.710	.484	.440 .425	.250	35	5,000	140-170
12	13/32	3/8-24UNJF-3B	.825 .815	.185 .175	.526	.421	.880 .860	.605	.780	.557	.503 .488	.255	40	7,000	210-260
14	15/32	7/16-20UNJF-3B	.935 .925	.225 .215	.605	.484	1.010 .990	.715	.895	.624	.565 .550	.285	60	9,500	310-370
16	17/32	1/2-20UNJF-3B	1.045 1.035	.255 .245	.685	.548	1.100 1.080	.770	.970	.763	.690 .675	.295	85	12,500	410-470

- 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 - 2024 aluminum alloy per QQ-A-430 or 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 AMS2770.
 Washer - Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per AMS-H-6875.
- FINISH:** Collar - HLT371-()A = Anodize per MIL-A-8625, color black, and cetyl alcohol lube per Hi-Shear Spec. 305.
 Washer - HLT371-()W = Cadmium plate per AMS-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.
 Code letter "A" following dash number indicates Hi-Lok Hi-Tigue collar.
 See "Finish" note for explanation of code letters.
- EXAMPLE:** HLT371-8AW = Assembly of HLT371-8A Collar and HLT371-8W Washer.



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

DATE	BY
DRAWN 11-11-69	VAN
APPROVED 11-12-69	J.G. WILCOX R.TING
REVISION 6-20-02	S. KIM

TITLE
HI-LOK[®] COLLAR
 SELF-ALIGNING COLLAR ASSEMBLY
 (ALUMINUM COLLAR - STAINLESS STEEL WASHER)
 1/16" GRIP VARIATION - SHEAR APPLICATION
 FOR USE ON 1/64" AND 1/32" OVERSIZE HI-TIGUE PINS
 (INCREASED DEPTH OF COUNTERBORE)

DRAWING NO.
HLT371