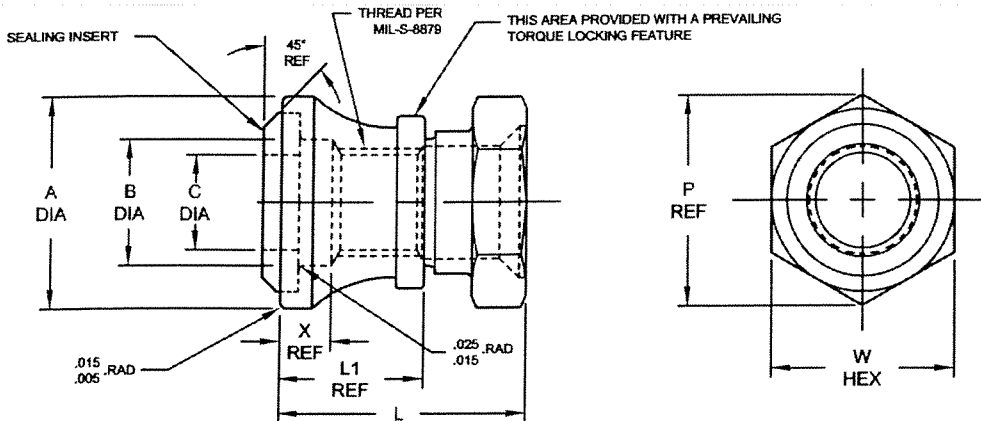


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73187
 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. 07328
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 66878
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 62215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
 (Tine & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 01868
 a GFI AEROSPACE Company
 HUCK S.A. France (Licensee - ECC Countries)
 BLANC AERO S.A. France (Licensee - ECC Countries)
 a GFI AEROSPACE Company
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	C DIA	E	L	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
6	3/16	10-32UNJF-3B	.375 .371	.216 .212	.198 .191	.040 .020	.457 .437	.275	.414	.378 .365	.118	2,750	40-50
8	1/4	1/4-28UNJF-3B	.500 .495	.285 .279	.269 .262	.045 .025	.552 .532	.340	.557	.503 .488	.127	5,000	110-130
10	5/16	5/16-24UNJF-3B	.625 .620	.349 .343	.331 .323	.045 .025	.672 .652	.430	.700	.628 .613	.139	8,300	200-250
12	3/8	3/8-24UNJF-3B	.720 .714	.418 .412	.400 .392	.055 .035	.744 .724	.475	.840	.753 .736	.139	12,700	360-420

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

MATERIAL: Collar - 303 Se stainless steel per ASTM A 582 and AMS5640.
 Insert - Teflon per MIL-P-19468.

① **FINISH:** Collar - HLT87-() = Cadmium plate per QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT87PB() = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT87LP() = Solid film lube per AS5272, Type II.

Insert - None.

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

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

EXAMPLE: HLT87PB8 = 1/4-28 Hi-Tigue Collar with cadmium plate Type II, Class 2 and cetyl alcohol lube.

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

	DATE	BY
DRAWN	6-15-71	Van
APPROVED	7-12-71	JGWilcox
① REVISION	3-16-00	J.F.Obispo

TITLE
HI-LOK® HI-TIGUE® COLLAR
 (SEALING TYPE)
 TYPE 303 Se STAINLESS STEEL
 1/16" GRIP VARIATION, TENSION APPLICATION

DRAWING NO.

HLT87