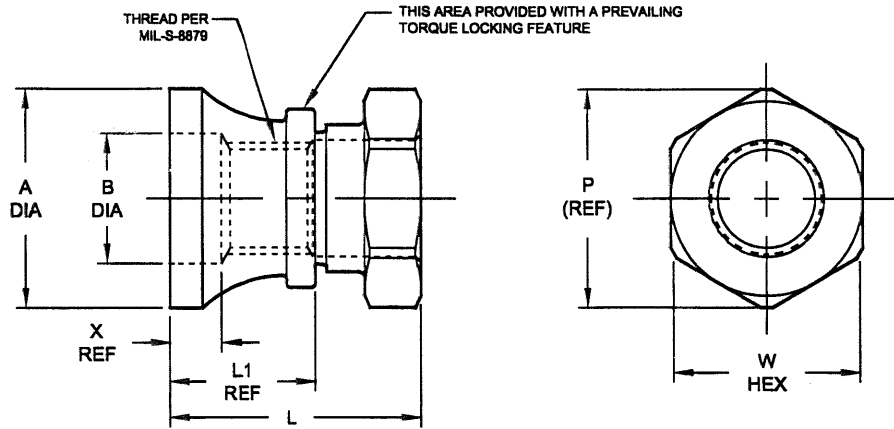


**STANDARDS COMMITTEE  
FOR HI-LOK® HI-TIGUE® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 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. 97828  
 SPB TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 66878  
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92216  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516  
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. CL889  
 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	L LENGTH	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.287 .283	.179 .175	.447 .427	.270	.344	.314 .302	.118	2,300	15-25
6	3/16	10-32UNJF-3B	.307 .303	.205 .201	.457 .437	.280	.344	.314 .302	.118	2,750	25-35
8	1/4	1/4-28UNJF-3B	.412 .408	.265 .261	.552 .532	.340	.380	.346 .332	.127	5,000	60-80
10	5/16	5/16-24UNJF-3B	.518 .512	.330 .324	.672 .652	.430	.484	.440 .425	.139	8,300	130-160
12	3/8	3/8-24UNJF-3B	.628 .622	.393 .387	.744 .724	.470	.557	.503 .488	.139	12,700	200-240
14	7/16	7/16-20UNJF-3B	.733 .727	.456 .450	.862 .842	.560	.624	.565 .550	.157	19,000	270-330
16	1/2	1/2-20UNJF-3B	.848 .842	.519 .513	.942 .922	.810	.763	.690 .675	.157	25,000	370-430
18	9/16	9/16-18UNJF-3B	.915 .905	.582 .576	1.029 1.009	.670	.970	.878 .861	.171	29,000	500-575
20	5/8	5/8-18UNJF-3B	.995 .985	.650 .644	1.123 1.103	.735	1.120	1.003 .986	.171	32,000	625-700
24	3/4	3/4-16UNJF-3B	1.120 1.110	.776 .770	1.371 1.351	.940	1.240	1.128 1.110	.188	42,000	900-1000
28	7/8	7/8-14UNJF-3B	1.345 1.335	.902 .896	1.571 1.551	1.060	1.450	1.315 1.292	.205	62,000	1200-1325
32	1	1-12UNJF-3B	1.490 1.480	1.030 1.024	1.836 1.816	1.225	1.650	1.504 1.480	.229	84,000	1450-1600

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
  2. Dimensions apply after finish.
  3. Use HLT294 for oversize replacement.

**MATERIAL:** Type 303 Se stainless steel per ASTM A 582 and AMS5640.

- FINISH:**
- HLT94( ) = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT94G( ) = Silver plate per AMS2410 (.0005 max. thickness) and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HLT94LP( ) = Solid film lube per AS5272, Type II and yellow paint.
  - HLT94MA( ) = Solid film lube per Kalgard RA.

**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:** HLT94-8 = 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

			TITLE	DRAWING NO.
DATE	BY		<b>HI-LOK® HI-TIGUE® COLLAR</b> TYPE 303 Se STAINLESS STEEL 1/16" GRIP VARIATION, SHEAR APPLICATION	<b>HLT94</b>
DRAWN	5-21-69	Van		
APPROVED	6-5-69	V. Miller		
REVISION	2-10-00	J.F. Obispo		