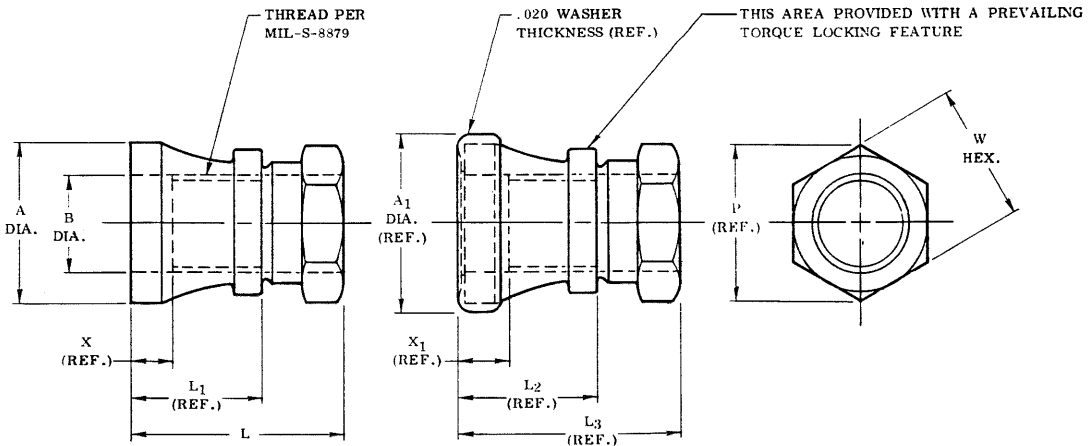


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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. 06725
 HUCK INTERNATIONAL INC., U.S.A. (Licensee) CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56678
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 22215
 WEST COAST AEROSPACE INC. U.S.A. (Licensee) CAGE No. 80618
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) - CAGE No. 0L868
 Division of Hi-Shear Industries Inc., U.S.A.
 HUCK INTERNATIONAL GMBH & CO., Germany (Licensee - EEC Countries)
 SAINT CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
 SIMMONDS 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	.337	.173 .166	.447 .427	.270	.300	.467	.344	.314 .302	.107	.137	1,400	15-25
6	3/16	10-32UNJF-3B	.307 .303	.360	.200 .192	.457 .437	.280	.310	.477	.344	.314 .302	.107	.137	1,600	25-35
8	1/4	1/4-28UNJF-3B	.412 .408	.462	.261 .252	.552 .532	.340	.370	.572	.380	.346 .332	.112	.142	3,000	60-80
10	5/16	5/16-24UNJF-3B	.518 .512	.575	.325 .314	.672 .652	.430	.460	.692	.484	.440 .425	.122	.152	5,000	130-160
12	3/8	3/8-24UNJF-3B	.628 .622	.690	.388 .376	.744 .724	.470	.500	.764	.557	.503 .488	.122	.152	7,000	200-240
14	7/16	7/16-20UNJF-3B	.713 .707	.770	.450 .442	.862 .842	.560	.590	.882	.624	.565 .550	.137	.167	9,500	270-330
16	1/2	1/2-20UNJF-3B	.815 .809	.872	.513 .501	.942 .922	.610	.640	.962	.763	.690 .675	.137	.167	12,500	370-430
18	9/16	9/16-18UNJF-3B	NOTE: USE HL79-18												
20	5/8	5/8-18UNJF-3B	NOTE: USE HL79-20												
24	3/4	3/4-16UNJF-3B	NOTE: USE HL79-24												
28	7/8	7/8-14UNJF-3B	NOTE: USE HL79-28												
32	1	1-12UNJF-3B	NOTE: USE HL79-32												

- NOTES:**
1. Go thread penetration shall be 3/4 of one revolution minimum.
 2. Dimensions apply after finish.
 3. Use HL79 for oversize replacement.

MATERIAL: Collar - 2024 aluminum alloy per QQ-A-430 or QQ-A-225/6.
 Washer - "NW" = 300 series stainless steel.
 "TW" = 5052 aluminum alloy per QQ-A-250/8, or 2024 aluminum alloy per QQ-A-250/4 OR QQ-A-250/5.

HEAT TREAT: Collar - Age to T6 condition per MIL-H-6088.
 Washer - "NW" = None.
 "TW" = Age to T6 condition per MIL-H-6088 (for 2024 only).

FINISH: Collar - HL70-() = Anodize per MIL-A-8625, dye color red, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL70CM-() = Chemical conversion coat per MIL-C-5541, Class 1A, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL70D-() = Anodize per MIL-A-8625 and solid film lube per MIL-L-46010, Type I.
 HL70K-() = Anodize per MIL-A-8625 and solid film lube per "Lubeco" 905.
 (31) HL70TF-() = Anodize per MIL-A-8625 and Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
 HL70TT-() = Anodize per MIL-A-8625, dye color red and transiube.
 Collar & Washer -
 HL70DTW-() = Collar finish is the same as HL70D-(). Washer finish is anodize per MIL-A-8625, dye color grey, or blue (for 2024 only).
 HL70NW-() = Collar finish is the same as HL70-(). Washer is passivated.
 HL70TW-() = Collar finish same as HL70-(). Washer finish is anodize per MIL-A-8625, dye color grey, or blue (for 2024 only).

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: HL70-8 = 1/4-28 Hi-Lok collar only.
 HL70TW-8 = 1/4-28 Hi-Lok collar with aluminum washer.

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 2024 - T6 ALUMINUM ALLOY 1/16" GRIP VARIATION - SHEAR APPLICATION	HL70
DRAWN	7-27-60	VAN		
APPROVED	7-27-60	MEC		
(31) REVISION	11-28-95	J.F.Obispo		