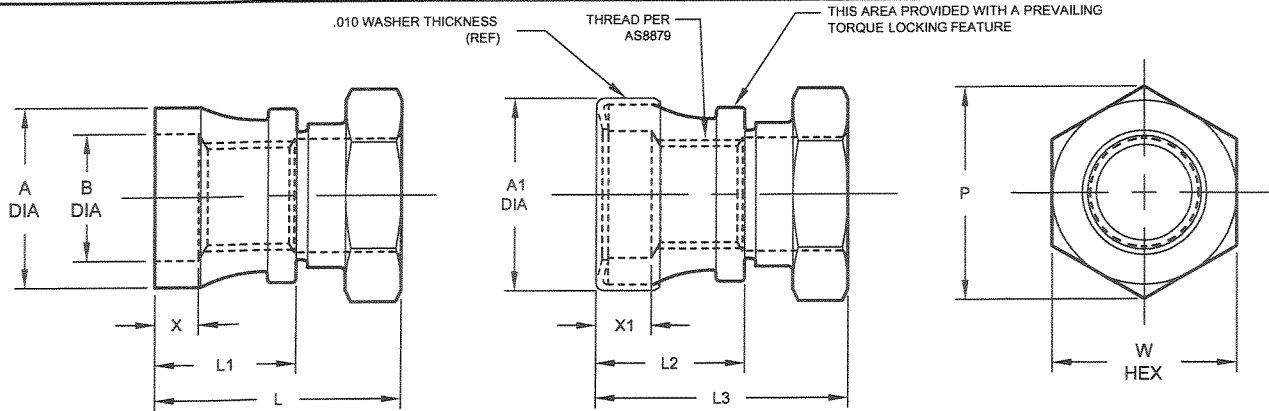


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 a LISI 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. 07928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60516
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0LB88
 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	A1 DIA (REF)	B DIA	L LENGTH	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.287 .283	.320	.173 .166	.447 .427	.265	.280	.460	.344	.314 .302	.107	.120	2,300	30-40
6	3/16	10-32UNJF-3B	.307 .303	.340	.212 .208	.457 .437	.275	.290	.470	.344	.314 .302	.107	.120	2,750	40-50
8	1/4	1/4-28UNJF-3B	.412 .408	.442	.272 .268	.552 .532	.340	.355	.565	.484	.440 .425	.112	.125	5,000	110-130
10	5/16	5/16-24UNJF-3B	.518 .512	.552	.336 .330	.672 .652	.430	.446	.685	.624	.565 .550	.122	.135	8,300	200-250
12	3/8	3/8-24UNJF-3B	.620 .614	.665	.398 .392	.744 .724	.475	.490	.755	.715	.628 .613	.122	.135	12,700	360-420
14	7/16	7/16-20UNJF-3B	.733 .727	.765	.463 .457	.862 .842	.560	.575	.875	.840	.753 .736	.137	.150	19,000	525-600
16	1/2	1/2-20UNJF-3B	.848 .842	.880	.528 .522	.942 .922	.610	.625	.955	.970	.878 .861	.137	.150	25,500	725-825
18	9/16	9/16-18UNJF-3B	.915 .905	.940	.598 .592	1.029 1.009	.670	.685	1.042	1.045	.941 .924	.145	.158	29,000	1000-1150
20	5/8	5/8-18UNJF-3B	.995 .985	1.020	.661 .655	1.123 1.103	.735	.750	1.136	1.120	1.003 .986	.145	.158	32,000	1350-1550
24	3/4	3/4-16UNJF-3B	1.120 1.110	1.190	.786 .780	1.371 1.351	.940	.960	1.485	1.240	1.128 1.110	.156	.170	42,000	1900-2200
28	7/8	7/8-14UNJF-3B	1.345 1.335	1.365	.911 .905	1.575 1.545	1.060	1.080	1.585	1.520	1.380 1.356	.169	.182	62,000	3200-3600
32	1	1-12UNJF-3B	1.490 1.480	1.525	1.036 1.030	1.840 1.810	1.225	1.245	1.850	1.650	1.504 1.480	.186	.200	84,000	4500-5000

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
 - Dimensions apply after finish.
 - Non-lubed collars must be used with lubed pin.
 - Use HL278 for oversize replacement.

- MATERIAL:**
- Collar - A-286 high temperature alloy per AMS5731, AMS5734, or AMS5736.
 - Washer - Type 300 series stainless steel.
- FINISH:**
- HL78(-) = Collar only with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL78DK() = Collar only with vacuum compatible Kalgard FA solid film lube.
 - HL78DU() = Collar only with solid film lube per AS5272, Type I.
 - HL78DUW() = Collar finish the same as HL78DU(), and washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 - HL78DRPBW = Collar finish same as HL78DR(), and washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 - HL78EG() = Collar only with Everlube 620 solid film lube.
 - HL78K() = Collar only with solid film lube per Lubeco 905.
 - HL78GU() = Collar only with silver plate per AMS2410.
 - HL78P() = Collar only with cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL78PB() = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL78PBW() = Collar finish the same as HL78PB(), and washer with passivate per Hi-Shear Spec. 258.
 - HL78PW() = Collar finish same as HL78P(), and washer with passivate per Hi-Shear Spec. 258.
 - HL78W() = Collar with silver plate and cetyl alcohol lube, and washer with passivate per Hi-Shear Spec. 258.
 - HL78V() = Collar only with solid film lube per Lubeco 2123.
 - HL78VW() = Collar and washer both Lubeco 2123 solid film lube.

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: HL78PBW8 = 1/4-28 Hi-Lok collar with cadmium plate, Type II, Class 2, and cetyl alcohol lube. Washer is passivated.

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

			TITLE		DRAWING NO.	
			HI-LOK® COLLAR		HL78	
			A-286 HIGH TEMPERATURE ALLOY			
			1/16" GRIP VARIATION, TENSION APPLICATION			
DRAWN	11-31-60	R.K.L.				
APPROVED	11-31-60	M.E.C.				
33 REVISION	9-16-03	J.F.Obispo				