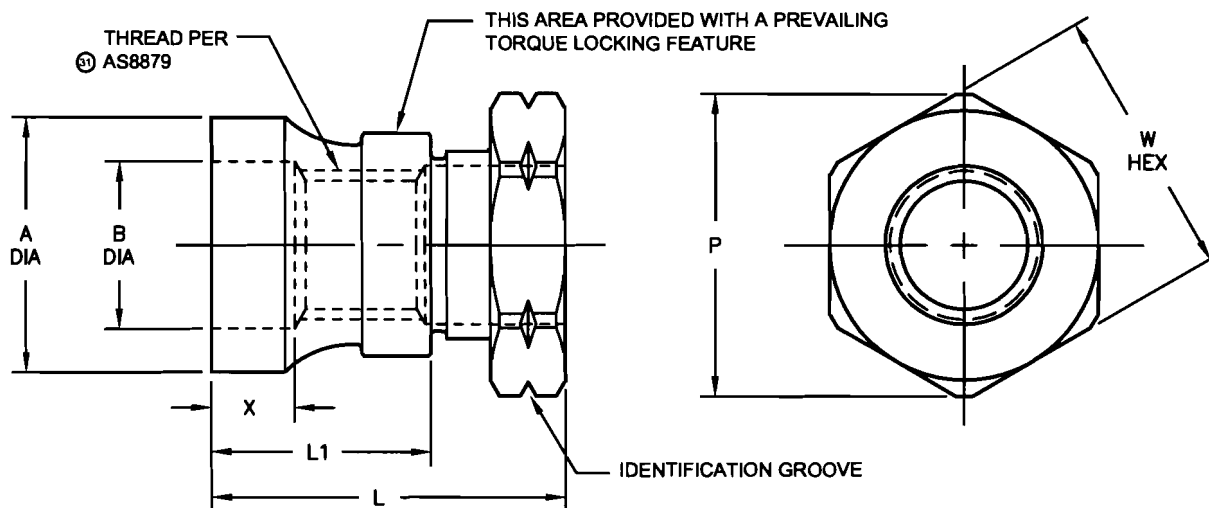




HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 a LI SI AEROSPACE Company
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada) CAGE No. 08725
 HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97628
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 58878
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 82215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 80516

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB88
 a LI SI AEROSPACE Company
 HUCK S.A. France (Licensee - ECC Countries)
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 a LI SI AEROSPACE Company
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32										
NOTE: For -5 diameter pin, use HL70-5											
6	13/64	10-32UNJF-3B	.322 .318	.212 .208	.457 .437	.280	.380	.346 .332	.107	1,600	25-35
8	17/64	1/4-28UNJF-3B	.422 .418	.272 .268	.552 .532	.340	.484	.440 .425	.112	3,000	60-80
10	21/64	5/16-24UNJF-3B	.538 .532	.336 .330	.672 .652	.430	.484	.440 .425	.122	5,000	130-160
12	25/64	3/8-24UNJF-3B	.649 .642	.398 .392	.744 .724	.470	.557	.503 .488	.122	7,000	200-240
14	29/64	7/16-20UNJF-3B	.743 .737	.463 .457	.862 .842	.565	.624	.565 .550	.137	9,500	270-330
16	33/64	1/2-20UNJF-3B	.865 .855	.528 .522	.942 .922	.615	.763	.690 .675	.137	12,500	370-430
18	37/64	9/16-18UNJF-3B	.880 .870	.598 .592	1.029 1.009	.670	.970	.878 .861	.145	14,500	500-575
20	41/64	5/8-18UNJF-3B	1.005 .995	.661 .655	1.123 1.103	.735	1.120	1.003 .986	.145	18,000	825-700
24	49/64	3/4-16UNJF-3B	1.105 1.095	.786 .780	1.370 1.351	.940	1.240	1.128 1.110	.156	27,500	900-1000
28	57/64	7/8-14UNJF-3B	1.295 1.285	.911 .905	1.575 1.545	1.060	1.450	1.315 1.292	.169	37,500	1200-1325
32	1-1/64	1-12UNJF-3B	1.475 1.465	1.036 1.030	1.840 1.810	1.225	1.650	1.504 1.480	.186	50,000	1450-1600

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions apply after finish.
 3. Use HL84 for oversize replacement.

MATERIAL: 2024 aluminum alloy per QQ-A-430 or AMS-QQ-A-225/6. (31)

HEAT TREAT: Age to T6 condition per AMS2770. (31)

FINISH: HL79(-) = Anodize per MIL-A-8625, dye color red, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL79D() = Anodize per MIL-A-8625 and solid film lube per AS5272, Type I.
 HL79GG() = Anodize per MIL-A-8625, dye color green, and cetyl alcohol lube per Hi-Shear Spec. 305.
 (31) HL79K() = Anodize per MIL-A-8625 and Lubeco 905 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: HL79-8 = 1/4-28 Hi-Lok Collar with cetyl alcohol lube.

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

			TITLE	DRAWING NO.
DRAWN	11-31-60	R.K.L.	HI-LOK® COLLAR 2024-T6 ALUMINUM ALLOY 1/16" GRIP VARIATION, SHEAR APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LOK PINS	HL79
APPROVED	11-31-60	M.C.		
(31) REVISION	2-18-14	J.F.Obispo		