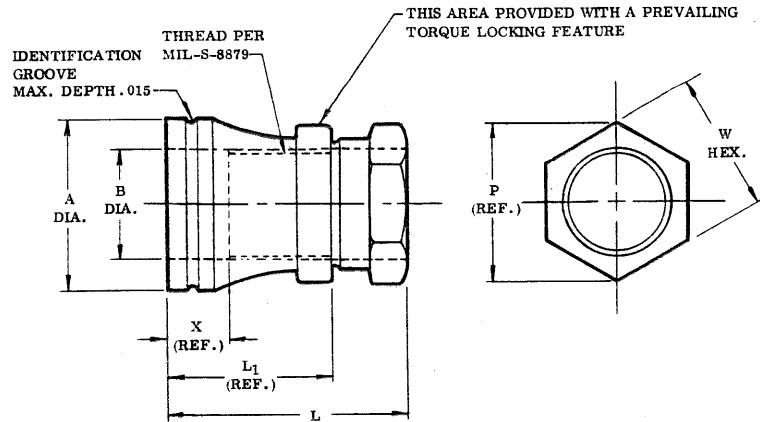


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION (Patent Holder) — Federal Code Ident. No. 73197
 VOI-SHAN DIV., VSI CORP. (Licensee) — Federal Code Ident. No. 92215
 STANDARD PRESSED STEEL CO. (Licensee) — Federal Code Ident. No. 56878



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B DIA.	L	L ₁ (REF.)	P (REF.)	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE OFF IN. LBS.
-5	13/64"				NOTE: For -5 diameter pin, use HL79-6						
-6	7/32"	10-32UNJF-3B	.335 .325	.227 .223	.457 .437	.275	.380	.346 .332	.107	1,600	25-35
-8	9/32"	1/4-28UNJF-3B	.430 .420	.290 .286	.552 .532	.340	.434	.440 .425	.112	3,000	60-80
-10	11/32"	5/16-24UNJF-3B	.580 .570	.353 .347	.672 .652	.430	.484	.440 .425	.122	5,000	130-160
-12	13/32"	3/8-24UNJF-3B	.690 .680	.416 .410	.744 .724	.475	.557	.503 .488	.122	7,000	200-240
-14	15/32"	7/16-20UNJF-3B	.775 .765	.481 .475	.862 .842	.565	.624	.565 .550	.137	9,500	270-330
-16	17/32"	1/2-20UNJF-3B	.880 .870	.543 .537	.942 .922	.615	.763	.690 .675	.137	12,500	370-430
-18	19/32"	9/16-18UNJF-3B	.925 .915	.613 .607	1.029 1.009	.670	.970	.878 .861	.145	14,500	500-575
-20	21/32"	5/8-18UNJF-3B	1.005 .995	.678 .672	1.123 1.103	.735	1.120	1.003 .986	.145	18,000	625-700
-24	25/32"	3/4-16UNJF-3B	1.185 1.175	.803 .797	1.371 1.351	.940	1.240	1.128 1.110	.156	27,500	900-1000
-28	29/32"	7/8-14UNJF-3B	1.360 1.350	.918 .912	1.575 1.545	1.060	1.450	1.315 1.292	.169	37,500	1200-1325
-32	1-1/32"	1-12UNJF-3B	1.520 1.510	1.048 1.042	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 HL279 for oversize replacement.

MATERIAL: 2024 aluminum alloy per QQ-A-430 or QQ-A-225/6.

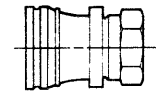
HEAT TREAT: Age to T6 condition per MIL-H-6088.

- FINISH: HL84-() = Anodize per Spec. MIL-A-8625, dye color blue, and cetyl alcohol per Hi-Shear Spec. 305.
 HL84D-() = Anodize per Spec. MIL-A-8625, and solid film lube per MIL-L-8937.
 ⑥ HL84K-() = Anodize per Spec. MIL-A-8625, and solid film lube per "Lubeco" 905.

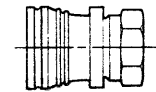
SPECIFICATION: Hi-Lok Product Specification 345.

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

EXAMPLE: HL84-8 = 1/4-28 Hi-Lok collar with cetyl alcohol lube.



VOI-SHAN
1 raised bead indicates
VOI-SHAN identification.



STANDARD PRESSED STEEL
2 raised beads indicate STANDARD
PRESSED STEEL identification.

U.S. patents 2,882,773; 2,927,491; 2,940,495; 3,027,789; 3,138,987; design patent 191,883; other U.S. and Foreign patents granted and pending; property of Hi-Shear Corporation. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

DRAWN	DATE	BY	TITLE	DRAWING NUMBER
	11-2-62	C. E. K.		
CHECKED	11-2-62	M. E. C.	hi-Lok® COLLAR 2024-T6 ALUMINUM ALLOY 1/16" GRIP VARIATION — SHEAR APPLICATION FOR USE ON 1/32" OVERSIZE HI-LOK PINS	HL84
REVISION	1-3-75	VAN		