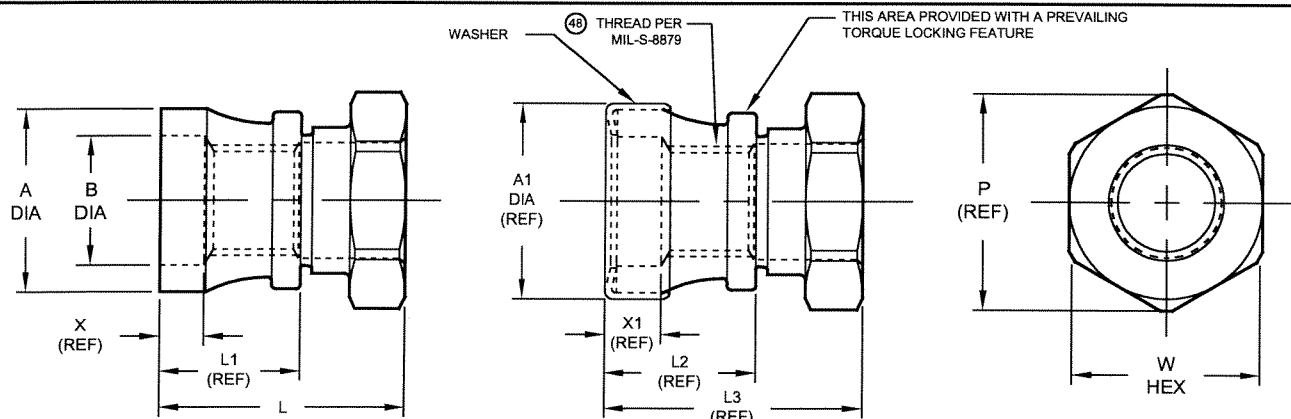


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
a 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. 97928
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)

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68
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	A1 DIA (REF)	B DIA	L	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	.200 .192	.457 .437	.275	.290	.470	.344	.314 .302	.107	.120	2,750	40-50
8	1/4	1/4-28UNJF-3B	.412 .408	.442	.261 .252	.552 .532	.340	.355	.565	.380	.346 .332	.112	.125	5,000	110-130
10	5/16	5/16-24UNJF-3B	.518 .512	.552	.325 .314	.672 .652	.430	.445	.685	.484	.440 .425	.122	.135	8,300	200-250
12	3/8	3/8-24UNJF-3B	.628 .622	.665	.388 .376	.744 .724	.475	.490	.755	.557	.503 .488	.122	.135	12,700	360-420
14	7/16	7/16-20UNJF-3B	.733 .727	.765	.463 .442	.862 .842	.560	.575	.875	.840	.753 .736	.137	.150	19,000	525-675
16	1/2	1/2-20UNJF-3B	.848 .842	.880	.528 .501	.942 .922	.610	.625	.955	.970	.878 .861	.137	.150	25,500	725-1000
18	9/16	9/16-18UNJF-3B	.915 .905	.940	.598 .570	1.029 1.009	.670	.685	1.042	.970	.878 .861	.145	.158	29,000	1000-1150
20	5/8	5/8-18UNJF-3B	.995 .985	1.040	.661 .634	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	1.140	.786 .762	1.371 1.351	.940	.955	1.384	1.240	1.128 1.110	.156	.169	42,000	1900-2200
28	7/8	7/8-14UNJF-3B	1.345 1.335	1.365	.911 .887	1.575 1.545	1.060	1.075	1.584	1.520	1.380 1.356	.169	.182	62,000	3200-3600
32	1	1-12UNJF-3B	1.490 1.480	1.510	1.036 1.015	1.840 1.810	1.225	1.240	1.849	1.650	1.504 1.480	.186	.199	84,000	4500-5000

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions apply after finish.
 3. Use HL87 for oversize replacement.
 4. Use HL73 or HL273 for higher tension application.

MATERIAL: Collar - 303 Se stainless steel per ASTM A-582 (AMS5640).
Steel Washer - 300 series stainless steel (.010 thick).
Aluminum Washer - 2024-T6 aluminum alloy (.020 thick) per AMS-QQ-A-250/4 or AMS-QQ-A-250/5 (sizes -5 through -12 only).

FINISH:

- HL86(-) = Collar only with cadmium plate per AMS-QQ-P-416, Type I, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL86W(-) = Collar finish the same as HL86(-), and steel washer with cadmium plate per AMS-QQ-P-416, Type I, Class 2.
- HL86CNNW(-) = Diffused nickel-cadmium plating per AMS2416, and cetyl alcohol lube per Hi-Shear Spec. 305, and steel washer is passivate.
- HL86D(-) = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and solid film lube per AS5272, Type I.
- HL86DU(-) = Collar only with solid film lube per AS5272, Type I.
- HL86DUW(-) = Collar finish the same as HL86DU(-), and steel washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2.
- HL86G(-) = Collar only with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL86GGW(-) = Collar and steel washer both with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL86GNW(-) = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305, and steel washer is passivate.
- HL86K(-) = Collar only with solid film lube "Lubeco" 905 (recommended for use on HL32 and HL33 only).
- HL86KP(-) = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, color violet to purple, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL86KPW(-) = Collar finish the same as HL86KP(-), and steel washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2.
- HL86MA(-) = Collar only with solid film lube per Kalgard RA.
- HL86PB(-) = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL86PBW(-) = Collar finish the same as HL86PB(-), and steel washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2.
- HL86TB(-) = Collar only with Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL86TF(-) = Collar only with Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
- HL86TW(-) = Collar with cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305, and aluminum washer anodize per AMS-A-8625, dye color blue (sizes -5 through -12 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.

EXAMPLES: HL86W8 = 1/4-28 Hi-Lok collar with steel washer.
HL86TW8 = 1/4-28 Hi-Lok collar with aluminum washer.

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

	DATE	BY	TITLE HI-LOK [®] COLLAR TYPE 303 Se STAINLESS STEEL 1/16" GRIP VARIATION, TENSION APPLICATION	DRAWING NO. HL86
DRAWN	7-29-60	Van		
APPROVED	8-6-65	J.M.		
48 REVISION	8-20-01	J.F.Obispo		