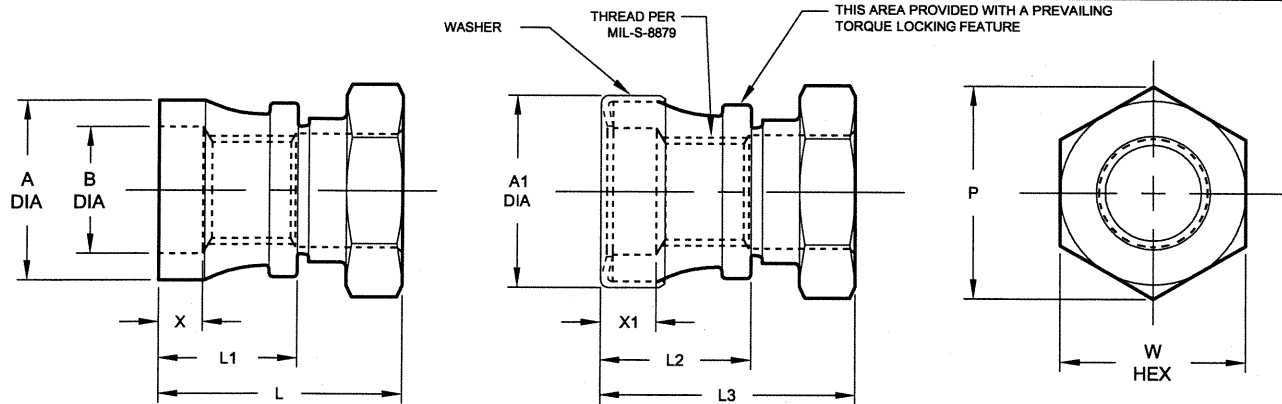


# STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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. 97828  
 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. 0LB68  
 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													
NOTE: USE HL86-5 for -5 diameter pin.															
6	13/64	10-32UNJF-3B	.307 .303	.340	.212 .208	.457 .437	.275	.290	.470	.344	.314 .302	.107	.120	2,750	40-50
8	17/64	1/4-28UNJF-3B	.412 .408	.442	.272 .268	.552 .532	.340	.355	.565	.380	.346 .332	.112	.125	5,000	110-130
10	21/64	5/16-24UNJF-3B	.518 .512	.552	.336 .330	.672 .652	.430	.445	.685	.484	.440 .425	.122	.135	8,300	200-250
12	25/64	3/8-24UNJF-3B	.628 .622	.665	.398 .392	.744 .724	.475	.490	.755	.557	.503 .488	.122	.135	12,700	360-420
14	29/64	7/16-20UNJF-3B	.733 .727	.775	.463 .457	.862 .842	.560	.575	.875	.840	.753 .736	.137	.150	19,000	525-675
16	33/64	1/2-20UNJF-3B	.848 .842	.895	.528 .522	.942 .922	.610	.625	.955	.970	.878 .861	.137	.150	25,500	725-1000
18	37/64	9/16-18UNJF-3B	.915 .905	.910	.598 .592	1.029 1.009	.670	.685	1.042	.970	.878 .861	.145	.158	29,000	1000-1150
20	41/64	5/8-18UNJF-3B	.995 .985	1.040	.661 .655	1.123 1.103	.735	.750	1.136	1.120	1.003 .986	.145	.158	32,000	1350-1550
24	49/64	3/4-16UNJF-3B	1.120 1.110	1.140	.786 .780	1.371 1.351	.940	.955	1.384	1.240	1.128 1.110	.156	.169	42,000	1900-2200
28	57/64	7/8-14UNJF-3B	1.345 1.335	1.365	.911 .905	1.575 1.545	1.060	1.075	1.584	1.520	1.380 1.356	.169	.182	62,000	3200-3600
32	1-1/64	1-12UNJF-3B	1.490 1.480	1.510	1.036 1.030	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 HL93 for oversize replacement.
  4. Use HL273 for higher tension application.

**MATERIAL:** Collar - 303 Se stainless steel per ASTM A-582 (AMS5640).  
 Washer - 300 series stainless steel (.010 thick). 2024-T6 aluminum alloy (.020 thick) per AMS-QQ-A-250/4 or QQ-A-250/5 (sizes -6 through -12 only).

**FINISH:**

- HL87(-) = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL87W(-) = Collar finish the same as HL87(-), and steel washer with cadmium plate per AMS-QQ-P-416, Type I, Class 2.
- HL87D(-) = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and solid film lube per AS5272, Type I.
- HL87DJ(-) = Collar only with solid film lube per AS5272, Type I, plus green identification on body of collar.
- HL87DU(-) = Collar only with solid film lube per AS5272, Type I.
- HL87DUW(-) = Collar finish the same as HL87DU(-), and steel washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2, no lube.
- HL87G(-) = Collar only with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL87GGW(-) = Collar and steel washer both with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL87KP(-) = 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.
- HL87KPW(-) = Collar finish the same as HL87KP(-), and steel washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2, no lube.
- HL87T(-) = Collar with cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL87TW(-) = 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 MIL-A-8625, dye color blue (sizes -6 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:** HL87G8 = 1/4-28 Hi-Lok collar with silver plate.  
 HL87W8 = 1/4-28 Hi-Lok collar and steel washer, both with cadmium plate.

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

			TITLE	DRAWING NO.
DRAWN	7-21-60	Van	<b>HI-LOK® COLLAR</b> TYPE 303 Se STAINLESS STEEL 1/16" GRIP VARIATION, TENSION APPLICATION FOR USE ON 1/64" OVERSIZE HI-LOK PINS	<b>HL87</b>
APPROVED	7-21-60	MEC		
REVISION	2-5-2004	J.F.Obispo		
(39)				