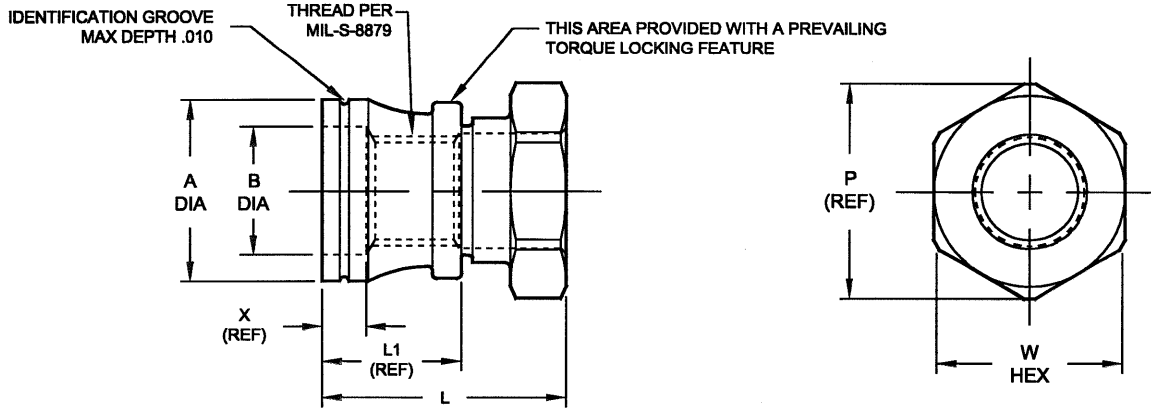


# STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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. 07628  
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878  
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 82215  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 80516  
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0LB88  
 a GFI AEROSPACE Company  
 HUCK S.A. France (Licensee - ECC Countries)  
 BLANG 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	B DIA	L	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
6	7/32	10-32UNJF-3B	.332 .328	.227 .223	.457 .437	.275	.380	.346 .332	.107	2,750	40-50
8	9/32	1/4-28UNJF-3B	.427 .423	.290 .286	.552 .532	.342	.484	.440 .425	.112	5,000	110-130
10	11/32	5/16-24UNJF-3B	.578 .572	.353 .347	.672 .652	.432	.484	.440 .425	.122	8,300	200-250
12	13/32	3/8-24UNJF-3B	.683 .677	.416 .410	.744 .724	.474	.557	.503 .488	.122	12,700	360-420
14	15/32	7/16-20UNJF-3B	.775 .765	.481 .475	.862 .842	.565	.970	.878 .861	.137	19,000	525-600
16	17/32	1/2-20UNJF-3B	.880 .870	.543 .537	.942 .922	.615	1.120	1.003 .986	.137	25,500	725-825
18	19/32	9/16-18UNJF-3B	.925 .915	.613 .607	1.060 1.040	.700	1.120	1.003 .986	.165	29,000	1000-1150
20	21/32	5/8-18UNJF-3B	1.000 .990	.678 .672	1.145 1.125	.755	1.120	1.003 .986	.165	32,000	1350-1550
24	25/32	3/4-16UNJF-3B	1.185 1.175	.803 .797	1.415 1.385	.975	1.240	1.128 1.110	.175	42,000	1900-2200
28	29/32	7/8-14UNJF-3B	1.360 1.350	.924 .918	1.615 1.585	1.100	1.520	1.380 1.356	.190	62,000	3200-3600
32	1-1/32	1-12UNJF-3B	1.530 1.520	1.055 1.045	1.915 1.885	1.300	1.650	1.504 1.480	.210	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 HL287 for oversize replacement.
  4. Use HL373 for higher tension application.

**MATERIAL:** 303 Se stainless steel per QQ-S-764 and ASTM A-582 (AMS5640).

- FINISH:**
- HL93( ) = Cadmium plate per QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL93DU( ) = Solid film lube per MIL-L-46010, Type I.
  - HL93G( ) = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL93K( ) = Solid film lube "Lubeco" 905.
  - HL93TF( ) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
  - HL93V( ) = Solid film lube per "Lubeco" 2123.

**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:** HL93-8 = 1/4-28 Hi-Lok oversize collar with Type II cadmium plate.

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

			TITLE	DRAWING NO.
DATE	BY		<b>HI-LOK® COLLAR</b> TYPE 303 Se STAINLESS STEEL 1/16" GRIP VARIATION, TENSION APPLICATION FOR USE ON 1/32" OVERSIZE HI-LOK PINS	<b>HL93</b>
DRAWN	6-12-62	R.K.L.		
APPROVED	6-12-62	M.E.C.		
REVISION	4-10-00	J.F.Obispo		