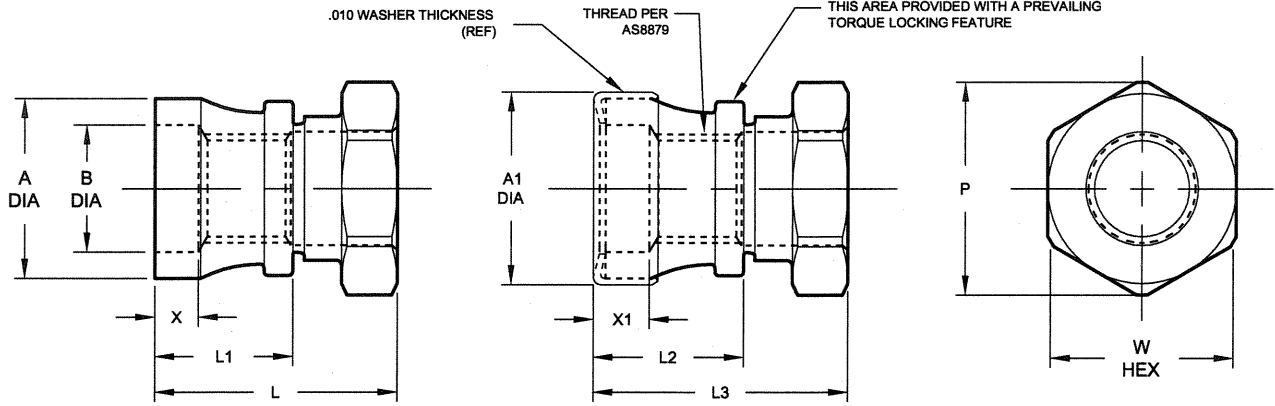


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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. 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)

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
4	1/8	6-32UNJC-3B	.245 .235	.270	.147 .143	.420 .400	.250	.265	.435	.344	.314 .302	.107	.120	1,350	10-20
5	5/32	8-32UNJC-3B	.287 .283	.320	.173 .166	.447 .427	.265	.280	.460	.344	.314 .302	.107	.120	1,940	15-25
6	3/16	10-32UNJF-3B	.307 .303	.340	.200 .195	.457 .437	.275	.290	.470	.344	.314 .302	.107	.120	2,500	25-35
8	1/4	1/4-28UNJF-3B	.412 .408	.442	.261 .254	.552 .532	.340	.355	.565	.484	.440 .425	.112	.125	4,300	60-80
10	5/16	5/16-24UNJF-3B	.518 .512	.552	.325 .319	.672 .652	.430	.445	.685	.624	.565 .550	.122	.135	6,300	130-160
12	3/8	3/8-24UNJF-3B	.620 .614	.665	.388 .381	.744 .724	.475	.490	.755	.715	.628 .613	.122	.135	8,700	200-240
14	7/16	7/16-20UNJF-3B	.733 .727	.765	.450 .442	.862 .842	.560	.575	.875	.840	.753 .736	.137	.150	12,100	270-330
16	1/2	1/2-20UNJF-3B	.848 .842	.880	.521 .507	.942 .922	.610	.625	.955	.970	.878 .861	.137	.150	15,300	370-430
18	9/16	9/16-18UNJF-3B	.915 .905	.940	.576 .570	1.029 1.009	.670	.685	1.042	1.045	.941 .924	.145	.158	20,500	500-575
20	5/8	5/8-18UNJF-3B	.995 .985	1.020	.640 .634	1.123 1.103	.735	.750	1.136	1.120	1.003 .986	.145	.158	25,700	625-700
24	3/4	3/4-16UNJF-3B	1.120 1.110	1.190	.770 .762	1.371 1.351	.940	.960	1.485	1.240	1.128 1.110	.156	.170	37,300	900-1000
28	7/8	7/8-14UNJF-3B	1.345 1.335	1.365	.895 .887	1.575 1.545	1.060	1.080	1.585	1.520	1.380 1.356	.169	.182	50,900	1200-1325
32	1	1-12UNJF-3B	1.490 1.480	1.525	1.025 1.015	1.840 1.810	1.225	1.245	1.850	1.650	1.504 1.480	.186	.200	67,000	1450-1600

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions apply after finish.
 3. Use HL197 for oversize replacement.

- MATERIAL:**
 Collar - A-286 high temperature alloy per AMS5731, AMS5734, or AMS5736.
 Washer - Type 300 series stainless steel.
- FINISH:**
- HL97(-) = Collar only with silver plate per AMS2410 (.0002-.0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL97DJ() = Collar only with solid film lube per AS5272, Type I plus green identification on body of collar.
 - HL97DN() = Collar only with solid film lube per AS5272, Type I.
 - HL97DU() = Collar only with solid film lube per AS5272, Type I plus yellow MIL-P-23377 identification on body of collar.
 - HL97DUW() = Collar finish the same as HL97DU(), and washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 - HL97DUWU() = Collar finish the same as HL97DU(), and washer with passivate per Hi-Shear Spec. 258.
 - HL97EG() = Collar only with Evertube 620 solid film lube.
 - HL97K() = Collar only with solid film lube per Lubeco 905.
 - HL97KG() = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, color green, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL97KGW() = Collar finish the same as HL97KG(), and washer with passivate per Hi-Shear Spec. 258.
 - HL97KW() = Collar finish the same as HL97K(), and washer with passivate per Hi-Shear Spec. 258.
 - HL97LP() = Collar only with solid film lube per AS5272, Type II.
 - HL97MA() = Collar only with Kalgard RA solid film lube per AS5272, Type II.
 - HL97PB() = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL97PBW() = Collar finish the same as HL97PB(), and washer with passivate per Hi-Shear Spec. 258.
 - HL97TB() = Collar only with Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL97TF() = Collar only with Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
 - HL97TFW() = Collar finish same as HL97TF(), and washer with passivate per Hi-Shear Spec. 258.
 - HL97W() = Collar with silver plate and cetyl alcohol lube, and washer with passivate per Hi-Shear Spec. 258.
 - HL97V() = Collar only with solid film lube per Lubeco 2123.
 - HL97VW() = Collar and washer both Lubeco 2123 solid film lube.
 - HL97Y() = Collar only with Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

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: HL97TFW8 = Collar with Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and passivated washer.

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

			TITLE	DRAWING NO.
DRAWN	11-31-60	Van	HI-LOK® COLLAR A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION, SHEAR APPLICATION	HL97
APPROVED	11-31-60	Cessna		
REVISION	4-6-05	J.F.Obispo		
(39)				