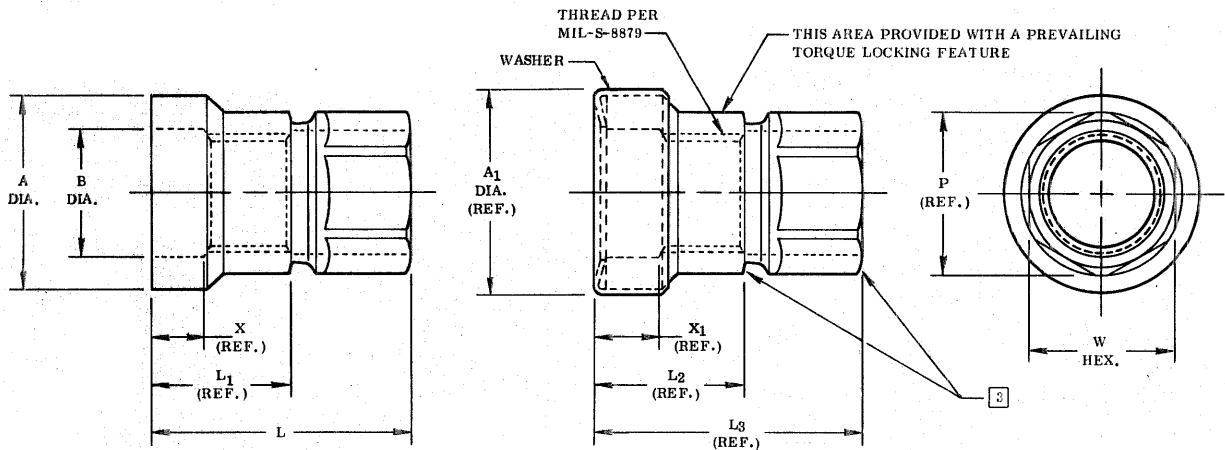


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 AIR INDUSTRIES CO., U.S.A. (Licensee - U.S. & Canada) CAGE No. 06725
 FAIRCHILD FASTENERS, Industry Operations, U.S.A. (Licensee) CAGE No. 92215
 FAIRCHILD FASTENERS, South Bay Operations, U.S.A. (Licensee) CAGE No. 6M902
 HUCK INTERNATIONAL, INC., Aerospace Fasteners, U.S.A. (Licensee) CAGE No. 17446
 HUCK INTERNATIONAL, INC., Lukewood Operations, U.S.A. (Licensee) CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878

WEST COAST AEROSPACE INC., U.S.A. (Licensee - U.S. & Canada) CAGE No. 60516
 HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee) CAGE No. 0LB88
 FAIRCHILD FASTENERS, Simmonds, France (Licensee - EEC Countries)
 FAIRCHILD FASTENERS, VSD GmbH, Germany (Licensee - EEC Countries)
 HUCK S.A., France (Licensee - EEC Countries)
 SAINT CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



DASH NO.	PIN DIA.	THREAD	A DIA.	A ₁ DIA. (REF.)	B DIA.	L LENGTH	L ₁ (REF.)	L ₂ (REF.)	L ₃ (REF.)	P (REF.)	W HEX.	X (REF.)	X ₁ (REF.)	UTS POUNDS MIN.	TORQUE OFF IN. LBS.
5	5/32	8-32UNJC-3B	.287 .283	.320	.173 .169	.435 .415	.235	.250	.450	.248	.223 .213	.107	.120	2,300	15-25
6	13/64	10-32UNJF-3B	.307 .303	.340	.212 .208	.450 .430	.250	.265	.465	.280	.254 .244	.107	.120	2,750	25-35
8	17/64	1/4-28UNJF-3B	.412 .408	.440	.276 .272	.550 .530	.300	.315	.565	.344	.314 .305	.112	.125	5,000	60-80
10	21/64	5/16-24UNJF-3B	.518 .512	.550	.340 .334	.670 .650	.370	.385	.685	.414	.378 .365	.122	.135	8,300	130-160
12	25/64	3/8-24UNJF-3B	.628 .622	.660	.403 .397	.740 .720	.410	.425	.755	.484	.440 .425	.122	.135	12,700	200-240
14	29/64	7/16-20UNJF-3B	.735 .725	.775	.466 .460	.930 .910	.560	.575	.935	.573	.505 .490	.137	.150	19,000	270-330
16	33/64	1/2-20UNJF-3B	.850 .840	.895	.528 .522	1.020 1.000	.610	.625	1.025	.643	.565 .550	.137	.150	25,500	370-430

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 - Dimensions apply after finish.
 - Burrs from cutoff process and cutting torque-off groove allowed.
 - HL1094N-() collars are for use in special environments; to be lubricated with compatible materials by user.

MATERIAL: Collar - S30430 (302 HQ) stainless steel per Spec. ASTM A 493, Type XM-7, or 302 or 305 stainless steel per QQ-S-763 and AMS5686, or 303Se stainless steel per ASTM A 582 (AMS 5640).
 Washer - 300 series stainless steel.

FINISH: Collar - HL1094-() = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL1094D() = Cadmium plate per QQ-P-416, Type II, Class 2, and solid film lube per AS5272, Type I.
 HL1094DU() = Solid film lube per AS5272, Type I.
 HL1094G() = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 [4] HL1094N() = Cadmium plate per QQ-P-416, Type II, Class 2, no lube.
 HL1094TF() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
 Collar & Washer - HL1094W() = Collar finish same as HL1094-(), and washer with cadmium plate per QQ-P-416, Type I, Class 2.
 HL1094DUW() = Collar and washer both with solid film lube per AS5272 Type I.
 HL1094GW() = Collar and washer both with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL1094GNW() = Collar finish same as HL1094G(), and washer passivated per Hi-Shear Spec. 258.
 HL1094TFNW() = Collar finish same as HL1094TF(), and washer passivated per Hi-Shear Spec. 258.

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: HL1094-8 = 1/4-28 Hi-Lok collar with Type II cadmium plate.
 HL1094W8 = 1/4-28 Hi-Lok collar and plated washer.

U.S. patents 3,390,906; and foreign patents.
 "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

DRAWN	DATE	BY	TITLE HI-LOK® COLLAR STAINLESS STEEL 1/16" GRIP VARIATION - SHEAR APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LOK PINS	DRAWING NUMBER
	10-16-80	D.P.S.		
APPROVED	10-16-80	R.Ting		HL1094
[8] REVISION	11-17-98	J.Henderson		