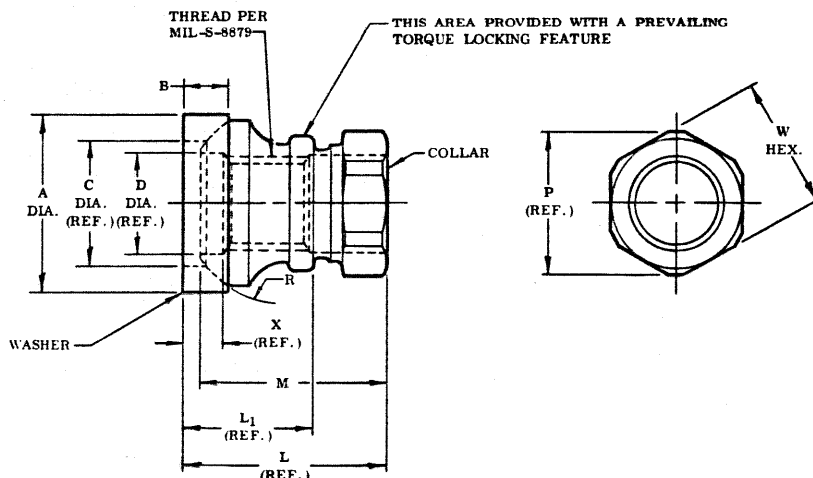


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 Division of Hi-Shear Industries Inc., U.S.A.
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. Canada) CAGE No. 06725
 HUCK INTERNATIONAL INC., Deutch Operation, U.S.A. (Licensee) CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 66678
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92216
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 92516
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee) CAGE No. 0L868
 Division of Hi-Shear Industries Inc., U.S.A.
 HUCK INTERNATIONAL GMBH & CO., Germany (Licensee - EEC Countries)
 SAINT CHAMOND GRANAT, S.A. France (Licensee - EEC Countries)
 SIMMONDS S.A., France (Licensee - EEC Countries - Collars)
 TOKYO SCREW COMPANY, Japan (Licensee - Japan)



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B	C DIA. (REF.)	D DIA. (REF.)	L (REF.)	L ₁ (REF.)	M	P (REF.)	R SPHER. RAD.	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE-OFF IN. LBS.
6	7/32	10-32UNJF-3B	.400 .390	.120 .110	.295	.226	.465	.290	.415 .395	.414	.23	.378 .365	.122	4,000	40-50
8	9/32	1/4-28UNJF-3B	.505 .495	.170 .160	.370	.289	.565	.355	.480 .460	.484	.26	.440 .425	.127	7,500	115-130
10	11/32	5/16-24UNJF-3B	.645 .635	.170 .160	.453	.352	.675	.445	.600 .580	.484	.34	.440 .425	.137	11,750	200-250
12	13/32	3/8-24UNJF-3B	.825 .815	.185 .175	.526	.416	.740	.485	.660 .640	.557	.38	.503 .488	.137	18,000	360-440
14	15/32	7/16-20UNJF-3B	.935 .925	.225 .215	.605	.479	.865	.575	.750 .730	.624	.45	.565 .550	.152	23,750	525-600
16	17/32	1/2-20UNJF-3B	1.045 1.035	.255 .245	.685	.542	.955	.625	.820 .800	.763	.51	.690 .675	.152	30,000	725-825
18	19/32	9/16-18UNJF-3B	1.185 1.175	.270 .260	.807	.610	1.055	.700	.920 .900	.970	.71	.878 .861	.165	39,000	950-1075

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions apply after finish.
 3. For use on sloped surfaces up to 7° maximum.

MATERIAL: Collar - 17-4PH stainless steel per AMS5643.
 Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

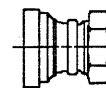
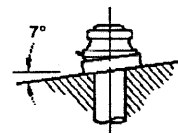
HEAT TREAT: Collar - Age to H-1025 condition per MIL-H-6875.
 Washer - Age to H-1025 condition for 17-4PH, age to TH-1050 condition for 17-7PH and 15-7Mo per MIL-H-6875.

FINISH: Collar - HL289-()A = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL289N-()A = Diffused nickel-cadmium plate per AMS2416 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL289PB-()A = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL289DU-()A = Solid film lube per MIL-L-46010, Type I.
 HL289LP-()A = Solid film lube per MIL-L-46010, Type II.
 HL289YL-()A = Solid film lube per MIL-L-46010, Type II and yellow paint.
 Washer - HL289-()GW = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL289-()DW = Solid film lube per MIL-L-46010, Type I.
 HL289-()NW = Diffused nickel-cadmium plate per AMS2416 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL289-()LPW = Solid film lube per MIL-L-46010, Type II.
 HL289-()PBW = Cadmium plate per QQ-P-416, Type II, Class 2.

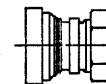
SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 345.

CODE: Dash number indicates nominal thread size in 1/32nds.
 See Finish note for explanation of code letters.

EXAMPLE: HL289-8AGW = Assembly of HL289-8A collar and HL289-8GW washer.
 HL289DU-8ADW = Assembly of HL289DU-8A collar and HL289-8DW washer.
 HL289LP-8ALPW = Assembly of HL289LP-8A collar and HL289-8LPW washer.



VOI-SHAN
 1 raised bead indicates
 VOI-SHAN identification



STANDARD PRESSED STEEL
 2 raised beads indicate
 STANDARD PRESSED STEEL
 identification

"Hi-Lok", "HL", "Hi-Tigue", and "HLT" are internationally registered trademarks of Hi-Shear Corporation.

DRAWN	DATE	BY	TITLE	DRAWING NUMBER
	3-1-72	VAN		
APPROVED	3-2-72	R. Ting	HI-LOK® COLLAR SELF-ALIGNING COLLAR ASSEMBLY 17-4PH STAINLESS STEEL 1/16" GRIP VARIATION, TENSION APPLICATION FOR USE ON 1/32" OVERSIZE HI-LOK PINS	HL289
⑤ REVISION	3-27-95	J.F.Obispo		