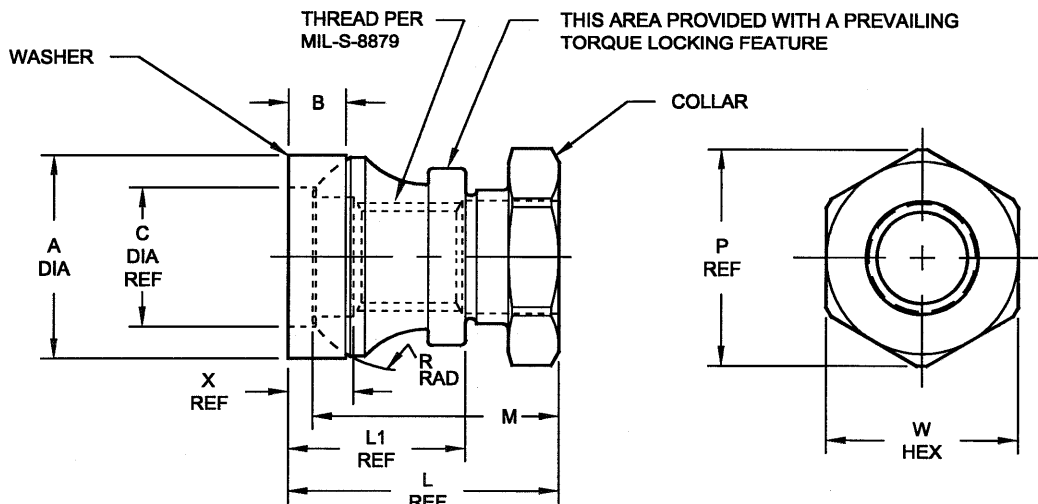


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2800 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. 08725
 HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 58676
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 80516
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0LB68
 a GFI AEROSPACE Company
 HUCK S.A. France (Licensee - ECC Countries)
 BLANC 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	C DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER. RAD	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
6	7/32	10-32UNJF-3B	.400 .390	.120 .110	.295	.465	.290	.415 .395	.380	.23	.346 .332	.122	2,750	40-50
8	9/32	1/4-28UNJF-3B	.505 .495	.170 .160	.370	.565	.355	.480 .460	.484	.26	.440 .425	.127	5,000	115-130
10	11/32	5/16-24UNJF-3B	.645 .635	.170 .160	.453	.675	.445	.600 .580	.484	.34	.440 .425	.137	8,300	200-250
12	13/32	3/8-24UNJF-3B	.825 .815	.185 .175	.528	.740	.485	.660 .640	.557	.38	.503 .488	.137	12,700	360-440
14	15/32	7/16-20UNJF-3B	.935 .925	.225 .215	.605	.865	.575	.750 .730	.624	.45	.565 .550	.152	19,000	550-825
16	17/32	1/2-20UNJF-3B	1.045 1.035	.255 .245	.685	.955	.625	.820 .800	.763	.51	.690 .675	.152	25,500	725-825
18	19/32	9/16-18UNJF-3B	1.185 1.175	.270 .260	.807	1.055	.700	.920 .900	.970	.71	.878 .861	.165	32,400	950-1075

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

MATERIAL: Collar - Type 303 Se stainless steel per ASTM A582 (AMS5640), 110-140 ksi UTS.
 Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

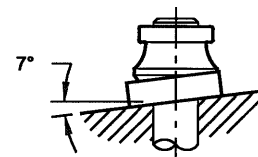
HEAT TREAT: Collar - None.
 Washer - Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per MIL-H-6875.

FINISH: Collar - HL375-()JA = Cadmium plate per QQ-P-416, Type I, Class 2, with cetyl alcohol lube per Hi-Shear Spec. 305.
 HL375DK()JA = Kalgard FA, special cure for vacuum compatibility.
 HL375DU()JA = Solid film lube per MIL-L-46010, Type I.
 HL375G()JA = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL375TF()JA = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
 HL375V()JA = Solid film lube per "Lubeco" 2123.
 Washer - HL375-()DKW = Kalgard FA, special cure for vacuum compatibility.
 HL375-()DW = Solid film lube per MIL-L-46010, Type I.
 HL375-()GW = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL375-()KW = Solid film lube per "Lubeco" 905.
 HL375-()VW = Solid film lube per "Lubeco" 2123.
 HL375-()JW = Cadmium plate per QQ-P-416, Type I, Class 2.
 HL375-()JU = Passivate per Hi-Shear Spec. 258.

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: HL375-8AW = Assembly of HL375-8A collar and HL375-8W washer.
 HL375V-8AVW = Assembly of HL375V-8A collar and HL375-8VW washer.



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

DATE	BY	TITLE	DRAWING NO.
DRAWN 12-8-72	VAN	HI-LOK® COLLAR	HL375
APPROVED 12-21-72	R.Ting	SELF-ALIGNING COLLAR ASSEMBLY	
8 REVISION 3-8-00	J.F.Obispo	303 STAINLESS STEEL	
		1/16" GRIP VARIATION, TENSION APPLICATION	
		FOR USE ON 1/32" OVERSIZE HI-LOK PINS	