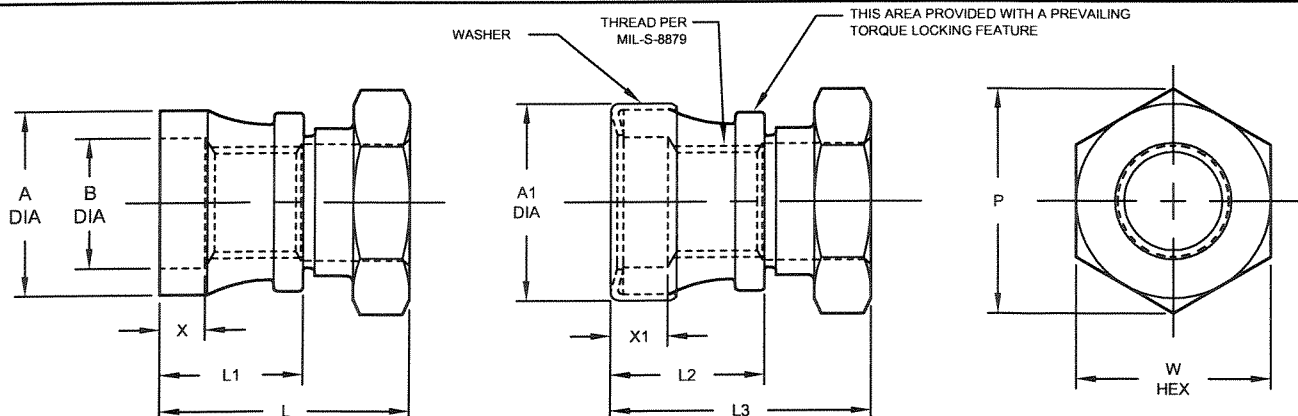


STANDARDS COMMITTEE FOR HI-LOK[®] PRODUCTS

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. 97828
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)

BLANC AERO INDUSTRIES UK LIMITED (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	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.287 .283	.320	.179 .166	.447 .427	.265	.280	.460	.344	.314 .302	.118	.138	3,050	30-40
6	3/16	10-32UNJF-3B	.307 .303	.340	.205 .192	.457 .437	.275	.290	.470	.344	.314 .302	.118	.138	4,000	40-50
8	1/4	1/4-28UNJF-3B	.413 .407	.445	.265 .252	.552 .532	.340	.355	.565	.380	.346 .332	.127	.147	7,500	115-130
10	5/16	5/16-24UNJF-3B	.518 .512	.550	.330 .314	.672 .652	.430	.445	.685	.484	.440 .425	.139	.164	11,750	200-250
12	3/8	3/8-24UNJF-3B	.628 .622	.660	.393 .376	.744 .724	.475	.490	.755	.557	.503 .488	.139	.167	18,000	360-420
14	7/16	7/16-20UNJF-3B	.733 .727	.765	.456 .439	.862 .842	.560	.575	.875	.840	.753 .736	.157	.185	23,750	525-675
16	1/2	1/2-20UNJF-3B	.848 .842	.880	.519 .501	.942 .922	.610	.625	.955	.970	.878 .861	.157	.185	30,000	725-1000
18	9/16	9/16-18UNJF-3B	.915 .905	.910	.582 .570	1.029 1.009	.670	.685	1.042	.970	.878 .861	.171	.200	39,000	1000-1250
20	5/8	5/8-18UNJF-3B	.995 .985	1.040	.650 .634	1.123 1.103	.735	.750	1.136	1.120	1.003 .986	.171	.200	49,000	1350-1550
24	3/4	3/4-16UNJF-3B	1.120 1.110	1.140	.776 .762	1.371 1.351	.940	.955	1.384	1.240	1.128 1.110	.188	.215	70,000	1900-2200
28	7/8	7/8-14UNJF-3B	1.345 1.335	1.365	.902 .887	1.575 1.545	1.060	1.075	1.584	1.520	1.380 1.356	.205	.240	95,000	3200-3600
32	1	1-12UNJF-3B	1.490 1.480	1.510	1.030 1.015	1.840 1.810	1.225	1.240	1.849	1.650	1.504 1.480	.229	.265	124,000	4500-5000

NOTES:

1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. Dimensions apply after plating and before solid film lube where applicable.
3. Use HL273 for oversize replacement.

MATERIAL:

- Collar - 17-4PH stainless steel per AMS5643.
Washer - 300 series stainless steel (.010 thick).

HEAT TREAT:

- Collar - To condition H1025 per AMS-H-6875.

FINISH:

- Collar - HL73() = Silver plate per AMS2410, dye color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL73DU() = Solid film lube per AS5272, Type I.
HL73DY() = Solid film lube per AS5272, Type I, plus yellow identification on body of collar.
HL73LP() = Solid film lube per AS5272, Type II.
HL73PB() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL73V() = Solid film lubricant per Lubeco 2123.
- Collar & Washer - HL73DUW() = Both with solid film lube per AS5272, Type I.
HL73DYW() = Both with solid film lube per AS5272, Type I.
HL73VW() = Both with Lubeco 2123 solid film lubricant.
HL73W() = Collar same as HL73() and washer is passivate.
HL73VW() = Collar same as HL73() and washer is 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.

EXAMPLES:

- HL73-8 = 1/4-28 Hi-Lok collar.
HL73W8 = 1/4-28 Hi-Lok collar with washer.

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

DATE	BY	TITLE	DRAWING NO.
DRAWN	4-24-61	DGF	HL73
APPROVED	4-24-61	MEC	
REVISION	8-29-02	J.F.Obispo	
27			