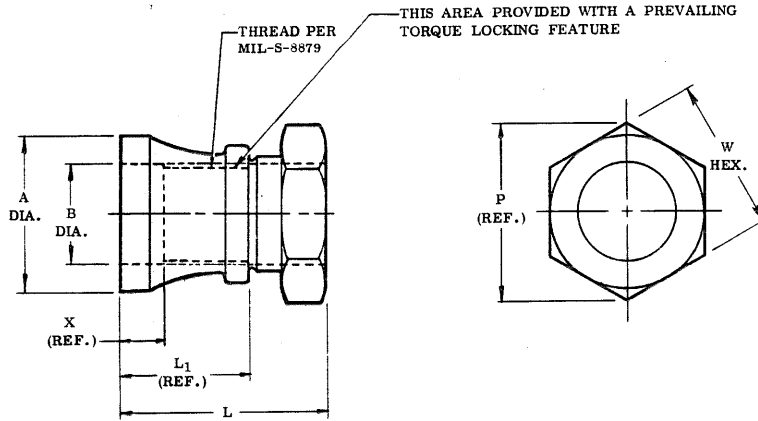


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197	HI-SHEAR FASTENERS EUROPE LTD. U.K. (Licensee)
Division of Hi-Shear Industries Inc. U.S.A. (Licensee)	Division of Hi-Shear Industries Inc. U.S.A. (Licensee-EEC Countries)
AIA INDUSTRIES CO. INC. (Licensee) U.S. Federal Code I.D. No. 06725	KAMAZ-WERKE Germany (Licensee-EEC Countries)
DEUTSCH FASTENER CO., INC. (Licensee) U.S. Federal Code I.D. No. 87928	Rudolph Kammann GmbH & Co. (Licensee-EEC Countries)
SPI TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 86078	ST. CHAMOND (FRANCE), S.A. France (Licensee-EEC Countries)
VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215	SIMMONDS S.A. France (Licensee-EEC Countries)
WEST COAST AEROSPACE INC., U.S.A. (Licensee) U.S. Federal Code I.D. No. 60516	(Licensee)
(Pat. & Steel Collars)	TOKYO SCREW COMPANY, Japan (Licensee-Japan)



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B DIA.		L	L1 (REF.)			P (REF.)		W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE OFF IN. LBS.
-6	7/32	10-32UNJF-3B	.332 .328	.227 .223		.470 .450	.290			.380		.346 .332	.122	2,500	25-35
-8	9/32	1/4-28UNJF-3B	.427 .423	.290 .286		.565 .545	.355			.484		.440 .425	.127	4,300	60-80
-10	11/32	5/16-24UNJF-3B	.560 .554	.356 .350		.685 .665	.445			.624		.565 .550	.137	6,300	130-160
-12	13/32	3/8-24UNJF-3B	.683 .675	.419 .413		.755 .735	.485			.763		.690 .675	.137	8,700	200-240
-14	15/32	7/16-20UNJF-3B	.748 .740	.481 .475		.875 .855	.575			.840		.753 .736	.152	12,100	270-330
-16	17/32	1/2-20UNJF-3B	.870 .860	.543 .537		.955 .935	.625			.970		.878 .861	.152	15,300	370-430
-18	19/32	9/16-18UNJF-3B	.925 .915	.613 .607		1.060 1.040	.700			1.120		.941 .924	.165	20,500	500-575
⑩ -20	21/32	5/8-18UNJF-3B	1.000 .990	.678 .672		1.150 1.130	.755			1.120		1.003 .986	.165	25,700	625-700
⑩ -24	23/32	3/4-16UNJF-3B	1.185 1.175	.803 .797		1.400 1.380	.965			1.240		1.128 1.110	.176	37,300	900-1000

NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. Dimensions apply after finish.

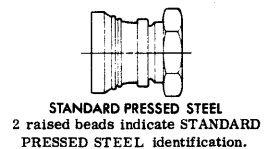
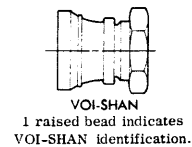
MATERIAL: A-286 high temperature alloy per AMS5731, AMS5734 or AMS5736.

FINISH: HL197-() = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL197D-() = Solid film lube per MIL-L-8937.
HL197DJ-() = Solid film lube per MIL-L-8937 plus green identification on body of collar.
HL197DU-() = Solid film lube per MIL-L-8937 plus yellow MIL-P-23377 identification on body of collar.
HL197EG-() = Solid film lube per "Everlube" 820.
HL197K-() = Solid film lubricant per "Lubeco" 905.
HL197KG-() = Cadmium plate per QQ-P-416, Type II, Class 2, color green, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL197PB-() = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL197TF-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
HL197V-() = Solid film lubricant 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 other code letters.

EXAMPLE: HL197K-8 = 1/4-28 Hi-Lok oversize collar, finish is "Lubeco" 905.



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

DRAWN	DATE	BY	TITLE	DRAWING NUMBER
	3-31-66	Brlj		
CHECKED	3-31-66	Miller	hi-Lok® COLLAR A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION - SHEAR APPLICATION FOR USE ON 1/32" OVERSIZE HI-LOK PINS	HL197
⑩ REVISION	5-26-89	D. P. S.		