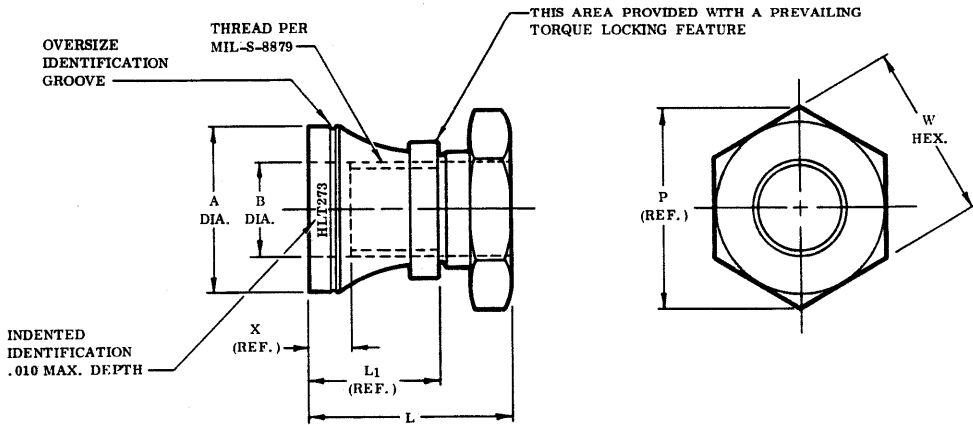


**STANDARDS COMMITTEE  
FOR HI-LOK® HI-TIGUE® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197  
 A Subsidiary of GFI Industries, France  
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S. & Canada) CAGE No. 08725  
 HUCK INTERNATIONAL, INC., Deutschl. Operation, U.S.A. (Licensee) CAGE No. 87928  
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 88879  
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 82216  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 80516  
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) - CAGE No. 0L888  
 A Subsidiary of GFI Industries, France  
 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 DIA.	L LENGTH	L <sub>1</sub> (REF.)	P (REF.)	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE-OFF INCH - LB.
6	7/32	10-32UNJF-3B	.337 .333	.228 .224	.485 .465	.305	.380	.346 .332	.149	4,000	40-50
8	9/32	1/4-28UNJF-3B	.430 .426	.291 .287	.580 .560	.370	.484	.440 .425	.163	7,500	115-130
10	11/32	5/16-24UNJF-3B	.560 .554	.355 .349	.710 .690	.470	.557	.503 .488	.181	11,750	200-250
12	13/32	3/8-24UNJF-3B	.670 .664	.419 .413	.780 .760	.510	.624	.565 .450	.181	18,000	360-420
14	15/32	7/16-20UNJF-3B	.770 .764	.482 .476	.900 .880	.600	.840	.753 .736	.207	23,750	525-675
16	17/32	1/2-20UNJF-3B	.870 .864	.545 .539	.980 .960	.650	.970	.878 .861	.207	30,000	725-1000
18	19/32	9/16-18UNJF-3B	.935 .925	.613 .607	1.080 1.060	.720	.970	.878 .861	.227	39,000	1000-1300
20	21/32	5/8-18UNJF-3B	1.005 ①.995	.678 .672	1.165 1.145	.775	1.120	1.003 .986	.227	49,000	1350-1550
24	25/32	3/4-16UNJF-3B	1.160 1.150	.803 .797	1.410 1.390	.975	1.240	1.128 1.110	.250	70,000	1900-2200
28	29/32	7/8-14UNJF-3B	1.360 1.350	.929 .923	1.620 1.600	1.110	1.450	1.315 1.292	.277	95,000	3200-3600
32	1-1/32	1-12UNJF-3B	1.530 1.520	1.055 1.049	1.900 1.880	1.290	1.650	1.504 1.480	.312	124,000	4500-5000

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
  - Dimensions apply after finish.
  - Oversize collar for HLT73.

**MATERIAL:** 17-4PH stainless steel per AMS5643.

**HEAT TREAT:** To condition H1025 per MIL-H-6875.

**⑦ FINISH:** HLT273-( ) = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HLT273DU( ) = Solid film lube per AS5272 Type I.  
 HLT273LP( ) = Solid film lube per AS5272 Type II.  
 HLT273PB( ) = Cadmium plate per QQ-P416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

**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:** HLT273-8 = 1/4-28 Hi-Tigue Collar with silver plate.

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

			TITLE	DRAWING NUMBER
DATE	BY		<b>HI-LOK® HI-TIGUE® COLLAR</b>  17-4PH STAINLESS STEEL 1/16" GRIP VARIATION - TENSION APPLICATION FOR USE ON 1/64" AND 1/32" OVERSIZE HI-TIGUE PINS	<b>HLT273</b>
DRAWN	9-23-69	Van		
APPROVED	9-23-69	JGWilcox		
⑦ REVISION	9-24-97	J.Henderson		