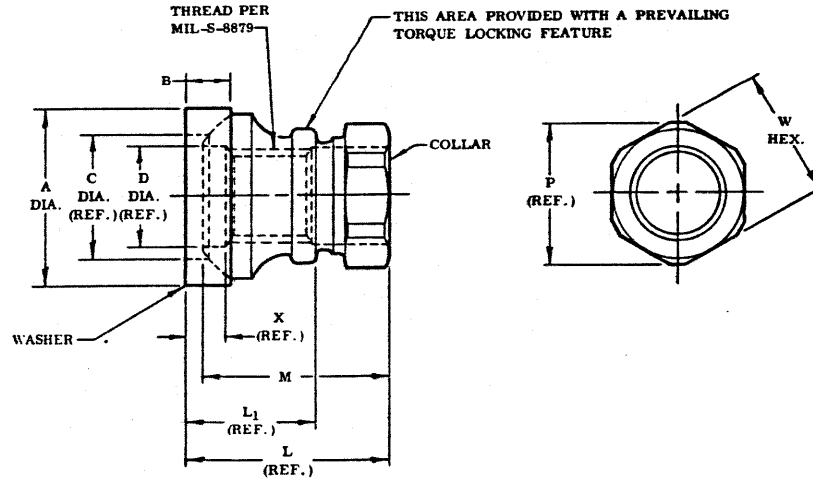


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) — CAGE No. 78197
 Division of Hi-Shear Industries Inc., U.S.A.
 AIR INDUSTRIES CO., INC. U.S.A. (Licensee - U.S. & Canada) — CAGE No. 06725
 HUCK INTERNATIONAL, INC., Deutch Operation, U.S.A. (Licensee) — CAGE No. 97928
 SPS TECHNOLOGIES, U.S.A. (Licensee) — CAGE No. 96878
 FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) — CAGE No. 92216
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) — CAGE No. 00518
 (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 LENGTH	L (REF.)	M (REF.)	P (REF.)	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE-OFF IN. LBS.
6	7/32	10-32UNJF-3B	.400 .390	.120 .110	.295	.226	.485 .465	.305	.408	.380	.346 .332	.149	4,000	40 - 50
8	9/32	1/4-28UNJF-3B	.505 .495	.170 .160	.370	.289	.580 .560	.370	.490	.380	.346 .332	.163	7,500	115 - 130
10	11/32	5/16-24UNJF-3B	.645 .635	.170 .160	.453	.352	.710 .690	.470	.613	.484	.440 .425	.181	11,750	200 - 250
12	13/32	3/8-24UNJF-3B	.825 .815	.185 .175	.526	.416	.780 .760	.510	.673	.557	.503 .488	.181	18,000	360 - 440
14	15/32	7/16-20UNJF-3B	.935 .925	.225 .215	.605	.479	.900 .880	.600	.762	.840	.753 .736	.207	23,750	550 - 625
16	17/32	1/2-20UNJF-3B	1.045 1.035	.255 .245	.685	.542	.980 .960	.650	.833	.970	.878 .861	.207	32,000	725 - 825
18	19/32	9/16-18UNJF-3B	1.185 1.175	.270 .260	.808	.610	1.080 1.060	.720	.928	.970	.878 .861	.227	39,000	850 - 1075
20	21/32	5/8-18UNJF-3B	1.375 1.360	.315 .305	.870	.695	1.300 1.270	.900	1.155	1.120	1.003 .986	.227	49,000	1350 - 1550

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
 - Dimensions apply after finish.
 - 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 TH1050 condition for 17-7PH and 15-7Mo per MIL-H-6875.

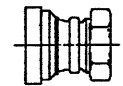
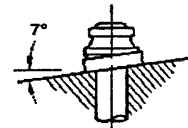
FINISH: Collar - HLT274-()A = Silver plate per AMS2410, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT274DU-()A = Solid film lube per MIL-L-46010, Type I.
 HLT274LP-()A = Solid film lube per MIL-L-46010, Type II.
 Washer - HLT274-()W = Cadmium plate per QQ-P-416, Type II, Class 2.
 HLT274-()DUW = Solid film lube per MIL-L-46010, Type I.
 HLT274-()GW = Silver plate per AMS2410.

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

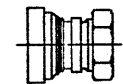
CODE: Dash number indicates nominal thread size in 1/32nds.
 See Finish note for explanation of code letters.

EXAMPLE: HLT274DU-8AGW = Assembly of HLT274DU-8A collar and HLT274-8GW washer, both silver plated.
 HLT274LP-8AW = Assembly of HLT274LP-8A collar and HLT274-8W washer.

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



VOI-SHAN
 1 raised bead indicates VOI-SHAN identification



STANDARD PRESSED STEEL
 2 raised beads indicate STANDARD PRESSED STEEL identification

			TITLE	DRAWING NUMBER
DRAWN	DATE	BY	HI-LOK® HI-TIGUE™ COLLAR SELF-ALIGNING COLLAR ASSEMBLY 17-4PH STAINLESS STEEL 1/16" GRIP VARIATION - TENSION APPLICATION FOR USE ON 1/64" AND 1/32" OVERSIZE HI-TIGUE PINS	HLT274
APPROVED	10-3-69	VAN		
REVISION	10-3-69	R. Ting		
6	3-23-95	J.F.Obispo		