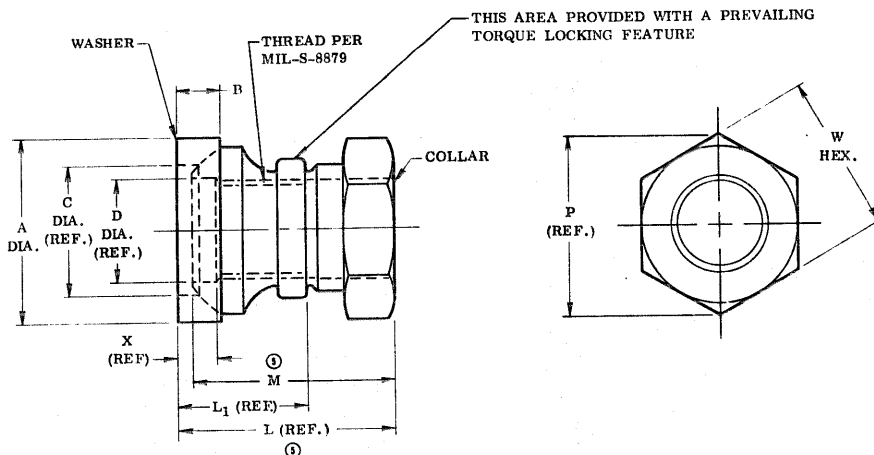


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

① HI-SHEAR CORPORATION, U.S.A. (Patent Holder) — U.S. Federal Code I.D. No. 73197
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee)
 AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee)
 VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) — U.S. Federal Code I.D. No. 92215
 SPS TECHNOLOGIES, U.S.A. (Licensee) — U.S. Federal Code I.D. No. 95378

ST. CHAMOND-GRANAT, S.A. France (Licensee—EEC Countries)
 KAMAX-WERKE, Germany (Licensee—EEC Countries)
 Rudolph Kellerman GmbH & Co. (Licensee—EEC Countries—Collars)
 SIMMONDS, S.A. France (Licensee—EEC Countries—Collars)
 TOKYO SCREW COMPANY, Japan (Licensee—Japan)
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Stair Collars)
 U.S. Federal Code I.D. No. 60516



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B	C DIA. (REF.)	D DIA. (REF.)	L (REF.)	L ₁ (REF.)	M	P (REF.)	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE-OFF IN.-LBS.
-6	7/32"	10-32UNJF-3B	.400 .390	.145 .135	.305	.226	.505	.330	.418 .398	.380	.346 .332	.149	2,750	40-50
-8	9/32"	1/4-28UNJF-3B	.505 .495	.205 .195	.385	.289	.695	.400	.492 .472	.484	.440 .425	.163	5,000	115-130
-10	11/32"	5/16-24UNJF-3B	.645 .635	.210 .200	.465	.352	.730	.500	.610 .590	.484	.440 .425	.181	8,300	200-250
-12	13/32"	3/8-24UNJF-3B	.715 .705	.230 .220	.540	.416	.800	.545	.660 .640	.557	.503 .488	.181	12,700	360-440
-14	15/32"	7/16-20UNJF-3B	.835 .825	.280 .270	.625	.479	.935	.645	.753 .733	.624	.565 .550	.207	19,000	525-625
-16	17/32"	1/2-20UNJF-3B	.945 .935	.310 .300	.705	.542	1.015	.705	.833 .813	.763	.690 .675	.207	25,500	725-825
-18	19/32"	9/16-18UNJF-3B	1.185 1.175	.335 .325	.830	.610	1.125	.785	.930 .910	.970	.878 .861	.227	29,000	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 QQ-5-764.
 Washer — 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

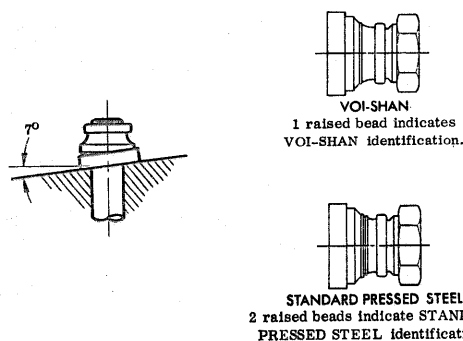
HEAT TREAT: Collar — None.
 Washer — Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and 15-7Mo per MIL-H-6875.

FINISH: Collar — HLT288-()A = Cadmium plate per QQ-P-416, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT288LP-()A = Solid film lube per MIL-L-46010.
 Washer — HLT288-()W = Cadmium plate per QQ-P-416, Type II, Class 3.

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

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

EXAMPLE: HLT288-8AW = Assembly of HLT288-8A Collar and HLT288-8W Washer.
 HLT288LP-8AW = Assembly of HLT288LP-8A Collar and HLT288-8W Washer.



U.S. patents 3,390,906; and foreign patents.
 "Hi-Lok" and "Hi-Tigue" are Registered Trademarks of Hi-Shear Corporation.

	DATE	BY
DRAWN	10-3-69	Van
APPROVED	10-6-69	SAWYER K. TING
⑤ REVISION	6-21-85	D. P. S.

TITLE

hi-lok® hi-tigue® COLLAR

SELF-ALIGNING COLLAR ASSEMBLY
 303 STAINLESS STEEL
 1/16" GRIP VARIATION — TENSION APPLICATION
 FOR USE ON 1/64" AND 1/32" OVERSIZE HI-TIGUE PINS

DRAWING NUMBER

HLT288