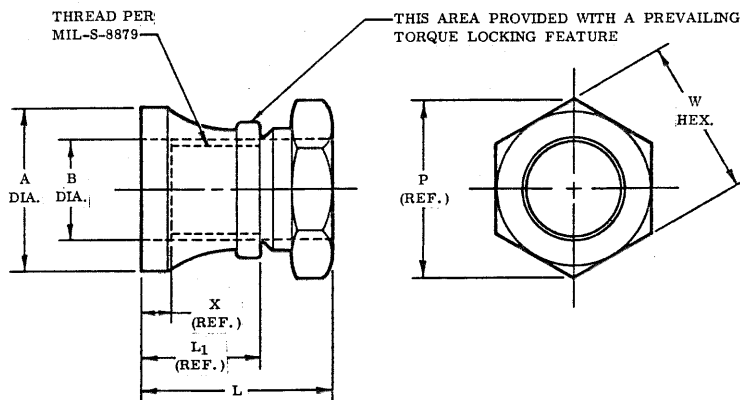


**STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION (Patent Holder) — Federal Code Ident. No. 73197  
VOI-SHAN DIV., VSI CORP. (Licensee) — Federal Code Ident. No. 92215  
STANDARD PRESSED STEEL CO. (Licensee) — Federal Code Ident. No. 56878



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B DIA.	L	L <sub>1</sub> (REF.)	P (REF.)	W HEX.	X (REF.)	UTS. LBS. MIN.	TORQUE OFF IN. LBS.
-5	5/32"	8-32UNJC-3B		① USE HLT77-5							
-6	3/16"	10-32UNJF-3B		① USE HLT77-6							
-8	1/4"	1/4-28UNJF-3B		① USE HLT77-8 OR HLT477-8							
-10	5/16"	5/16-24UNJF-3B		① USE HLT77-10							
-12	3/8"	3/8-24UNJF-3B		① USE HLT77-12							
-14	7/16"	7/16-20UNJF-3B		① USE HLT77-14							
-16	1/2"	1/2-20UNJF-3B		① USE HLT77-16							
-18	9/16"	9/16-18UNJF-3B		① USE HLT77-18							
-20	5/8"	5/8-18UNJF-3B		① USE HLT77-20							
-24	3/4"	3/4-16UNJF-3B	1.105 1.095	.776 .770	1.371 1.351	.970	1.240	1.128 1.110	.188	27,500	900-1000
-28	7/8"	7/8-14UNJF-3B	1.295 1.285	.902 .896	1.571 1.551	1.105	1.450	1.315 1.292	.205	37,500	1200-1325
-32	1"	1-12UNJF-3B	1.475 1.465	1.030 1.024	1.836 1.816	1.275	1.650	1.504 1.480	.229	50,000	1450-1600

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.  
2. Dimensions apply after finish.  
① 3. Use HLT270 or HLT277 for oversize replacement.

MATERIAL: 2024 aluminum alloy per QQ-A-430 or QQ-A-225/6.

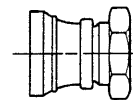
HEAT TREAT: Age to T6 condition per MIL-H-6088.

FINISH: HLT70-( ) = Anodize per MIL-A-8625, dye color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HLT70LP-( ) = Anodize per MIL-A-8625, color natural, and solid film lube per MIL-L-46010.

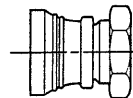
SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 345.

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

① EXAMPLE: HLT70-8 = 1/4-28 Hi-Tigue Collar with cetyl alcohol lube.



VOI-SHAN  
1 raised bead indicates VOI-SHAN identification.



STANDARD PRESSED STEEL  
2 raised beads indicate STANDARD PRESSED STEEL identification.

U.S. patents 2,882,773; 2,947,491; 2,940,495; 3,027,789; 3,138,987; 3,578,367; design patent 191,883; other U.S. and Foreign patents granted and pending; property of Hi-Shear Corporation. "Hi-Lok" and "Hi-Tigue" are Registered Trademarks of Hi-Shear Corporation.

	DATE	BY
DRAWN	2-27-69	VQR
CHECKED	2-27-69	Don Miller
① REVISION	6-19-73	VQR

TITLE

**hi-lok® hi-tigue® COLLAR**

2024-T6 ALUMINUM ALLOY  
1/16" GRIP VARIATION — SHEAR APPLICATION

DRAWING NUMBER
<b>HLT70</b>