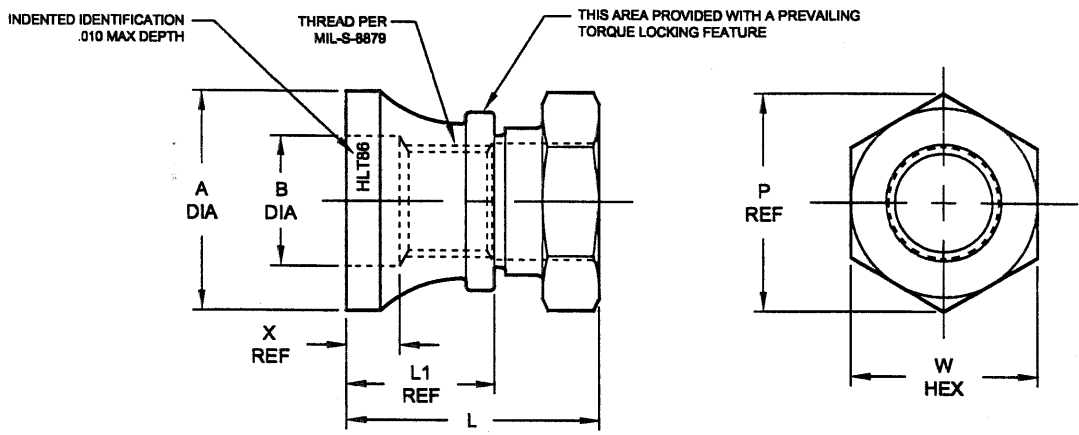


STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
 a GFI AEROSPACE Company
 AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 08725
 HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928
 SP8 TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 60678
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60615
 (Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 01868
 a GFI AEROSPACE Company
 HUCK S.A. France (Licensee - ECC Countries)
 BLANC AERD S.A. France (Licensee - ECC Countries)
 a GFI AEROSPACE Company
 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 INCH-POUNDS
5	5/32	8-32UNJC-3B	.287 .283	.179 .175	.447 .427	.265	.344	.314 .302	.118	2,300	30-40
6	3/16	10-32UNJF-3B	.307 .303	.205 .201	.457 .437	.275	.344	.314 .302	.118	2,750	40-50
8	1/4	1/4-28UNJF-3B	.412 .408	.265 .261	.552 .532	.340	.380	.346 .332	.127	5,000	110-130
10	5/16	5/16-24UNJF-3B	.518 .512	.330 .324	.672 .652	.430	.484	.440 .425	.139	8,300	200-250
12	3/8	3/8-24UNJF-3B	.628 .622	.393 .387	.744 .724	.475	.557	.503 .488	.139	12,700	360-420
14	7/16	7/16-20UNJF-3B	.733 .727	.463 .450	.862 .842	.560	.840	.753 .736	.157	19,000	525-675
16	1/2	1/2-20UNJF-3B	.848 .842	.528 .513	.942 .922	.610	.970	.878 .861	.157	25,000	725-1000
18	9/16	9/16-18UNJF-3B	.915 .905	.598 .576	1.029 1.009	.670	.970	.878 .861	.171	29,000	1000-1150
20	5/8	5/8-18UNJF-3B	.995 .985	.661 .644	1.123 1.103	.735	1.120	1.003 .986	.171	32,000	1350-1550
24	3/4	3/4-16UNJF-3B	1.120 1.110	.788 .770	1.371 1.351	.940	1.240	1.128 1.110	.188	42,000	1900-2200
28	7/8	7/8-14UNJF-3B	1.345 1.335	.911 .896	1.575 1.545	1.060	1.520	1.380 1.356	.205	62,000	3200-3600
32	1	1-12UNJF-3B	1.490 1.480	1.036 1.024	1.840 1.810	1.225	1.650	1.504 1.480	.229	84,000	4500-5000

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions apply after finish.
 3. Use HLT286 for oversize replacement.
 4. Use HLT73 or HLT89 for higher tension application.

MATERIAL: Type 303 Se stainless steel per ASTM A 582 and AMS5640.

- FINISH:**
- HLT86() = Cadmium plate per QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT86PB() = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HLT86LP() = Solid film lube per AS5272, Type II.
 - HLT86TB() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 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: HLT86-8 = 1/4-28 Hi-Tigue Collar with cadmium plate Type I, Class 2 and cetyl alcohol lube.

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

DATE	BY	TITLE	DRAWING NO.
DRAWN 3-3-69	Van	HI-LOK® HI-TIGUE® COLLAR TYPE 303 Se STAINLESS STEEL 1/16" GRIP VARIATION, TENSION APPLICATION	HLT86
APPROVED 3-14-69	V. Miller		
7 REVISION 3-16-00	J.F. Obispo		