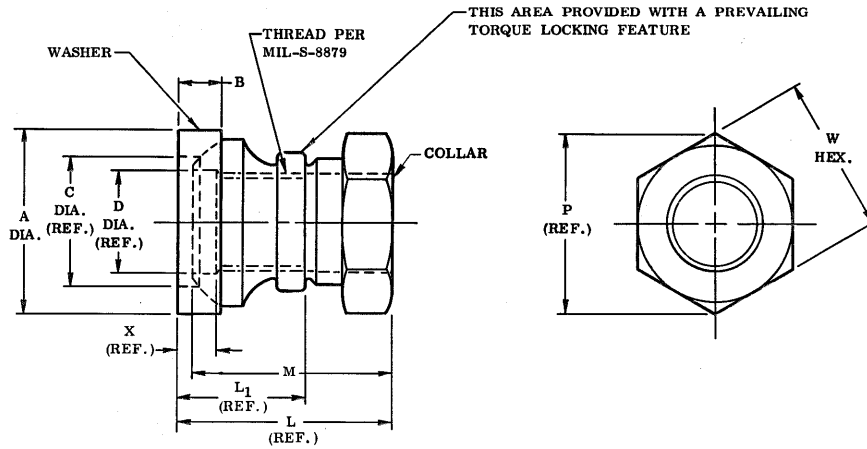


**STANDARDS COMMITTEE FOR HI-LOK® HI-TIGUE® PRODUCTS**  
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

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.  
AIRCRAFT FASTENERS (Forged Parts) LTD., U.K. (Licensee)  
Division of Hi-Shear Industries Inc., U.S.A.  
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. 56878

ST. CHAMOND-GRANAT, S.A. France (Licensee—EEC Countries)  
KAMAX-WERKE, Germany (Licensee—EEC Countries)  
Rudolph Kellerman GmbH & Co. (Licensee—EEC Countries—Collars)  
SIRMINDS, S.A. France (Licensee—EEC Countries—Collars)  
TOKYO SCREW COMPANY, Japan (Licensee—Japan)  
WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Steel 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 <sub>1</sub> (REF.)	M	P (REF.)	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE OFF IN. LBS.
-5	5/32	8-32UNJC-3B	.365 .355	.105 .095	.235	.184	.455	.290	.420 .400	.380	.346 .322	.118	2,300	22-32
-6	3/16	10-32UNJF-3B	.365 .355	.105 .095	.261	.210	.455	.290	.420 .400	.380	.346 .322	.118	2,750	32-42
-8	1/4	1/4-28UNJF-3B	.475 .465	.135 .125	.339	.270	.555	.355	.510 .490	.380	.346 .322	.127	5,000	75-90
-10	5/16	5/16-24UNJF-3B	.620 .600	.145 .135	.423	.333	.675	.445	.617 .597	.484	.440 .425	.139	8,300	140-170
-12	3/8	3/8-24UNJF-3B	.685 .675	.160 .150	.496	.395	.745	.485	.677 .657	.557	.503 .488	.139	12,700	210-260
-14	7/16	7/16-20UNJF-3B	.805 .795	.210 .200	.575	.456	.885	.592	.772 .752	.840	.753 .736	.157	19,000	310-370
-16	1/2	1/2-20UNJF-3B	.915 .905	.235 .225	.654	.518	.955	.642	.842 .822	.970	.878 .861	.157	25,500	410-470
-18	9/16	9/16-18UNJF-3B	1.125 1.115	.270 .260	.763	.592	1.050	.700	.960 .940	.970	.878 .861	.171	29,000	575-650
-20	5/8	5/8-18UNJF-3A	1.305 1.290	.315 .305	.855	.647	1.145	.765	1.035 1.015	1.120	1.003 .986	.171	32,000	700-775

- NOTES:
- Go thread gage penetration shall be 3/4 of one revolution minimum.
  - For use on sloped surfaces up to 7° maximum on standard Hi-Lok Hi-Tigue pins.
  - Dimensions apply after finish.
  - Use HLT295 for oversize replacement.

MATERIAL: Collar — Type 303 Se stainless steel per AMS 5640 and ASTM A582.  
Washer — "W" — 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

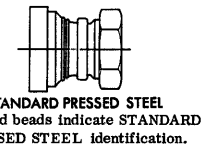
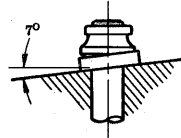
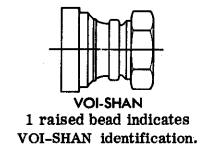
HEAT TREAT: Collar — None.  
Washer — "W" — Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and 15-7Mo per MIL-H-6875.  
"C" — 90,000 psi shear minimum.

FINISH: Collar — HLT95-( )A = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HLT95LP-( )A = Solid film lube per MIL-L-46010.  
Washer — HLT95-( )W = Cadmium plate per QQ-P-416, Type II, Class 2.  
HLT95-( )LPW = Solid film lube per MIL-L-46010.  
HLT95-( )C = Passivate per Hi-Shear Spec. 258 and cetyl alcohol per Hi-Shear Spec. 305.

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: HLT95-8AW = Assembly of HLT95-8A Collar and HLT95-8W Washer.  
HLT95LP-8ALPW = Assembly of HLT95LP-8A Collar and HLT95-8LPW Washer.  
HLT95-8AC = Assembly of HLT95-8A Collar and HLT95-8C Washer.



U.S. Patent 3,578,367 and international patents. "HL", "Hi-Lok", "HLT", and "Hi-Tigue" are internationally registered trademarks of Hi-Shear Corporation.

	DATE	BY
DRAWN	1-26-70	Van
APPROVED	1-26-70	SBW/ELC
REVISION	8-5-86	D. P. S.

hi-lok® hi-tigue® COLLAR  
SELF-ALIGNING COLLAR ASSEMBLY  
303 STAINLESS STEEL  
1/16" GRIP VARIATION — SHEAR APPLICATION

DRAWING NUMBER  
**HLT95**