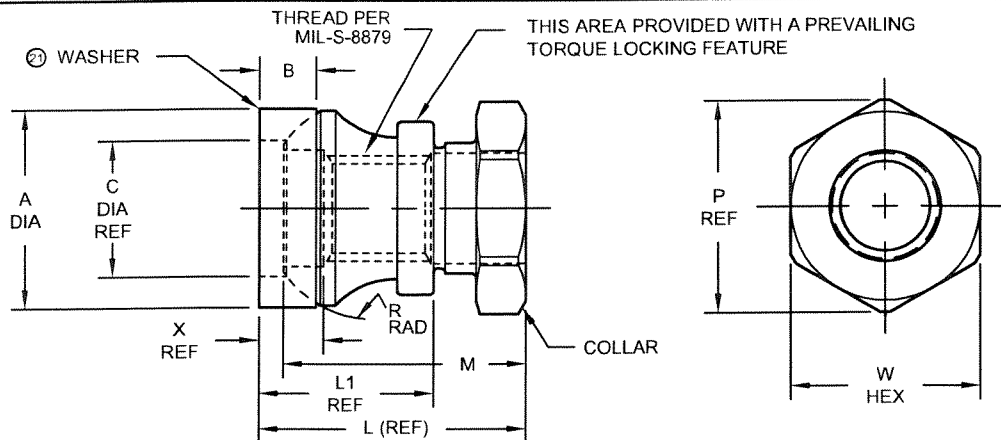


# STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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. 06725  
 HUCK INTERNATIONAL, INC., U.S.A. (Licensee) CAGE No. 97928  
 SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878  
 FAIRCHILD Aerospace Fastener Division (Licensee) CAGE No. 92215  
 WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 50516  
 (Pins & Steel Collars)

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB88  
 a GFI AEROSPACE Company  
 HUCK S.A. France (Licensee - ECC Countries) CAGE No. 06725  
 BLANC AERO S.A. France (Licensee - ECC Countries) CAGE No. 97928  
 a GFI AEROSPACE Company  
 TOKYO SCREW COMPANY, Japan (Licensee - Japan) CAGE No. 56878



DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER. (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.365 .355	.095 .085	.255	.445	.280	.420 .400	.380	.20	.346 .332	.107	2,300	22-32
6	3/16	10-32UNJF-3B	.365 .355	.095 .085	.255	.445	.280	.420 .400	.380	.20	.346 .332	.107	2,750	32-42
8	1/4	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.540	.340	.510 .490	.380	.26	.346 .332	.112	5,000	75-90
10	5/16	5/16-24UNJF-3B	.620 .610	.130 .120	.417	.660	.430	.617 .597	.484	.34	.440 .425	.122	8,300	140-170
12	3/8	3/8-24UNJF-3B	.685 .675	.145 .135	.490	.730	.470	.677 .657	.557	.38	.503 .488	.122	12,700	210-260
14	7/16	7/16-20UNJF-3B	.805 .795	.180 .170	.570	.855	.562	.772 .752	.840	.45	.753 .736	.137	19,000	310-370
16	1/2	1/2-20UNJF-3B	.915 .905	.205 .195	.648	.925	.612	.842 .822	.970	.51	.878 .861	.137	25,500	410-470
18	9/16	9/16-18UNJF-3B	1.125 1.115	.270 .260	.763	1.050	.700	.960 .940	.970	.71	.878 .861	.145	29,000	575-650
20	5/8	5/8-18UNJF-3B	1.305 1.290	.315 .305	.855	1.145	.765	1.035 1.015	1.120	.76	1.003 .986	.145	32,000	700-775
24	3/4	3/4-16UNJF-3B	1.500 1.485	.390 .380	.985	1.405	.980	1.285 1.255	1.240	.81	1.128 1.110	.156	42,000	1000-1100
28	7/8	7/8-14UNJF-3B	1.740 1.720	.450 .435	1.155	1.600	1.100	1.470 1.440	1.520	.92	1.380 1.356	.169	62,000	1275-1400
32	1	1-12UNJF-3B	2.000 1.980	.505 .490	1.345	1.900	1.300	1.755 1.725	1.650	1.11	1.504 1.480	.186	84,000	1550-1700

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
  2. For use on sloped surfaces up to 7° maximum on standard and 1/64 oversize Hi-Lok shear head pins.
  3. Dimensions apply after finish.
  4. Use HL675 for oversize replacement.

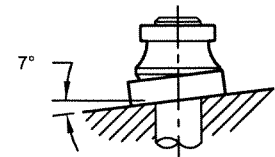
**MATERIAL:** Collar - Type 303 Se stainless steel per ASTM A582 (AMS5640).  
 Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

**HEAT TREAT:** Collar - None.  
 Washer - Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per AMS-H-6875.

**FINISH:**

Collar - HL175-( )A = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL175DU( )A = Solid film lube per AS5272, Type I.  
 HL175G( )A = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL175K( )A = Solid film lube per Lubeco 2123.  
 HL175TB( )A = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL175TF( )A = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.  
 HL175V( )A = Solid film lube per "Lubeco" 2123.

Washer - HL175-( )DW = Solid film lube per AS5272, Type I.  
 HL175-( )GW = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL175-( )KW = Solid film lube per "Lubeco" 905.  
 HL175-( )LPW = Solid film lube per AS5272, Type II.  
 HL175-( )PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.  
 HL175-( )VW = Solid film lube per "Lubeco" 2123.  
 HL175-( )JW = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.  
 HL175-( )WU = Passivate per Hi-Shear Spec. 258.



**SPECIFICATION:** Hi-Lok Product Specification 345.  
**CODE:** Dash number indicates nominal thread size in 1/32nds.  
 Code letter "A" following dash number indicates Hi-Lok collar.  
 See "Finish" note for explanation of code letters.

**EXAMPLE:** HL175-8AW = Assembly of HL175-8A collar and HL175-8W washer.

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

			TITLE		DRAWING NO.	
DATE	BY		<b>HI-LOK® COLLAR</b> SELF-ALIGNING COLLAR ASSEMBLY 303 STAINLESS STEEL 1/16" GRIP VARIATION, SHEAR APPLICATION		<b>HL175</b>	
DRAWN	10-28-65	Brlcj				
APPROVED	10-28-65	MILLER				
REVISION	11-15-01	J.F.Obispo				