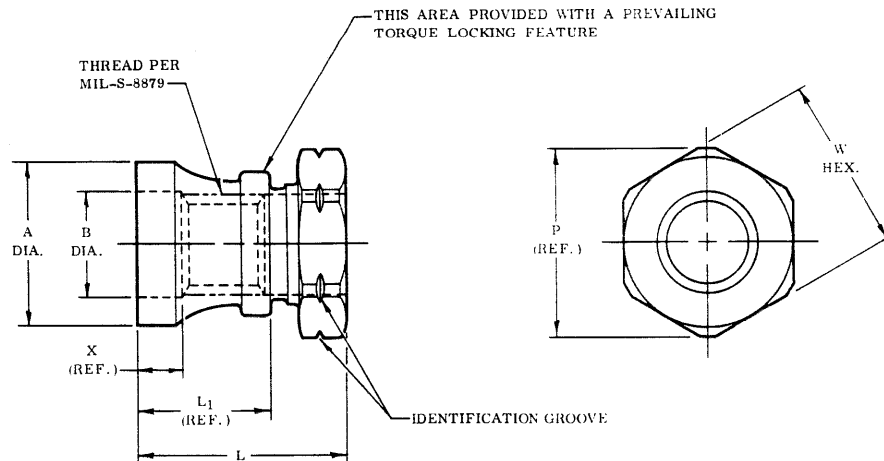


# STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

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

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197  
Division of Hi-Shear Industries Inc., U.S.A.  
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. Canada) CAGE No. 09725  
HUCK INTERNATIONAL, INC., Deutsch Operation, U.S.A. (Licensee) CAGE No. 97925  
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56678  
FAIRCHILD Aerospace Fastener Division, U.S.A. (Licensee) CAGE No. 92215  
WEST COAST AEROSPACE INC., U.S.A. (Licensee) CAGE No. 60616  
(Pins & Steel Collars)

HI-SHEAR FASTENERS EUROPE, LTD. U.K. (Licensee) CAGE No. 01B66  
Division of Hi-Shear Industries Inc., U.S.A.  
HUCK INTERNATIONAL GMBH & CO., Germany (Licensee - EEC Countries)  
SAINT DIAMOND GRANAT, S.A. France (Licensee - EEC Countries)  
SIMMONDS S.A. France (Licensee - EEC Countries)  
TOKYO SCREW COMPANY, Japan (Licensee - Japan)



| DASH NO. | PIN NOM. DIA. | THREAD         | A DIA.         | B DIA.         | L LENGTH       | L <sub>1</sub> (REF.) | P (REF.) | W HEX.         | X +0.010 / -0.000 | UTS LBS. MIN. | TORQUE-OFF INCH-LB. |
|----------|---------------|----------------|----------------|----------------|----------------|-----------------------|----------|----------------|-------------------|---------------|---------------------|
| 6        | 15/64         | 10-32UNJF-3B   | .342<br>.338   | .246<br>.242   | .490<br>.470   | .310                  | .380     | .346<br>.332   | .140              | 1,600         | 25-35               |
| 8        | 19/64         | 1/4-28UNJF-3B  | .442<br>.438   | .308<br>.304   | .585<br>.565   | .375                  | .484     | .440<br>.425   | .145              | 3,000         | 60-80               |
| 10       | 23/64         | 5/16-24UNJF-3B | .558<br>.552   | .373<br>.367   | .700<br>.680   | .460                  | .484     | .440<br>.425   | .150              | 5,000         | 130-160             |
| 12       | 27/64         | 3/8-24UNJF-3B  | .668<br>.662   | .436<br>.430   | .770<br>.750   | .500                  | .557     | .503<br>.488   | .150              | 7,000         | 200-240             |
| 14       | 31/64         | 7/16-20UNJF-3B | .763<br>.757   | .499<br>.493   | .885<br>.865   | .585                  | .624     | .565<br>.550   | .160              | 9,500         | 270-330             |
| 16       | 35/64         | 1/2-20UNJF-3B  | .883<br>.877   | .562<br>.556   | .965<br>.945   | .635                  | .763     | .690<br>.675   | .160              | 12,500        | 370-430             |
| 18       | 39/64         | 9/16-18UNJF-3B | .903<br>.893   | .625<br>.619   | 1.052<br>1.032 | .693                  | .970     | .878<br>.861   | .168              | 14,500        | 500-575             |
| 20       | 43/64         | 5/8-18UNJF-3B  | 1.028<br>1.018 | .687<br>.681   | 1.146<br>1.126 | .758                  | 1.120    | 1.003<br>.986  | .168              | 18,000        | 625-700             |
| 24       | 51/64         | 3/4-16UNJF-3B  | 1.200<br>1.190 | .816<br>.808   | 1.394<br>1.374 | .963                  | 1.240    | 1.128<br>1.110 | .179              | 27,500        | 900-1000            |
| 28       | 59/64         | 7/8-14UNJF-3B  | 1.375<br>1.365 | .941<br>.933   | 1.598<br>1.578 | 1.083                 | 1.450    | 1.315<br>1.292 | .192              | 37,500        | 1200-1325           |
| 32       | 1-3/64        | 1-12UNJF-3B    | 1.540<br>1.530 | 1.072<br>1.062 | 1.863<br>1.843 | 1.248                 | 1.650    | 1.504<br>1.480 | .209              | 50,000        | 1450-1600           |

- NOTES:** 1. Go thread gage penetration shall be 3/4 of one revolution minimum.
- MATERIAL:** 2024 aluminum alloy per QQ-A-430 or QQ-A-225/6.
- HEAT TREAT:** Age to T6 condition per MIL-H-6088.
- FINISH:** HL279-( ) = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.
- SPECIFICATION:** Boeing BPS-F-68.
- CODE:** Dash number indicates nominal thread size in 1/32nds.
- EXAMPLE:** HL279-8 = 1/4-28 Hi-Lok 3/64" oversize collar.

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

| DRAWN      | DATE    | BY         | TITLE<br><b>HI-LOK® COLLAR</b><br>2024-T6 ALUMINUM ALLOY<br>1/16" GRIP VARIATION, SHEAR APPLICATION<br>FOR USE ON 3/64" OVERSIZE HI-LOK PINS | DRAWING NUMBER<br><b>HL279</b> |
|------------|---------|------------|----------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------|
|            | 3-25-64 | BRLEJ      |                                                                                                                                              |                                |
| APPROVED   | 3-25-64 | M.C.       |                                                                                                                                              |                                |
| ⑩ REVISION | 7-10-95 | J.F.Obispo |                                                                                                                                              |                                |