lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company
Design Holder
CAGE No. 73197

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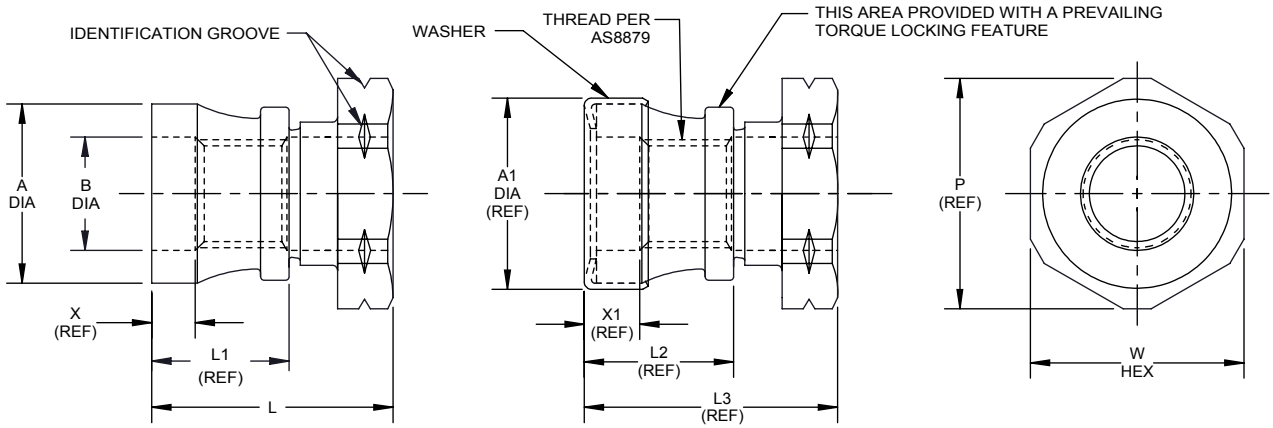

DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.292 .288	.320	.173 .166	.447 .427	.270	.285	.460	.344	.314 .302	.107	.120	2,300	15-25
6	13/64	.1900-32 UNJF-3B	.322 .318	.355	.212 .208	.457 .437	.280	.295	.470	.380	.346 .332	.107	.120	2,750	25-35
8	17/64	.2500-28 UNJF-3B	.422 .418	.455	.272 .268	.552 .532	.340	.355	.565	.484	.440 .425	.112	.125	5,000	60-80
10	21/64	.3125-24 UNJF-3B	.538 .532	.570	.336 .330	.672 .652	.430	.445	.685	.484	.440 .425	.122	.135	8,300	130-160
12	25/64	.3750-24 UNJF-3B	.649 .642	.685	.398 .392	.744 .724	.470	.485	.755	.557	.503 .488	.122	.135	12,700	200-240
14	29/64	.4375-20 UNJF-3B	.740 .730	.775	.463 .457	.862 .842	.560	.575	.875	.840	.753 .736	.137	.150	19,000	270-330
16	33/64	.5000-20 UNJF-3B	.860 .850	.895	.528 .522	.942 .922	.610	.625	.955	.970	.878 .861	.137	.150	25,500	370-430
18	37/64	.5625-18 UNJF-3B	.915 .905	.950	.598 .592	1.029 1.009	.670	.685	1.042	.970	.878 .861	.145	.158	29,500	500-575
20	41/64	.6250-18 UNJF-3B	.995 .985	1.050	.661 .655	1.123 1.103	.735	.750	1.136	1.120	1.003 .986	.145	.158	32,000	625-750
24	49/64	.7500-16 UNJF-3B	1.120 1.110	1.150	.786 .780	1.371 1.351	.940	.955	1.384	1.240	1.128 1.110	.156	.169	42,000	900-1000
28	57/64	.8750-14 UNJF-3B	1.345 1.335	1.380	.911 .905	1.571 1.551	1.060	1.075	1.584	1.520	1.380 1.356	.169	.182	62,000	1200-1325
32	1-1/64	1.0000-12 UNJF-3B	1.490 1.480	1.530	1.036 1.030	1.836 1.815	1.225	1.240	1.849	1.650	1.504 1.480	.186	.199	84,000	1450-1600

NOTES:
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
(32) 2. Dimensions are in inches and apply after finish and before application of lubricants.
3. Use HL294 for oversize replacement.
(32) [4] Use the following test bolts for thread lock inspection:
TB64VF( )L for HL94DU( ), HL94K( ), HL94LP( ), HL94TF( ), HL94V( ), HL94HK( ), and HL94DUW( ).
TB64VF( )M for HL94TB( ).

MATERIAL:
Collar — Type 303 Se stainless steel per ASTM A582.
Steel Washer — 300 series stainless steel.

FINISH:
Collar
HL94-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL94DU( ) = Solid film lube per AS5272, Type I.
HL94G( ) = Silver plate per AMS2410 (.0002 - .0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.
HL94K( ) = Solid film lube per Lubeco 905.
HL94LP( ) = Solid film lube per AS5272, Type II.
HL94PK( ) = Cadmium plate per AMS-QQ-P-416 (olive drab color), Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL94TB( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL94TF( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
HL94V( ) = Solid film lube per Lubeco 2123.
HL94HK( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Collar & Washer
HL94W( ) = Collar finish same as HL94-( ), and washer with cadmium plate per AMS-QQ-P-416, Type I, Class 2.
HL94DUW( ) = Collar and washer both with solid film lube per AS5272, Type I.
HL94GW( ) = Collar and washer both with silver plate per AMS2410 (.0002 - .0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305
HL94GNW-( ) = Collar finish same as HL94G( ), and washer passivated per Hi-Shear Spec. 258.
HL94GVW( ) = Collar finish same as HL94G( ), and washer with solid film lube per lubeco 2123.

SPECIFICATION: HI-LOK™ Product Specification 345. Test bolt requirement exceptions per note [4] above. (32)

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

EXAMPLES: HL94K-8 = 1/4-28 HI-LOK™ collar; finish is Lubeco 905.

	DATE	BY
DRAWN	1963-05-15	BRIEJ
APPROVED	1963-05-15	M.C.
(32) REVISION	2018-01-09	S.WILEY

TITLE
HI-LOK™ COLLAR
TYPE 303 Se STAINLESS STEEL
1/16 GRIP VARIATION, SHEAR APPLICATION
FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LOK™ PINS

DRAWING NO.
HL94