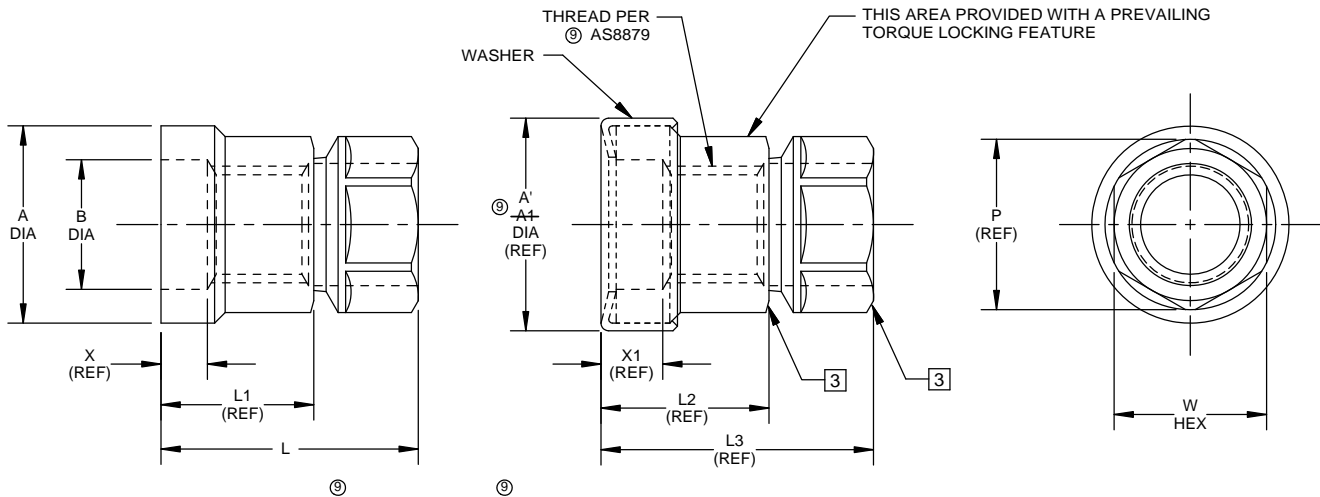


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DASH NO.	PIN NOM DIA	THREAD	A DIA	A' DIA (REF)	B DIA	L LENGTH	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32UNJC-3B	.287 .283	.320	.173 .169	.435 .415	.235	.250	.450	.248	.223 .213	.107	.120	2,300	15-25
6	13/64	.1900-32UNJF-3B	.307 .303	.340	.212 .208	.450 .430	.250	.265	.465	.280	.254 .244	.107	.120	2,750	25-35
8	17/64	.2500-28UNJF-3B	.412 .408	.440	.276 .272	.550 .530	.300	.315	.565	.344	.314 .305	.112	.125	5,000	60-80
10	21/64	.3125-24UNJF-3B	.518 .512	.550	.340 .334	.670 .650	.370	.385	.685	.414	.378 .365	.122	.135	8,300	130-160
12	25/64	.3750-24UNJF-3B	.628 .622	.660	.403 .397	.740 .720	.410	.425	.755	.484	.440 .425	.122	.135	12,700	200-240
14	29/64	.4375-20UNJF-3B	.735 .725	.775	.466 .460	.930 .910	.560	.575	.935	.573	.505 .490	.137	.150	19,000	270-330
16	33/64	.5000-20UNJF-3B	.850 .840	.895	.528 .522	1.020 1.000	.610	.625	1.025	.643	.565 .550	.137	.150	25,500	370-430

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 2. Dimensions are in inches and apply after finish.
 3. Burrs from cutoff process and cutting torque-off groove allowed.
 4. HL1094N-() collars are for use in special environments; to be lubricated with compatible materials by user.

MATERIAL:

Collar ⑨ - S30430 (302HQ) stainless steel per Spec. ASTM A493, Type XM-7, or 302 or 305 stainless steel per AMS-QQ-S-763 and AMS5686, or 303Se series stainless steel per ASTM A582 (AMS5640).

Washer - 300 series stainless steel.

FINISH:

⑨ HL1094-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, cetyl alcohol lube per Hi-Shear Spec. 305.

⑨ HL1094D() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per AS5272, Type I.

HL1094DU() = Solid film lube per AS5272, Type I.

HL1094G() = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.

⑨ ④ HL1094N() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, no lube.

HL1094TF() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.

HL1094HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Collar & Washer - ⑨ HL1094W() = Collar finish same as HL1094-(), and washer with cadmium plate per AMS-QQ-P-416, Type I, Class 2.

HL1094DUW() = Collar and washer both with solid film lube per AS5272, Type I.

HL1094GW() = Collar and washer both with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.

HL1094GNW() = Collar finish same as HL1094G(), and washer passivated per Hi-Shear Spec. 258.

HL1094TFNW() = Collar finish same as HL1094TF(), and washer passivated per Hi-Shear Spec. 258.

SPECIFICATION: HI-LOK™ Product Specification 345.

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

EXAMPLE: HL1094-8 = 1/4-28 HI-LOK™ collar with Type II cadmium plate.
 HL1094W8 = 1/4-28 HI-LOK™ collar and plated washer.

"HI-LOK" AND "HL" ARE INTERNATIONAL
 REGISTERED TRADEMARKS OF HI-SHEAR CORPORATION

DATE	BY	TITLE	DRAWING NO.
1980-10-16	D.P.S.	HI-LOK™ COLLAR	HL1094
1980-10-16	R.TING	STAINLESS STEEL	
1980-10-16	R.TING	1/16 GRIP VARIATION, SHEAR APPLICATION	
2017-09-06	M.BEARD	FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LOK™ PINS	