

COLLAR
ALUMINIUM ALLOY
SHEAR TYPE

FORM AIF 8001.2

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1. SCOPE AND FIELD OF APPLICATION

This standard specifies the characteristics and dimensions of aluminium alloy sheartyp collars for use preferably as nonremovable fasteners in primary structure

2. REFERENCES

MIL-S-8879	Screw threads, controlled radius roth with increased minor diameter, General Specification.
MIL-H-6088	Heat treatment of aluminium alloy.
MIL-A-8625	Anodic coatings for aluminium and aluminium alloys.
QQ-A-225/9	Aluminium alloy 7075, bar, rod wire and special chapes, rolled, drawn or cold finished.
QQ-A-430	Aluminium alloy rod and wire; for rivets and cold heading
prEN2424	Identification marking of standard fasteners, aerospace series.
(*)Spec.305	Cetyl alcohol and lauric acid lubrication of fasteners
(*)Spec.381	Product specification HI-LITE fastening system, HI-LITE collar

3. REQUIRED CHARACTERISTICS

3.1. Configuration-Dimensions-Loads-Torque off-Masses.

3.1.1. Configuration shall be accordance with the figure.

3.1.2. Dimensions shall conform with the table 1. To be meet after finish

3.1.3. Loads, Torque-off and masses shall conform with table 1.

3.2. Material

7050 aluminium alloy per QQ-A-430 or 7075 aluminium alloy per QQ-A-225/9

3.3. Heat treatment

Age to T73 condition per MIL-H-6088

3.4. Finish

Anodize per MIL-A-8625 color black and cetyl alcohol lube per Spec.305

(*) Manufacturer Specification

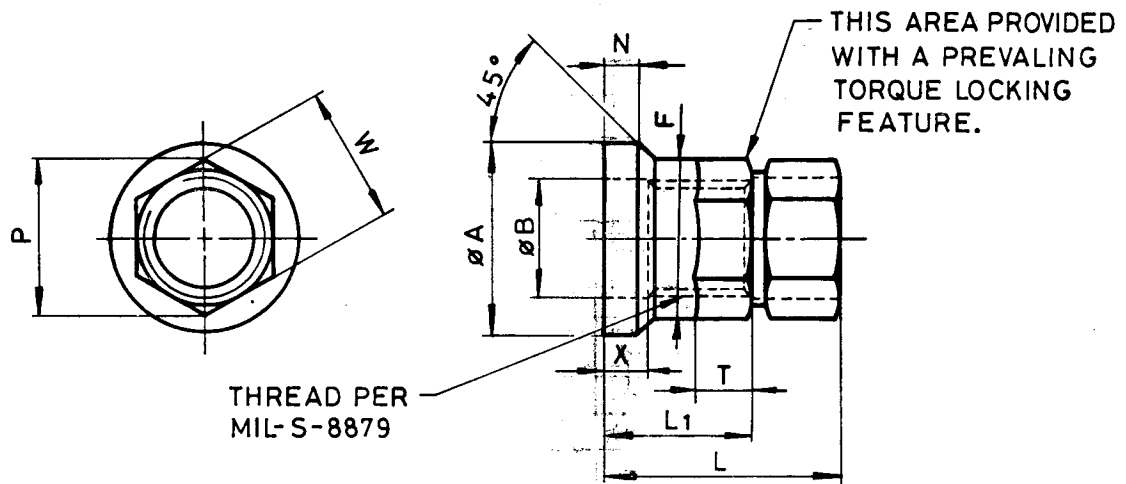


Figure - Configuration

STANDARDS MANUAL

Table-Dimensions-Loads-Torque-off-Masses

Table Dimensions in millimetres (inch)

DIAMETER CODE		5
NOMINAL DIAMETER		4 (5/32)
THREAD MIL-S-8879		.1640-32UNJC-3B
A	MAX	7,47 (.294)
	MIN	7,26 (.286)
B	MAX	4,39 (.173)
	MIN	4,29 (.169)
F	MAX	6,43 (.253)
L	MAX	10,29 (.405)
	MIN	9,78 (.385)
L1	REF	5,84 (.230)
N	MAX	1,78 (.070)
P	REF	6,30 (.248)
T	MIN	2,29 (.090)
W HEX	MAX	5,61 (.221)
	MIN	5,36 (.211)
X	MAX	2,59 (.102)
	MIN	2,34 (.092)
UTS kN (lbs)	MIN	6,23 (1400)
TORQUE-OFF N.m (in-lbs)		1,70-2,82 (15-25)
Mass kg/1000 parts		0,37

STANDARDS MANUAL
4. DESIGNATION

Description	Identity block
COLLAR	ABS0274-5
Number of ABS standard _____	
Diameter code _____	

5. MARKING

According to prEN2424 Style G

6. TECHNICAL SPECIFICATION

Spec.381