



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	.1640-32UNJC-3B	.287 .283	.320	.173 .169	.435 .415	.235	.250	.450	.250	.220 .213	.107	.120	2,300	25-35
6	13/64	.1900-32UNJF-3B	.307 .303	.340	.212 .208	.450 .430	.250	.265	.465	.280	.251 .244	.107	.120	2,750	30-40
8	17/64	.2500-28UNJF-3B	.412 .408	.440	.276 .272	.550 .530	.300	.315	.565	.350	.314 .302	.112	.125	5,000	80-95
10	21/64	.3125-24UNJF-3B	.518 .512	.550	.340 .334	.670 .650	.370	.385	.685	.420	.377 .365	.122	.135	8,300	150-200
12	25/64	.3750-24UNJF-3B	.628 .622	.660	.403 .397	.740 .720	.410	.425	.755	.490	.439 .425	.122	.135	12,700	260-360
14	29/64	.4375-20UNJF-3B	.735 .725	.775	.466 .460	.930 .910	.560	.575	.935	.573	.505 .490	.137	.150	19,000	390-480
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	640-800

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

			TITLE	DRAWING NO.
	DATE	BY	HI-LOK™ COLLAR STAINLESS STEEL 1/16 GRIP VARIATION, TENSION APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LOK™ PINS	HL1087 1 of 2
DRAWN	1980-06-26	D.P.S.		
APPROVED	1980-08-06	JGWILCOX		
23 REVISION	2022-03-10	K. PHAM		

GENERAL 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 and before application of lubricants.
3. Burrs from cutoff process and cutting torque-off groove allowed.
4. HL1087N() collars are for use in special environments; to be lubricated with compatible materials by user.
5. Use HL93 for oversize replacement.
- 23 6. After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in UK and European Union.
7. Use TB64AP()L for HL1087Y() thread lock inspection.
- 23 8. Hardness and UTS requirement in ASTM A582/A582M and/or AMS5640 are not applicable to the raw material. Raw material can be supplied in cold worked condition in order to meet the product UTS requirement.

MATERIAL:

- Collar S30430 (302HQ) stainless steel per 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).
- 23 8.
- Washer 300 series stainless steel (.010 thick). 2024-T6 aluminum alloy (.020 thick) per AMS-QQ-A-250/4 or AMS-QQ-A-250/5 (sizes -5 through -12 only).

FINISH:

- Collar HL1087-() = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1087D() = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and solid film lube per AS5272, Type I.
- HL1087DU() = Collar only with solid film lube per AS5272, Type I.
- HL1087G() = Collar only with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1087GU() = Collar only with silver plate per AMS2410.
- HL1087MA() = Collar only with solid film lube per Kalgard RA.
- HL1087N() = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, no lube.
- 23 4 6 HL1087Y() = Collar only with HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
- 23 HL1087HK() = Collar only with HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
- Collar & Washer HL1087PBW() = Collar with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305. Steel washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and no lube.
- HL1087TW() = Collar with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305. Aluminum washer anodize per MIL-A-8625, dye color blue (sizes -5 through -12 only).
- HL1087GGW() = Collar and steel washer both with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL1087DUW() = Collar finish same as HL1087DU(), and steel washer with cadmium plate per AMS-QQ-P-416 Type II, Class 2, no lube.
- 23 HL1087DUWU() = Collar finish same as HL1087DU(), and steel washer passivated per AMS2700, Method 1, Type 8, Class 1.
- REMOVED

SPECIFICATION:

HI-LOK™ Product Specification 345. Test bolt requirement exceptions per note 7 above.

CODE:

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

EXAMPLE:

HL1087-8 = 1/4-28 HI-LOK™ collar with Type II cadmium plate.

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