



FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 DIA REF	B DIA	L	L1 MAX	L2 REF	L3 REF	P REF	W HEX	X ±.005	X1 REF	UTS LBS. MIN	TORQUE-OFF IN-LBS
5	5/32	.1640-32 UNJC-3B	.287 .283	.320	.173 .166	.447 .427	.272	.280	.460	.344	.314 .302	.107	.120	2,300	20-30
6	13/64	.1900-32 UNJF-3B	.307 .303	.340	.212 .208	.457 .437	.282	.290	.470	.344	.314 .302	.107	.120	2,750	35-45
7	15/64	.2160-28 UNJF-3B	.374 .370	.405	.240 .236	.500 .480	.310	.313	.513	.484	.440 .425	.107	.120	3,900	50-65
8	17/64	.2500-28 UNJF-3B	.412 .408	.442	.272 .268	.552 .532	.347	.355	.565	.484	.440 .425	.112	.125	5,000	80-95
10	21/64	.3125-24 UNJF-3B	.518 .512	.552	.336 .330	.672 .652	.437	.445	.685	.624	.565 .550	.122	.135	8,300	150-200
12	25/64	.3750-24 UNJF-3B	.620 .614	.665	.398 .392	.744 .724	.479	.490	.755	.700	.628 .613	.122	.135	12,700	270-330
14	29/64	.4375-20 UJNJF-3B	.733 .727	.775	.463 .457	.862 .842	.567	.575	.875	.840	.763 .736	.137	.150	19,000	500-575
16	33/64	.5000-20 UNJF-3B	.848 .842	.895	.528 .522	.942 .922	.617	.625	.955	.970	.878 .861	.137	.150	25,500	750-850

- GENERAL NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 - Dimensions are in inches and to be met after finish and before application of lubricants.
 - 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 European Union.
 - Use TB64VF()L for thread lock inspection.

MATERIAL: Collar 6Al-4V titanium alloy per AMS4928, AMS4930 or AMS4967.
 Washer 300 series stainless steel.

FINISH: Collar HL198() = Collar only with surface coating per Hi-Shear Spec. 306, Type II, and solid film lubricant per Electrofilm 4396.
 [3] HL198AP() = Collar only with HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL198DL() = Collar only with surface coating per Hi-Shear Spec. 306, Type II and solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL198LJ() = Collar only with surface coating per Hi-Shear Spec. 306, Type II and solid film lube per AS5272, Type I.
 HL198V() = Collar only with pretreat Ticermet B and solid film lubricant per Lubeco 2123.
 Collar & Washer: HL198VW() = Both collar and washer with solid film lube per Lubeco 2123.
 HL198W() = Collar finish is same as HL198(). Washer finish is solid film lube per Electrofilm 4396 only. (26)

SPECIFICATION: HI-LOK™ Product Specification 345. Use shear collar tension preload requirements. Test bolt requirement exceptions per note [4] above.

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

EXAMPLE: HL198V8 = .2500-28 HI-LOK™ collar with Lubeco 2123 finish.
 HL198VW8 = .2500-28 HI-LOK™ collar and washer assembly with both Lubeco 2123 finish.

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			TITLE	DRAWING NO.
			HI-LOK™ COLLAR	HL198
			TITANIUM ALLOY	
			1/16 GRIP VARIATION, TENSION APPLICATION	
			FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LOK™ PINS	
DRAWN	DATE	BY		
APPROVED	1966-02-07	BRIEJ		
	1966-02-07	J.MILLER		
(26) REVISION	2019-10-08	F.CARINGELLA		