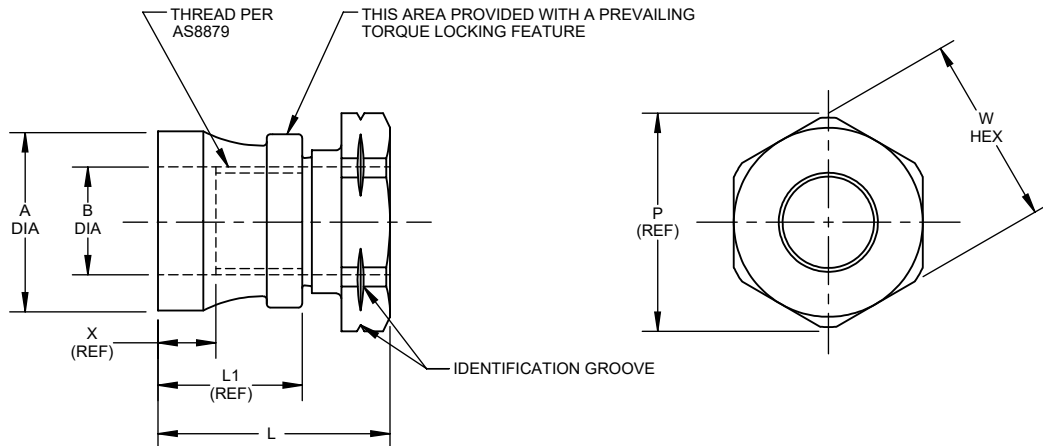




DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L LENGTH	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.292 .288	.173 .166	.447 .427	.270	.344	.314 .302	.107	3,050	30-40
6	13/64	.1900-32 UNJF-3B	.322 .318	.212 .208	.457 .437	.280	.380	.346 .332	.107	4,000	40-50
8	17/64	.2500-28 UNJF-3B	.422 .418	.272 .268	.552 .532	.340	.484	.440 .425	.112	7,500	115-130
10	21/64	.3125-24 UNJF-3B	.538 .532	.336 .330	.672 .652	.430	.484	.440 .425	.122	11,750	200-250
12	25/64	.3750-24 UNJF-3B	.648 .642	.398 .392	.744 .724	.470	.557	.503 .488	.122	18,000	360-420
14	29/64	.4375-20 UNJF-3B	.743 .737	.466 .460	.862 .842	.560	.840	.753 .736	.137	23,750	525-600
16	33/64	.5000-20 UNJF-3B	.865 .855	.528 .522	.942 .922	.610	.970	.878 .861	.137	30,000	725-825
18	37/64	.5625-18 UNJF-3B	.915 .905	.598 .592	1.029 1.009	.670	.970	.878 .861	.145	39,000	1000-1150
20	41/64	.6250-18 UNJF-3B	.995 .985	.661 .655	1.123 1.103	.735	1.120	1.003 .986	.145	49,000	1350-1550
24	49/64	.7500-16 UNJF-3B	1.120 1.110	.786 .780	1.371 1.351	.940	1.240	1.128 1.110	.156	70,000	1900-2200
28	57/64	.8750-14 UNJF-3B	1.345 1.335	.911 .905	1.575 1.545	1.060	1.520	1.380 1.356	.169	95,000	3200-3600
32	1-1/64	1.0000-12 UNJF-3B	1.490 1.480	1.036 1.030	1.840 1.810	1.225	1.650	1.504 1.480	.186	124,000	4500-5000

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 - Dimensions are in inches and apply after finish and before application of lubricants.
 - Use HL373 for oversize replacement.
 - Use test bolt TB64VF()L for thread lock inspection .

MATERIAL: 17-4PH stainless steel per Spec. AMS5643

HEAT TREAT: To condition H1025 per AMS-H-6875

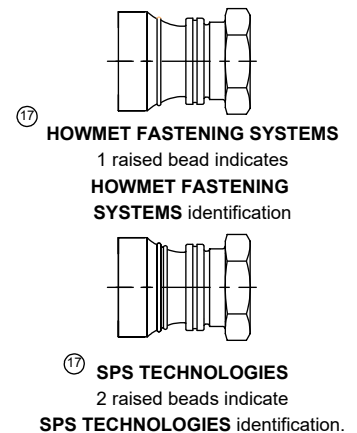
FINISH:

- HL273-() = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL273DU-() = Solid film lube per AS5272, Type I.
- HL273DY-() = Solid film lube per AS5272, Type I, and yellow paint on body of collar.
- HL273LP-() = Solid film lube per AS5272, Type II, and cetyl alcohol per Hi-Shear Spec. 305.
- HL273N-() = Diffused nickel - cadmium plating per AMS2416 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL273PB-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL273TB-() = HI-KOTE 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL273YL-() = Solid film lube per AS5272, Type II, and yellow paint.
- HL273HK-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LOK™ Product Specification 345. Test bolt requirement exceptions per note 4 above.

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

EXAMPLES: HL273-8 = 1/4-28 HI-LOK™ collar.



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

			TITLE	DRAWING NO.
			HI-LOK™ COLLAR	HL273
			17-4PH STAINLESS STEEL	
			1/16 GRIP VARIATION - TENSION APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LOK™ PINS	
DATE	BY			
DRAWN	1963-07-22	MARTIN		
APPROVED	1963-07-22	M.C.		
⑰ REVISION	2020-03-11	K. MURKER		