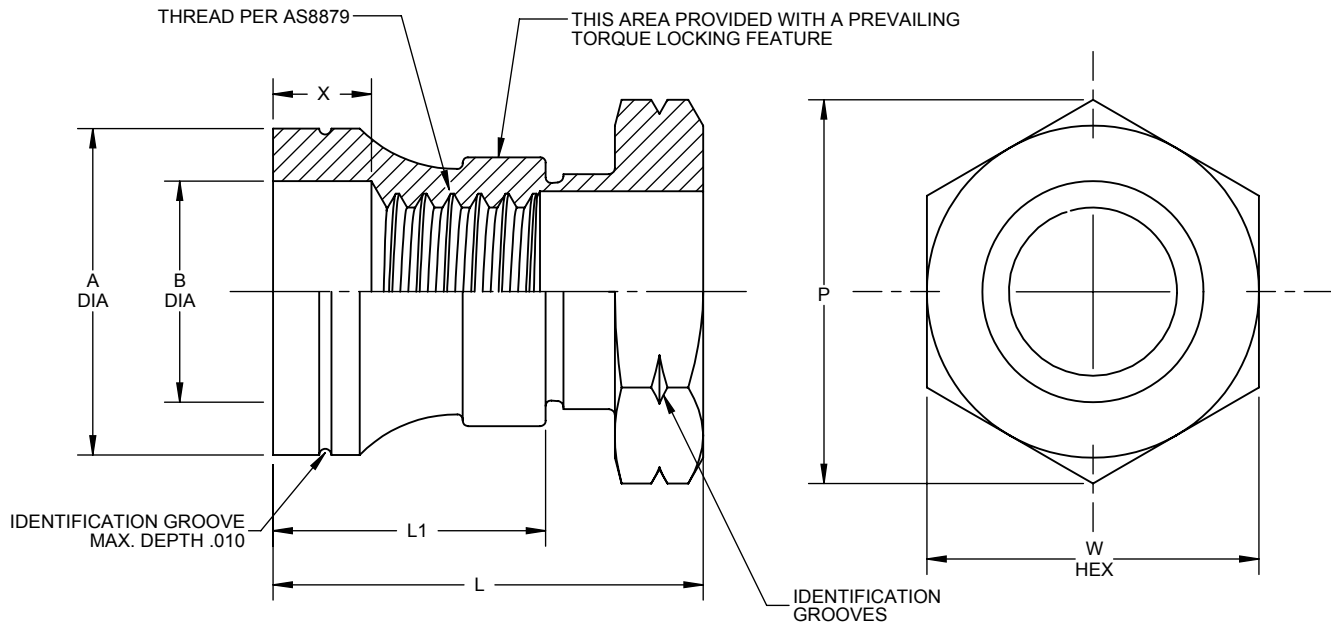




FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 REF	P REF	W HEX	X REF	UTS LBS. MIN	TORQUE-OFF IN-LBS
6	7/32	.1900-32 UNJF-3B	.332 .328	.227 .223	.470 .450	.290	.380	.346 .332	.118	4,000	40-50
8	9/32	.2500-28 UNJF-3B	.427 .423	.290 .286	.570 .550	.360	.484	.440 .425	.127	7,500	115-130
10	11/32	.3125-24 UNJF-3B	.558 .552	.356 .350	.690 .670	.450	.557	.503 .488	.139	11,750	200-250
12	13/32	.3750-24 UNJF-3B	.668 .662	.419 .413	.760 .740	.490	.700	.628 .613	.139	18,000	360-420
14	15/32	.4375-20 UNJF-3B	.763 .757	.481 .475	.880 .860	.580	.840	.753 .736	.157	23,750	525-600
16	17/32	.5000-20 UNJF-3B	.875 .865	.543 .537	.960 .940	.630	.970	.878 .861	.157	30,000	725-825
18	19/32	.5625-18 UNJF-3B	.925 .915	.613 .607	1.070 1.050	.705	.970	.878 .861	.170	39,000	1000-1150
20	21/32	.6250-18 UNJF-3B	1.020 1.010	.678 .672	1.155 1.135	.760	1.120	1.003 .986	.170	49,000	1350-1550
24	23/32	.7500-16 UNJF-3B	1.185 1.175	.803 .797	1.405 1.385	.970	1.240	1.128 1.110	.180	70,000	1900-2000

GENERAL NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 ⑩ 2. Dimensions to be met after finish and before application of lubricants.
 ⑩ ③ Use TB64VF() L for HL373DK(), HL373DU(), HL373DY(), and HL373TB().

MATERIAL: 17-4PH stainless steel per AMS5643.

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

FINISH: HL373() = Silver plate per AMS2410, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL373DK() = Kalgard FA, special cure for vacuum compatibility.
 HL373DU() = Solid film lube per AS5272, Type I.
 HL373DY() = Solid film lube per AS5272, Type I, plus yellow identification on body of collar.
 HL373PB() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL373TB() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ Product Specification 345. Test bolt requirement exceptions per note ③ above. ⑩

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

EXAMPLE: HL373-8 = .2500-28 HI-LOK™ oversize, silver plate and cetyl alcohol lube.

"HI-LOK" and "HL" are international registered trademarks of Hi-Shear Corporation

	DATE	BY	TITLE	DRAWING NO.
DRAWN	2-16-70	VAN	HI-LOK™ COLLAR	
APPROVED	3-16-70	R.Ting	17-4PH STAINLESS STEEL 1/16 GRIP VARIATION, TENSION APPLICATION FOR USE ON 1/32 OVERSIZE HI-LOK PINS	HL373
⑩ REVISION	9-14-2018	S. WILEY		