

DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	13/64		NOTE: Use HL278-6								
6	7/32	.1900-32 UNJF-3B	.332 .328	.227 .223	.470 .450	.290	.380	.346 .332	.122	2,750	35-45
8	9/32	.2500-28 UNJF-3B	.427 .423	.290 .286	.565 .545	.355	.484	.440 .425	.127	5,000	100-120
10	11/32	.3125-24 UNJF-3B	.560 .554	.356 .350	.685 .665	.445	.624	.565 .550	.137	8,300	180-220
12	13/32	.3750-24 UNJF-3B	.683 .675	.419 .413	.755 .735	.485	.763	.690 .675	.137	12,700	330-380
14	15/32	.4375-20 UNJF-3B	.748 .740	.481 .475	.875 .855	.575	.840	.753 .736	.152	19,000	525-600
16	17/32	.5000-20 UNJF-3B	.870 .860	.543 .537	.955 .935	.625	.970	.878 .861	.152	25,500	725-825

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 - ④ 2. Dimensions are in inches and apply after finish and before application of lubricants.
 - ④ 3. Use the following test bolts for thread lock inspection:
TB286PY()L for HL478EG-().
TB64-()L for HL478V-().

MATERIAL: A-286 high temperature alloy per AMS5731.

FINISH:

HL478-() = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.

HL478EG-() = Solide film lube per "EVERLUBE" 620.

HL478LZ-() = Silver plate per AMS2410 and lauric acid lube per Hi-Shear Spec. 305.

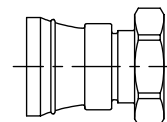
HL478PB-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

HL478V-() = Solid film lube per "LUBECO" 2123.

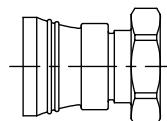
SPECIFICATION: HI-LOK™ Product Specification 345. Test bolt requirement exceptions per note ③ above. ④

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

EXAMPLES: HL478PB-8 = 1/4-28 HI-LOK™ oversize collar, finish is Type II cadmium plate plus cetyl alcohol lube.



VOI-SHAN
1 raised bead indicates
VOI-SHAN identification.



STANDARD PRESSED STEEL
2 raised bead indicates STANDARD
PRESSED STEEL identification.

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

DATE	BY	TITLE	DRAWING NO.
1972-12-08	VAN	HI-LOK™ COLLAR	HL478
1972-12-21	R. TING	A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION - TENSION APPLICATION	1 of 1
2018-02-15	S.WILEY	FOR USE ON 1/32 OVERSIZE HI-LOK™ PINS	