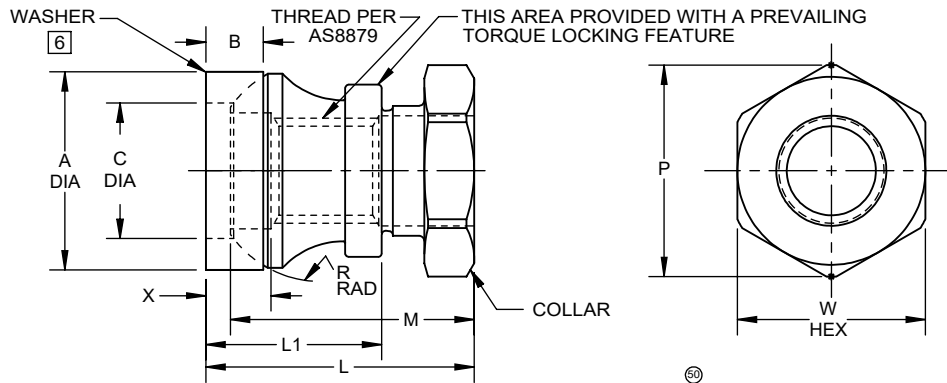


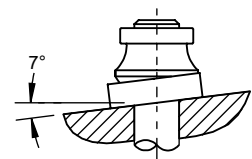


DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	L	L1 (REF)	M (REF)	P (REF)	R SPHER. RAD (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.365 .355	.095 .085	.255	.457 .427	.275	.410	.380	.20	.346 .332	.107	2,300	30-40
6	3/16	.1900-32 UNJF-3B	.365 .355	.095 .085	.255	.457 .427	.275	.410	.380	.20	.346 .332	.107	2,750	40-50
8	1/4	.2500-28 UNJF-3B	.475 .465	.120 .110	.333	.552 .522	.340	.500	.380	.26	.346 .332	.112	5,000	110-130
10	5/16	.3125-24 UNJF-3B	.620 .610	.130 .120	.417	.672 .642	.430	.607	.484	.34	.440 .425	.122	8,300	200-250
12	3/8	.3750-24 UNJF-3B	.790 .780	.145 .135	.490	.745 .715	.470	.667	.557	.38	.503 .488	.122	12,700	360-440
14	7/16	.4375-20 UNJF-3B	.895 .885	.180 .170	.570	.867 .837	.562	.762	.840	.45	.753 .736	.137	19,000	550-625
16	1/2	.5000-20 UNJF-3B	1.005 .995	.205 .195	.648	.939 .909	.610	.832	.970	.51	.878 .861	.137	25,500	725-825
18	9/16	.5625-18 UNJF-3B	1.125 1.115	.270 .260	.763	1.065 1.035	.700	.950	.970	.71	.878 .861	.145	29,000	950-1075
20	5/8	.6250-18 UNJF-3B	1.305 1.290	.315 .305	.855	1.160 1.130	.765	1.025	1.120	.76	1.003 .986	.145	32,000	1350-1550

NOTES:

- Go thread gage penetration shall be 3/4 of one revolution minimum.
- For use on sloped surfaces up to 7° maximum on standard and 1/64 oversize HI-LOK™ tension head pins.
- Non-lubed collars must be used with lubed pins.
- Dimensions are in inches and apply after finish and before application of lubricants.
- Use HL375 for oversize replacement.
- For -12, -14, and -16 washers, chamfer or radius .040-.060.
- Use TB64VF ()L for HL75DU()A, HL75K()A, HL75TF()A, HL75V()A, and HL75HK()A.

MATERIAL:	Collar	303 Se stainless steel per ASTM A582 (AMS5640).
	Washer	17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.
HEAT TREAT:	Collar	None.
	Washer	Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per AMS-H-6875.
FINISH:	Collar	HL75-()A = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, with cetyl alcohol lube per Hi-Shear Spec. 305. HL75DU()A = Solid film lube per AS5272, Type I. HL75G()A = Silver plate per AMS2410 (.0002-.0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305. HL75GU()A = Silver plate per AMS2410 (.0002-.0004 thick). HL75K()A = Solid film lube per Lubeco 905. HL75N()A = Cadmium plate per AMS-QQ-P-416, Type 1, Class 2. HL75PB()A = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305. HL75TF()A = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292. HL75V()A = Solid film lube per "Lubeco" 2123. HL75HK()A = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397. Washer HL75-()DW = Solid film lube per AS5272, Type I. HL75-()GW = Silver plate per AMS2410 (.0002-.0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305. HL75-()KW = Solid film lube per "Lubeco" 905. HL75-()PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2. HL75-()VW = Solid film lube per "Lubeco" 2123. HL75-()W = Cadmium plate per AMS-QQ-P-416, Type I, Class 2. HL75-()WU = Passivate per AMS2700, Method 1, Type 8, Class 1. HL75-()TFW = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292. HL75-()EW = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
SPECIFICATION:	HI-LOK™ Product Specification 345. Test bolt requirement exceptions per note 7 above.	
CODE:	Dash number indicates nominal thread size in 1/32nds. Code letter "A" following dash number indicates HI-LOK™ collar. See "Finish" note for explanation of code letters.	
EXAMPLE:	HL75-8AW = Assembly of HL75-8A collar and HL75-8W washer. HL75K8AKW = Assembly of HL75K8A collar and HL75-8KW washer.	



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	DATE	BY	50 HI-LOK™ COLLAR SELF-ALIGNING COLLAR ASSEMBLY 303 Se STAINLESS STEEL 1/16 GRIP VARIATION, TENSION APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LOK™ PINS	DRAWING NO.
DRAWN	1960-03-16	RKL		HL75 1 of 1
APPROVED	1960-03-16	MMS		
REVISION	2023-10-23	C.Arto		