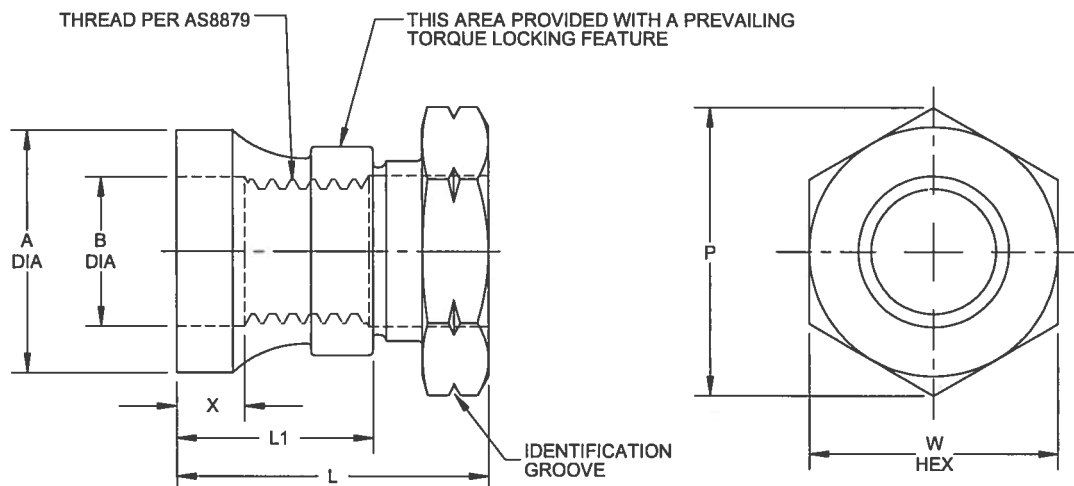




FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 REF	P REF	W HEX	X REF	UTS LBS. MIN	TORQUE-OFF IN-LBS
5	5/32		NOTE: For .5 diameter pin, use HL70-5								
6	13/64	.1900-32 UNJF-3B	.322 .318	.212 .208	.457 .437	.280	.380	.346 .332	.107	1,600	25-35
8	17/64	.2500-28 UNJF-3B	.422 .418	.272 .268	.552 .532	.340	.484	.440 .425	.112	3,000	60-80
10	21/64	.3125-24 UNJF-3B	.538 .532	.336 .330	.672 .652	.430	.484	.440 .425	.122	5,000	130-160
12	25/64	.3750-24 UNJF-3B	.649 .642	.398 .392	.744 .724	.470	.557	.503 .488	.122	7,000	200-240
14	29/64	.4375-20 UNJF-3B	.743 .737	.463 .457	.862 .842	.565	.624	.565 .550	.137	9,500	270-330
16	33/64	.5000-20 UNJF-3B	.865 .855	.528 .522	.942 .922	.615	.763	.690 .675	.137	12,500	370-430
18	37/64	.5625-18 UNJF-3B	.880 .870	.598 .592	1.029 1.009	.670	.970	.878 .861	.145	14,500	500-575
20	41/64	.6250-18 UNJF-3B	1.005 .995	.661 .655	1.123 1.103	.735	1.120	1.003 .986	.145	18,000	625-700
24	49/64	.7500-16 UNJF-3B	1.105 1.095	.786 .780	1.371 1.351	.940	1.240	1.128 1.110	.156	27,500	900-1000
28	57/64	.8750-14 UNJF-3B	1.295 1.285	.911 .905	1.575 1.545	1.060	1.450	1.315 1.292	.169	37,500	1200-1325
32	1-1/64	1.0000-12 UNJF-3B	1.475 1.465	1.036 1.030	1.840 1.810	1.225	1.650	1.504 1.480	.186	50,000	1450-1600

GENERAL NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 2. Dimensions to be met after finish.
 3. Use HL84 for oversize replacement.

MATERIAL: 2024 aluminum alloy per QQ-A-430 or AMS-QQ-A-225/6.

HEAT TREAT: Age to T6 condition per AMS2770.

FINISH: HL79() = Anodize per MIL-A-8625, dye color red, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL79D() = Anodize per MIL-A-8625 and solid film lube per AS5272, Type I.
 HL79GG() = Anodize per MIL-A-8625, dye color green, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL79K() = Anodize per MIL-A-8625 and LUBECO 905 solid film lube.
 33 HL79U() = Anodize per MIL-A-8625, dye color black.

SPECIFICATION: HI-LOK™ Product Specification 345.

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

EXAMPLE: HL79-8 = .2500-28 HI-LOK™ collar with anodize, dye color red and cetyl alcohol lube.

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DATE	BY	TITLE	DRAWING NO.
1960-11-31	R.K.L.	HI-LOK™ COLLAR	HL79
1960-11-31	M.C.	2024-T6 ALUMINUM ALLOY 1/16 GRIP VARIATION, SHEAR APPLICATION	
2017-05-11	J.F.Obispo	FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LOK PINS	
33 REVISION			