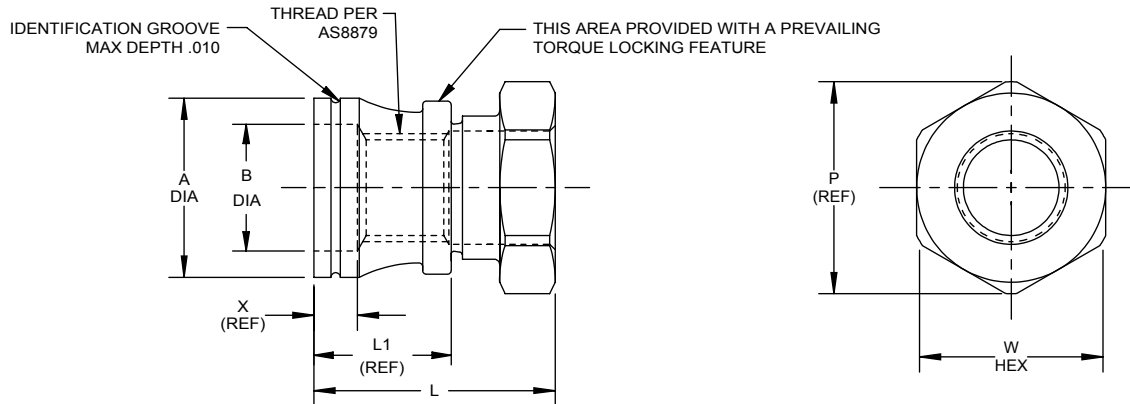




DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
6	7/32	.1900-32 UNJF-3B	.332 .328	.227 .223	.457 .437	.275	.380	.346 .332	.107	2,750	40-50
8	9/32	.2500-28 UNJF-3B	.427 .423	.290 .286	.552 .532	.342	.484	.440 .425	.112	5,000	110-130
10	11/32	.3125-24 UNJF-3B	.578 .572	.353 .347	.672 .652	.432	.484	.440 .425	.122	8,300	200-250
12	13/32	.3750-24 UNJF-3B	.683 .677	.416 .410	.744 .724	.474	.557	.503 .488	.122	12,700	360-420
14	15/32	.4375-20 UNJF-3B	.775 .765	.481 .475	.862 .842	.565	.970	.878 .861	.137	19,000	525-600
16	17/32	.5000-20 UNJF-3B	.880 .870	.543 .537	.942 .922	.615	1.120	1.003 .986	.137	25,500	725-825
18	19/32	.5625-18 UNJF-3B	.925 .915	.613 .607	1.060 1.040	.700	1.120	1.003 .986	.165	29,000	1000-1150
20	21/32	.6250-18 UNJF-3B	1.000 .990	.678 .672	1.145 1.125	.755	1.120	1.003 .986	.165	32,000	1350-1550
24	25/32	.7500-16 UNJF-3B	1.185 1.175	.803 .797	1.415 1.385	.975	1.240	1.128 1.110	.175	42,000	1900-2200
28	29/32	.8750-14 UNJF-3B	1.360 1.350	.924 .918	1.615 1.585	1.100	1.520	1.380 1.356	.190	62,000	3200-3600
32	1-1/32	1.0000-12 UNJF-3B	1.530 1.520	1.055 1.045	1.915 1.885	1.300	1.650	1.504 1.480	.210	84,000	4500-5000

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions are in inches and apply after finish and before application of lubricants.
 3. Use HL287 for oversize replacement.
 4. Use HL373 for higher tension application.
 5. Use TB64VF () L for HL93DU (), HL93K (), HL93TF (), and HL93V ().

MATERIAL: 303 Se stainless steel per QQ-S-764 and ASTM A-582 (AMS5640).

FINISH:

- HL93- () = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL93DU () = Solid film lube per AS5272, Type I.
- HL93G () = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL93K () = Solid film lube "Lubeco" 905.
- HL93TF () = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- HL93V () = Solid film lube per "Lubeco" 2123.
- HL93HK () = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LOK™ Product Specification 345. Test bolt requirement exceptions per note 5 above. 17

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

EXAMPLE: HL93-8 = 1/4-28 HI-LOK™ oversize collar with Type II cadmium plate.

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

			TITLE	DRAWING NO.
	DATE	BY	HI-LOK™ COLLAR TYPE 303 Se STAINLESS STEEL 1/16 GRIP VARIATION, TENSION APPLICATION FOR USE ON 1/32 OVERSIZE HI-LOK™ PINS	HL93 1 of 1
DRAWN	1962-06-12	R.K.L.		
APPROVED	1962-06-12	M.E.C.		
17 REVISION	2018-08-22	S. WILEY		