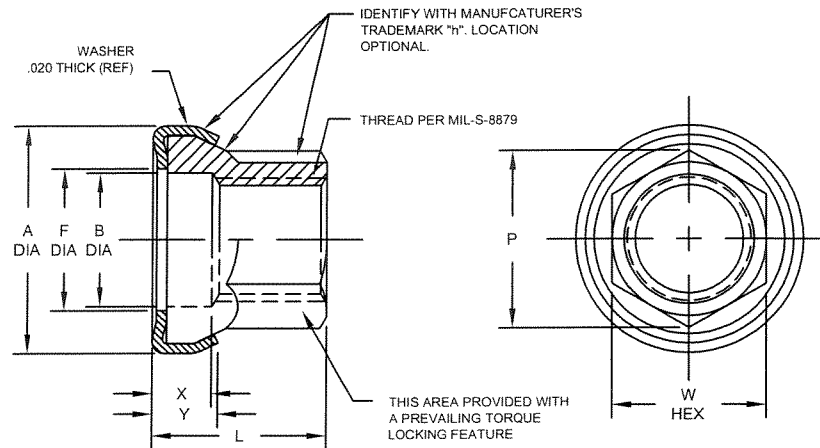


hi-shear
CORPORATION

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DASH NO.	THREAD	A DIA	B DIA	F DIA	L	P MIN	W HEX	X	Y MAX	UTS LBS. MIN	RECOM. SEATING TORQUE IN-LBS	APPROX WEIGHT LBS/100
08	8-32UNJC-3B	.350 .330	.171 .166	.186 .166	.280 .260	.242	.221 .214	.112 .102	.112	2,300	20-30	.20
3	10-32UNJF-3B	.373 .353	.210 .205	.225 .205	.290 .270	.277	.252 .245	.112 .102	.112	2,750	40-50	.29
4	1/4-28UNJF-3B	.470 .450	.272 .267	.287 .267	.350 .330	.348	.316 .306	.117 .107	.117	5,000	80-100	.52
5	5/16-24UNJF-3B	.570 .550	.335 .330	.350 .330	.440 .420	.419	.378 .369	.127 .117	.127	8,300	150-170	.92
6	3/8-24UNJF-3B	.670 .650	.397 .392	.412 .392	.480 .460	.491	.440 .431	.127 .117	.127	12,700	200-240	1.35
7	7/16-24UNJF-3B	.770 .750	.460 .455	.475 .455	.570 .550	.561	.504 .494	.142 .132	.142	19,000	320-400	1.70
8	1/2-24UNJF-3B	.870 .850	.522 .517	.537 .517	.620 .600	.631	.564 .553	.142 .132	.142	25,500	550-650	2.29

- NOTES:
1. Go Thread Gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions apply before lubrication (including solid film lubrication).
 3. "W and "P" dimensions apply prior to deformation for self-locking feature.

MATERIALS: Nut - A-286 Cres per AMS5732 or AMS5737.
Washer - 300 Series Cres per QQ-S-763; .020 ±.002 thick.

HEAT TREAT: Nut - 160,000 psi ultimate tensile strength minimum per AMS-H-6875, Rc 46 max.
Washer - None.

FINISH: HLN645DUW() Nut - Passivate per AMS-QQ-P-35 and solid film lube per AS5272, Type I.
Washer - Passivate per AMS-QQ-P-35.

SPECIFICATION: NASM25027, except 5 cycles seated test, using 6Al-4V titanium bolts at 160 to 180 ksi tensile, with threads per MIL-S-8879. Minimum nut tensile strength and seating torque as tabulated.

CODE: Dash number indicates nominal thread size in 1/16ths.
Add suffix code 'S' after dash number for spindle packaged nuts for use on automatic tools.
See finish note for explanation of code letters.

EXAMPLES: HLN645DUW4 = 1/4-28 Hi-Lok Nut, passivated and solid film lubed, with passivated washer.
HLN645DUW4S = 1/4-28 Hi-Lok Nut, passivated and solid film lubed, with passivated washer, packaged on spindles for use on automatic tools.

DATE	BY	TITLE	DRAWING NO.
8-01-02	J.Obispo	HI-LOK® NUT	HLN645
8-01-02	D. Hocking	A-286 CRES NUT AND 300 SERIES CRES WASHER	
		1/16" GRIP VARIATION	
		FOR USE ON STANDARD AND 1/64" OVERSIZE BOLTS	
REVISION			