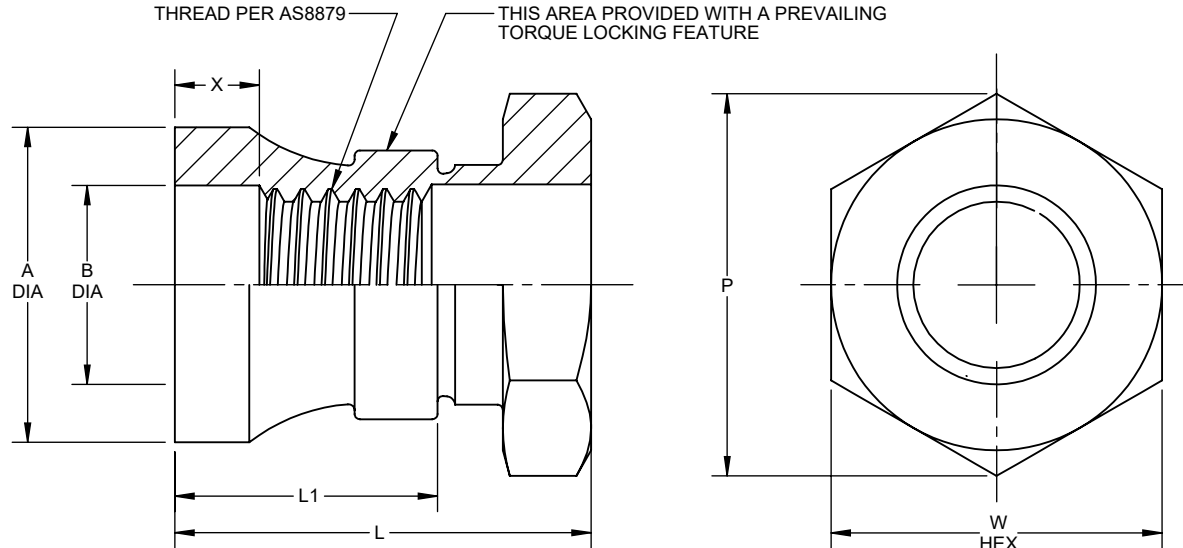




FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 MAX	P REF	W HEX	X REF	UTS LBS. MIN	TORQUE-OFF IN-LBS
6	7/32	.1900-32 UNJF-3B	.332 .328	.227 .223	.465 .450	.295	.380	.346 .332	.107	2,500	25-35
7	7/32	.2160-28 UNJF-3B	.394 .390	.259 .253	.508 .503	.315	.484	.440 .425	.107	3,300	40-55
8	9/32	.2500-28 UNJF-3B	.427 .423	.290 .286	.560 .545	.360	.484	.440 .425	.112	4,300	60-80
10	11/32	.3125-24 UNJF-3B	.560 .554	.356 .350	.680 .665	.450	.624	.565 .550	.122	6,300	130-160
12	13/32	.3750-24 UNJF-3B	.683 .675	.419 .413	.750 .735	.490	.763	.690 .675	.122	8,700	200-240
14	15/32	.4375-20 UNJF-3B	.748 .740	.481 .475	.870 .855	.580	.840	.753 .736	.137	12,100	270-330
16	17/32	.5000-20 UNJF-3B	.870 .860	.543 .537	.950 .935	.630	.970	.878 .861	.137	15,300	370-430
18	19/32	.5625-18 UNJF-3B	.925 .915	.613 .607	1.070 1.050	.705	1.120	.941 .924	.165	20,500	500-575
20	21/32	.6250-18 UNJF-3B	1.000 .990	.678 .672	1.155 1.135	.760	1.120	1.003 .986	.165	25,700	625-700
24	23/32	.7500-16 UNJF-3B	1.185 1.175	.803 .797	1.405 1.385	.970	1.240	1.128 1.110	.176	37,300	900-1000

- 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 and before application of lubricants.
 3. Use the following test bolts for thread lock inspection:
TB286PZ()L for HL197-().
TB64VF()L for HL197DJ(), HL197K(), HL197TF(), HL197V(), HL197LP(), HL197MA(), and HL197TF().
TB286PY()L for HL197EG().
TB8740PB()L for HL197DU().
TB8740PB()L for HL197KG(), HL197PB(),
TB286TB()L for HL197TB().

MATERIAL: A-286 high temperature alloy per AMS5731, AMS5734 or AMS5736.

- FINISH:**
- HL197-() = Silver plate per AMS2410, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL197DJ() = Solid film lube per AS5272, Type I plus green identification on body of collar.
 - HL197DU() = Solid film lube per AS5272, Type I plus yellow MIL-PRF-23377 identification on body of collar.
 - HL197EG() = Solid film lube per Everlube 620.
 - HL197K() = Solid film lube per Lubeco 905.
 - HL197KG() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color green and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL197LP() = Solid film lube per AS5272, type II
 - HL197MA() = Kalgard RA per AS5272, type II
 - HL197PB() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL197TB() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HL197TF() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
 - HL197V() = Solid film lube per Lubeco 2123.
 - HL197HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

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

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

EXAMPLE: HL197-8 = .2500-28 HI-LOK™ oversize collar, silver plate and cetyl alcohol lube.

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DATE	BY	TITLE	DRAWING NO.
DRAWN 1966-03-31	VAN	HI-LOK™ COLLAR	HL197
APPROVED 1966-03-31	R. TING	A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, SHEAR APPLICATION FOR USE ON 1/64" AND 1/32" OVERSIZE HI-LOK PINS	
REVISION 2024-04-12	C.Artois		