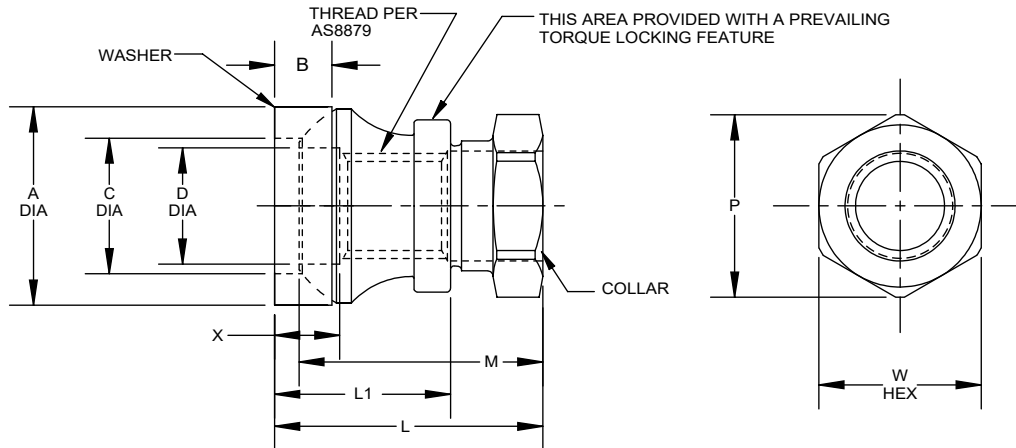




DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	D DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER. RAD	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
6	7/32	.1900-32 UNJF-3B	.400 .390	.120 .110	.295	.226	.465	.290	.415 .395	.414	.23	.378 .365	.122	4,000	40-50
8	9/32	.2500-28 UNJF-3B	.505 .495	.170 .160	.370	.289	.565	.355	.480 .460	.484	.26	.440 .425	.127	7,500	115-130
10	11/32	.3125-24 UNJF-3B	.645 .635	.170 .160	.453	.352	.675	.445	.600 .580	.484	.34	.440 .425	.137	11,750	200-250
12	13/32	.3750-24 UNJF-3B	.825 .815	.185 .175	.526	.416	.740	.485	.660 .640	.557	.38	.503 .488	.137	18,000	360-440
14	15/32	.4375-20 UNJF-3B	.935 .925	.225 .215	.605	.479	.865	.575	.750 .730	.624	.45	.565 .550	.152	23,750	525-600
16	17/32	.5000-20 UNJF-3B	1.045 1.035	.255 .245	.685	.542	.955	.625	.820 .800	.763	.51	.690 .675	.152	30,000	725-825
18	19/32	.5625-18 UNJF-3B	1.185 1.175	.270 .260	.807	.610	1.055	.700	.920 .900	.970	.71	.878 .861	.165	39,000	950-1075

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
 - Dimensions apply after finish and before application of lubricants.
 - For use on sloped surfaces up to 7° maximum.
 - DELETED.
 - Use TB64VF()L for HL289DU()A, HL289LP()A, and HL289YL()A thread lock inspection.
 - DELETED.

MATERIAL:

Collar - 17-4PH stainless steel per AMS5643.
 Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

HEAT TREAT:

Collar - Age to H-1025 condition per AMS2759.
 Washer - Age to H-1025 condition for 17-4PH, age to TH-1050 condition for 17-7PH and PH15-7Mo per AMS2759.

FINISH:

Collar - HL289-()A = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL289N()A = Diffused nickel-cadmium plate per AMS2416 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL289PB()A = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL289DU()A = Solid film lube per MIL-PRF-46010, Type I.
 HL289LP()A = Solid film lube per MIL-PRF-46010, Type II.
 HL289YL()A = Solid film lube per MIL-PRF-46010, Type II and yellow paint.

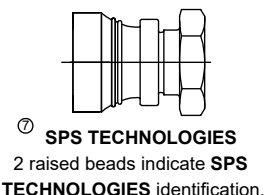
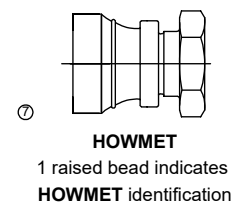
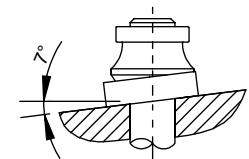
Washer - HL289-()GW = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL289-()DW = Solid film lube per MIL-PRF-46010, Type I.
 HL289-()NW = Diffused nickel-cadmium plate per AMS2416 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL289-()LPW = Solid film lube per MIL-PRF-46010, Type II.
 HL289-()PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

SPECIFICATION: HI-LOK™ HI-TIGUE™ Product Specification 345. Test bolt requirement exceptions per note 4 above.

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

EXAMPLE: HL289-8AGW = Assembly of HL289-8A collar and HL289-8GW washer.
 HL289DU8ADW = Assembly of HL289DU8A collar and HL289-8DW washer.
 HL289LP8ALPW = Assembly of HL289LP8A collar and HL289-8LPW washer.

HI-LOK™, "HL", and "HLT" ARE INTERNATIONAL REGISTERED TRADEMARKS OF HI-SHEAR CORPORATION



DATE	BY	TITLE	DRAWING NO.
1972-03-01	VAN	HI-LOK™ COLLAR	HL289
1972-03-02	R TING	SELF-ALIGNING COLLAR ASSEMBLY	
2020-07-23	A. CHAE	17-4PH STAINLESS STEEL	
		1/16 GRIP VARIATION, TENSION APPLICATION	
		1/32 OVERSIZE	