

DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 (REF)	P (REF)	W HEX	X (REF)	TENSION PRELOAD POUNDS MIN	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	11/64	.1640-32UNJC-3B	.307 .303	.188 .184	.447 .427	.270	.344	.314 .302	.107	350	1,400	10-20
6	7/32	.1900-32UNJF-3B	.332 .328	.227 .223	.457 .437	.280	.344	.314 .302	.107	500	1,600	20-30
8	9/32	.2500-28UNJF-3B	.427 .423	.290 .286	.552 .532	.340	.380	.346 .332	.112	1,000	3,000	55-70
10	11/32	.3125-24UNJF-3B	.578 .572	.353 .347	.672 .652	.430	.484	.440 .425	.122	1,650	5,000	100-125
12	13/32	.3750-24UNJF-3B	.688 .682	.416 .410	.744 .724	.470	.557	.503 .488	.122	2,300	7,000	170-200
14	15/32	.4375-20UNJF-3B	.773 .767	.483 .477	.862 .842	.560	.624	.565 .550	.137	3,100	9,500	220-270
16	17/32	.5000-20UNJF-3B	.880 .870	.543 .537	.942 .922	.610	.763	.690 .675	.137	4,100	12,500	310-370

- 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 HL477 for oversize replacement.
 4. Use TB7075AA()L for thread lock inspection.

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

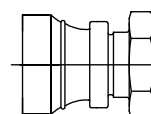
HEAT TREAT: Age tp T6 condition per Spec. AMS2770.

FINISH: HL377-() = Anodize per Spec. MIL-A-8625, dye color brown, and cetyl alcohol lubricant per Hi-Shear Spec. 305.
 HL377D-() = Anodize per MIL-A-8625 and solid film lube per AS5272.

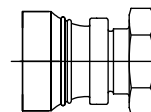
SPECIFICATION: ⑥ HI-LOK™ Product Specification 345, except tension preload as tabulated and test bolt requirement exception per note 4 above.

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

EXAMPLE: HL377-8 = 1/4-28 HI-LOK™ Collar with cetyl alcohol lubricant.



VOI-SHAN
 1 raised bead indicates
VOI-SHAN identification



STANDARD PRESSED STEEL
 2 raised beads indicate **STANDARD PRESSED STEEL** identification.

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

	DATE	BY	TITLE HI-LOK™ COLLAR 2024-T6 ALUMINUM ALLOY 1/16 GRIP VARIATION - SHEAR APPLICATION FOR USE ON 1/64 OR 1/32 OVERSIZE ALUMINUM ALLOY HI-LOK™ PINS	DRAWING NO.
DRAWN	1966-03-31	BRIEJ		HL377
APPROVED	1966-03-31	MILLER		
⑥ REVISION	2018-11-1	S. WILEY		
			1 of 1	