



FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 DIA REF	B DIA	L	L1 MAX	L2 REF	L3 REF	P REF	W HEX	X REF	X1 REF	UTS LBS. MIN	TORQUE-OFF IN-LBS
5	5/32	.1640-32 UNJC-3B	.287 .283	.325	.173 .166	.447 .427	.272	.290	.460	.344	.314 .302	.107	.125	2,300	15-25
6	3/16	.1900-32 UNJF-3B	.307 .303	.345	.212 .208	.457 .437	.292	.295	.470	.344	.314 .302	.107	.125	2,750	22-32
8	1/4	.2500-28 UNJF-3B	.412 .408	.450	.272 .268	.552 .532	.347	.360	.565	.484	.440 .425	.112	.130	5,000	50-70
10	5/16	.3125-24 UNJF-3B	.518 .512	.560	.336 .330	.672 .652	.437	.460	.685	.624	.565 .550	.122	.145	8,300	80-110
12	3/8	.3750-24 UNJF-3B	.620 .614	.670	.398 .392	.744 .724	.479	.500	.760	.700	.628 .613	.122	.150	12,700	140-180

GENERAL NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 2. Dimensions are in inches and to be met after finish and before application of lubricants.
 3. Use the following test bolts for thread lock inspection:
 TB64VF()L for HL379-(), HL379DL(), HL379TA(), and HL379V().
 TB64EG()L for HL379EG().

MATERIAL: Collar - 6Al-4V titanium alloy per AMS4928, AMS4930 or AMS4967 or 3Al-2.5V titanium alloy per AMS6940. (28)

Washer - 300 series stainless steel.

FINISH: Collar HL379-() = Surface coating per Hi-Shear Spec. 306, Type II, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
 HL379DL() = Solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL379EG() = Solid film lubricant per Everlube 620C.
 HL379TA() = Pretreat per Hi-Shear Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL379V() = Pretreat Ticermet B and solid film lubricant per Lubeco 2123, Type II.
 HL379HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
 Collar & Washer: HL379VW() = Both collar and washer with solid film lube per Lubeco 2123, Type II.
 HL379DLW() = Collar finish is same as HL379DL() and washer is passivate.
 HL379W() = Collar finish is same as HL379-() and washer is passivate.

SPECIFICATION: HI-LOK™ Product Specification 345. Use shear collar tension preload requirements. 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.

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

DATE	BY	TITLE	DRAWING NO.
DRAWN	1967-01-20	SHRODE	
APPROVED	2018-12-03	J.SOCKETT	
(28) REVISION	2018-12-03	D. OZCELIK	

HI-LOK™ COLLAR
 TITANIUM ALLOY
 1/16 GRIP VARIATION, SPECIAL APPLICATION
 FOR USE ON STANDARD AND 1/64 OVERSIZE
 HI-LOK™ PINS

HL379

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