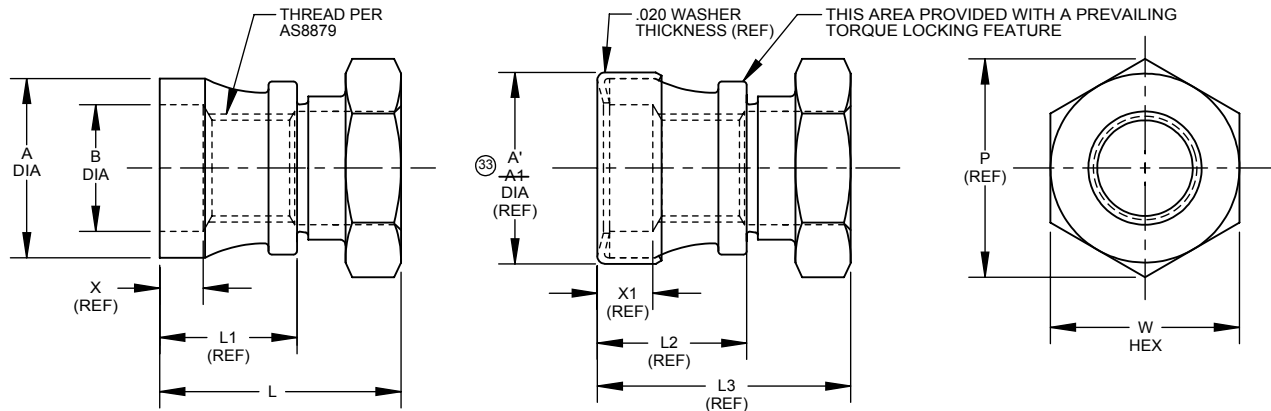


③

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DASH NO.	PIN NOM DIA	THREAD	A DIA	A' A4 DIA (REF)	B DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.292 .288	.337	.173 .166	.447 .427	.270	.300	.467	.344	.314 .302	.107	.137	1,400	15-25
6	3/16	.1900-32 UNJF-3B	.307 .303	.360	.200 .192	.457 .437	.280	.310	.477	.344	.314 .302	.107	.137	1,600	25-35
8	1/4	.2500-28 UNJF-3B	.412 .408	.462	.261 .252	.552 .532	.340	.370	.572	.380	.346 .332	.112	.142	3,000	60-80
10	5/16	.3125-24 UNJF-3B	.518 .512	.575	.325 .314	.672 .652	.430	.460	.692	.484	.440 .425	.122	.152	5,000	130-160
12	3/8	.3750-24 UNJF-3B	.628 .622	.690	.388 .376	.744 .724	.470	.500	.764	.557	.503 .488	.122	.152	7,000	200-240
14	7/16	.4375-20 UNJF-3B	.713 .707	.770	.450 .442	.862 .842	.560	.590	.882	.624	.565 .550	.137	.167	9,500	270-330
16	1/2	.5000-20 UNJF-3B	.815 .809	.872	.513 .501	.942 .922	.610	.640	.962	.763	.690 .675	.137	.167	12,500	370-430
18	9/16	.5625-18 UNJF-3B	NOTE: USE HL79-18												
20	5/8	.6250-18 UNJF-3B	NOTE: USE HL79-20												
24	3/4	.7500-16 UNJF-3B	NOTE: USE HL79-24												
28	7/8	.8750-14 UNJF-3B	NOTE: USE HL79-28												
32	1	1.0000-12 UNJF-3B	NOTE: USE HL79-32												

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 - ③ 2. Dimensions are in inches and apply after finish and before application of lubricants.
 3. Use HL79 for oversize replacement.
 - ③ 4. Use TB286PY()L for HL70K() thread lock inspection.

MATERIAL: ③ Collar 2024 aluminum alloy per AMS-QQ-A-225/6.
Washer NW - 300 series stainless steel.
TW - 5052 aluminum alloy per AMS-QQ-A-250/8, or 2024 aluminum alloy per AMS-QQ-A-250/4 or AMS-QQ-A-250/5.

HEAT TREAT: Collar Age to T6 condition per AMS2770.
Washer TW Age to T6 condition per AMS2770 (for 2024 only).

FINISH: ③ Collar HL70-() = Anodize per MIL-A-8625, dye color red, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL70D() = Anodize per MIL-A-8625 and solid film lube per AS5272, Type I.
HL70K() = Anodize per MIL-A-8625 and solid film lube per "Lubeco" 905.
HL70TF() = Anodize per MIL-A-8625 and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
HL70TT() = Anodize per MIL-A-8625, dye color red and translube.
Collar & Washer HL70DTW() = Collar finish same as HL70D(). Washer with anodize per MIL-A-8625, dye color grey, or blue (for 2024 only).
HL70NW() = Collar finish same as HL70-(). Washer is passivated.
HL70TW() = Collar finish same as HL70-(). Washer with anodize per MIL-A-8625, dye color grey, or blue (for 2024 only).

SPECIFICATION: HI-LOK™ Product Specification 345. Test bolt requirement exceptions per note ④ above. ③

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

EXAMPLES: HL70-8 = .2500-28 HI-LOK™ collar.
HL70TW8 = .2500-28 HI-LOK™ collar with aluminum washer.

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

DATE	BY	TITLE	DRAWING NO.
DRAWN 1960-07-27	VAN	HI-LOK™ COLLAR	HL70
APPROVED 1960-07-27	MEC	2024 - T6 ALUMINUM	
③ REVISION 2018-01-04	M.BEARD/S.WILEY	1/16 GRIP VARIATION, SHEAR APPLICATION	1 of 1