



DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 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	.287 .283	.320	.179 .166	.447 .427	.265	.280	.460	.344	.314 .302	.118	.138	3,050	30-40
6	3/16	.1900-32 UNJC-3B	.307 .303	.340	.205 .192	.457 .437	.275	.290	.470	.344	.314 .302	.118	.138	4,000	40-50
8	1/4	.2500-28 UNJF-3B	.413 .407	.445	.265 .252	.552 .532	.340	.355	.565	.380	.346 .332	.127	.147	7,500	115-130
10	5/16	.3125-24 UNJF-3B	.518 .512	.550	.330 .314	.672 .652	.430	.445	.685	.484	.440 .425	.139	.164	11,750	200-250
12	3/8	.3750-24 UNJF-3B	.628 .622	.660	.393 .376	.744 .724	.475	.490	.755	.557	.503 .488	.139	.167	18,000	360-420
14	7/16	.4375-20 UNJF-3B	.733 .727	.765	.456 .439	.862 .842	.560	.575	.875	.840	.753 .736	.157	.185	23,750	525-675
16	1/2	.5000-20 UNJF-3B	.848 .842	.880	.519 .501	.942 .922	.610	.625	.955	.970	.878 .861	.157	.185	30,000	725-1000
18	9/16	.5625-18 UNJF-3B	.915 .905	.910	.582 .570	1.029 1.009	.670	.685	1.042	.970	.878 .861	.171	.200	39,000	1000-1250
20	5/8	.6250-18 UNJF-3B	.995 .985	1.040	.650 .634	1.123 1.103	.735	.750	1.136	1.120	1.003 .986	.171	.200	49,000	1350-1550
24	3/4	.7500-16 UNJF-3B	1.120 1.110	1.140	.776 .762	1.371 1.351	.940	.955	1.384	1.240	1.128 1.110	.188	.215	70,000	1900-2200
28	7/8	.8750-14 UNJF-3B	1.345 1.335	1.365	.902 .887	1.575 1.545	1.060	1.075	1.584	1.520	1.380 1.356	.205	.240	95,000	3200-3600
32	1	1.0000-12 UNJF-3B	1.490 1.480	1.510	1.030 1.015	1.840 1.810	1.225	1.240	1.849	1.650	1.504 1.480	.229	.265	124,000	4500-5000

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions are in inches and apply after plating and before application of lubricants.
 3. Use HL273 for oversize replacement.
 - 4 Use TB64VF()L for HL73DU(), HL73DY(), HL73LP(), HL73V(), HL73DUW(), HL73DYW(), and HL73VW().

MATERIAL: Collar - 17-4PH stainless steel per AMS5643.
 Washer - 300 series stainless steel (.010 thick).
HEAT TREAT: Collar - To condition H1025 per AMS-H-6875.

FINISH: (30) Collar - HL73-() = Collar only with silver plate per AMS2410, plus blue identification on body of collar, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL73DU() = Collar only with solid film lube per AS5272, Type I.
 HL73DY() = Collar only with solid film lube per AS5272, Type I, plus yellow identification on body of collar.
 HL73LP() = Collar only with solid film lube per AS5272, Type II.
 HL73PB() = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL73V() = Collar only with solid film lubricant per Lubeco 2123.
 Collar & Washer - HL73DUW() = Collar and washer both with solid film lube per AS5272, Type I.
 HL73DYW() = Collar and washer both with solid film lube per AS5272, Type I.
 HL73VW() = Collar and washer both with Lubeco 2123 solid film lubricant.
 HL73W() = Collar same as HL73-() and washer is passivated.
 HL73VW() = Collar same as HL73-() and washer is solid film lube per Lubeco 2123.

SPECIFICATION: HI-LOK™ 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.

EXAMPLES: HL73-8 = 1/4-28 HI-LOK™ collar.
 HL73W8 = 1/4-28 HI-LOK™ collar with washer.

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DATE	BY	TITLE	DRAWING NO.
DRAWN	1961-04-24	DGF	
APPROVED	1961-04-24	MEC	
(30) REVISION	2019-10-31	F.CARINGELLA	

HI-LOK™ COLLAR
 17-4PH STAINLESS STEEL
 1/16 GRIP VARIATION, TENSION APPLICATION

HL73
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