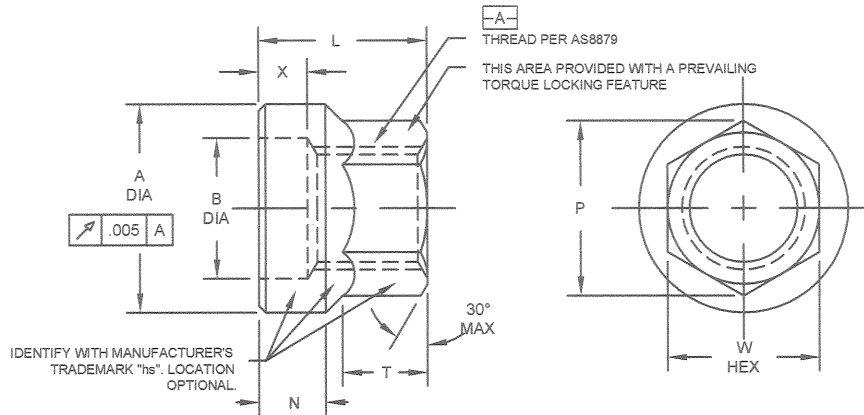




DASH NO.	THREAD	A DIA	B DIA	T MIN	N ±.010	L MAX	P MIN	W HEX	X ±.005	UTS LBS. MIN	WRENCH TORQUE IN-LBS
08	8-32UNJC-3B	.290 .280	.175 .170	.080	.100	.235	.244	.221 .213	.112	2,490	30
3	10-32UNJF-3B	.330 .320	.215 .210	.085	.110	.245	.277	.251 .243	.112	3,470	60
4	1/4-28UNJF-3B	.425 .415	.277 .272	.090	.110	.295	.348	.313 .305	.117	6,200	150
5	5/16-24UNJF-3B	.525 .515	.339 .334	.112	.120	.365	.419	.376 .367	.127	9,820	330
6	3/8-24UNJF-3B	.605 .595	.401 .396	.130	.130	.405	.491	.439 .430	.127	15,200	530

NOTES:

- Go Thread Gage penetration shall be 3/4 of one revolution minimum.
- Dimensions apply after plating and before lubrication
- "W" and "P" dimensions apply prior to deformation for self-locking feature.
- Nuts shall be forged. No flash extension permitted.
- Magnetic particle inspect -3 and larger nuts per NASM25027, allowable discontinuities per NAS3350.

MATERIALS:

8740 alloy steel per AMS-S-6049

HEAT TREAT:

200 KSI per AMS-H-6875

FINISH:

HLN306-() = Cadmium plate per AMS2401, thickness per AMS2401-2 except min shall be .0003"

LUBRICATION:

Solid film per AS5272, Ty I

SPECIFICATION:

NASM25027, except max torque for -3 shall be 15 in-lbs max and axial tensile strength as tabulated.

CODE:

Dash number indicates nominal thread size in 1/16ths.

EXAMPLE:

HLN306-4 = 1/4-28 Hi-Lok Nut with cadmium plate and solid film lube

	DATE	BY	TITLE HI-LOK[®] NUT ALLOY STEEL, DEEP COUNTERBORE, SELF-LOCKING 1/16" GRIP VARIATION FOR USE ON STANDARD, 1/64" OVERSIZE BOLTS	DRAWING NO. HLN306
DRAWN	5-29-08	A.B.		
APPROVED	5-29-08	J. Hayes		
- REVISION				