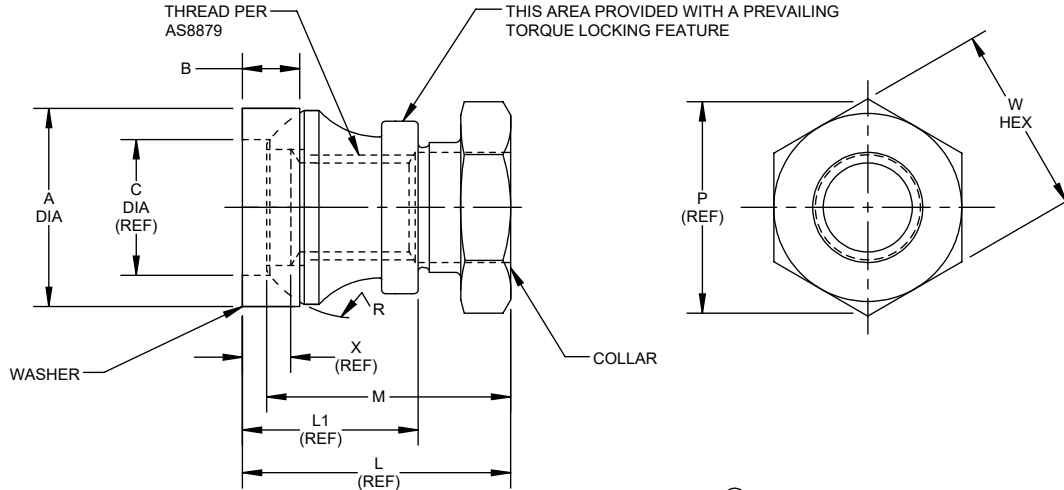




DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER. RAD (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.365 .355	.095 .085	.255	.455	.280	.420 .400	.420	.20	.378 .365	.107	1,940	22-32
6	3/16	.1900-32 UNJF-3B	.365 .355	.095 .085	.255	.455	.280	.420 .400	.420	.20	.378 .365	.107	2,500	32-42
8	1/4	.2500-28 UNJF-3B	.475 .465	.120 .110	.333	.540	.340	.510 .490	.557	.26	.503 .488	.112	4,300	75-90
10	5/16	.3125-24 UNJF-3B	.620 .600	.130 .120	.417	.660	.430	.617 .597	.624	.34	.565 .550	.122	6,300	140-170
12	3/8	.3750-24 UNJF-3B	.685 .675	.145 .135	.490	.730	.470	.677 .657	.700	.38	.628 .613	.122	8,700	210-260
14	7/16	.4375-20 UNJF-3B	.805 .795	.180 .170	.570	.855	.562	.772 .752	.840	.45	.753 .736	.137	12,100	310-370
16	1/2	.5000-20 UNJF-3B	.915 .905	.205 .195	.648	.925	.612	.842 .822	.970	.51	.878 .861	.137	15,300	410-470

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
 - For use on sloped surfaces up to 7° maximum on standard and 1/64 oversize HI-LOK™ shear head pins.
 - Dimensions are in inches and apply after finish and before application of lubricants.

4 Use TB64VF()L for HL185DU()A, HL185LP()A, and HL185TF()A.

Use TB8740PB()L for HL185PB()A and HL185-()A

MATERIAL: Collar - A-286 high temperature alloy per AMS5731,AMS5734.

Washer - A-286 high temperature alloy per AMS5731 or AMS5737.

HEAT TREAT: Collar - None.

Washer - 90,000 psi shear minimum.

FINISH: Collar - HL185-()A = Silver plate per AMS2410 and cetyl alcohol lube per Hi-shear Spec. 305.
HL185DU()A = Solid film lube per AS5272, Type I.
HL185LP()A = Solid film lube per AS5272, Type II.
HL185PB()A = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL185TF()A = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
HL185HK()A = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Washer - HL185-()W = Silver plate per AMS2410 and cetyl alcohol lube per Hi-shear Spec. 305.

HL185-()DW = Solid film lube per AS5272, Type I.

HL185-()LPW = Solid film lube per AS5272, Type II.

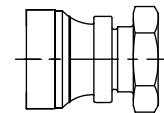
HL185-()PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

HL185-()WU = Passivate per AMS2700, Method 1, Type 8.

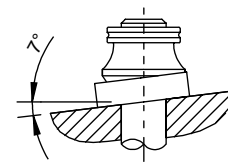
SPECIFICATION: HI-LOK™ Product Specification 345. Test bolt requirement exceptions per note 4 above.

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

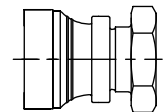
EXAMPLE: HL185-8AW = Assembly of HL185U-8A collar and HL185-8W washer, both with silver plate and cetyl alcohol lube.



11 **HOWMET**
1 raised bead indicates
HOWMET identification



11 **SPS TECHNOLOGIES**
2 raised beads indicate
SPS TECHNOLOGIES identification.



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

DATE	BY	TITLE	DRAWING NO.
1971-10-04	VAN	11 HI-LOK™ COLLAR SELF-ALIGNING COLLAR ASSEMBLY A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION - SHEAR APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LOK™ PINS	HL185 1 of 1
1971-10-06	R. TING		
2023-10-24	C.ARTOS		
REVISION			