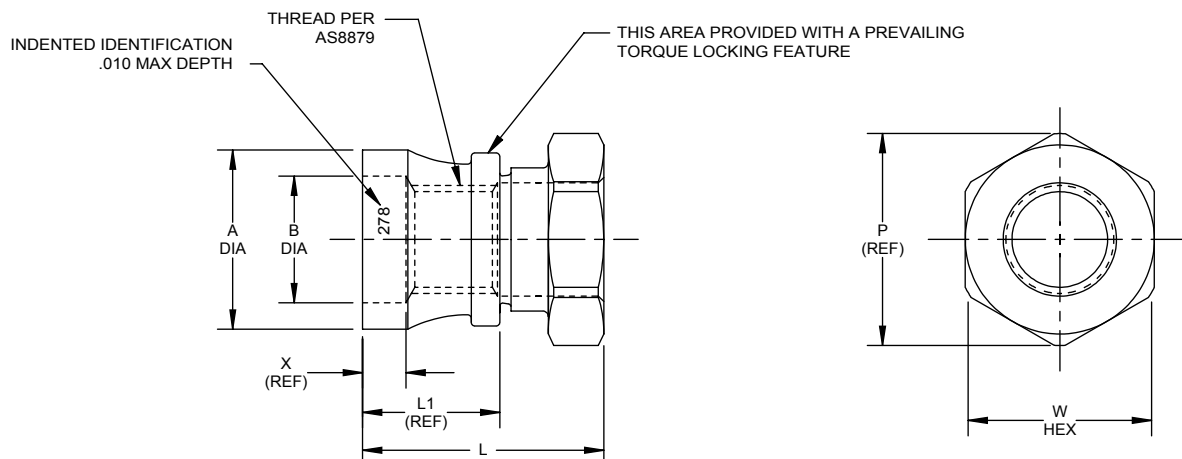


(1)

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(1)

DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L LENGTH	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH- POUNDS
5	5/32	.1640-32UNJC-3B	.287 .283	.173 .169	.447 .427	.265	.344	.314 .302	.107	2,300	30-40
6	13/64	.1900-32UNJF-3B	.307 .303	.212 .208	.457 .437	.275	.344	.314 .302	.107	2,750	40-50
8	17/64	.2500-28UNJF-3B	.412 .408	.272 .268	.552 .532	.340	.484	.440 .425	.112	5,000	115-130
10	21/64	.3125-24UNJF-3B	.518 .512	.336 .330	.672 .652	.430	.624	.565 .550	.122	8,300	200-250
12	25/64	.3750-24UNJF-3B	.620 .614	.398 .392	.744 .724	.475	.715	.628 .613	.122	12,700	360-420
14	29/64	.4375-20UNJF-3B	.733 .727	.463 .457	.862 .842	.565	.840	.753 .736	.137	19,000	525-675
16	33/64	.5000-20UNJF-3B	.848 .842	.528 .522	.942 .922	.615	.970	.878 .861	.137	25,500	725-1000

**NOTES:**

1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. Dimensions are in inches and apply after finish and before application of lubricants.
3. Non-lubed collars must be used with lubed pin.
4. Use HL478 for oversize replacement.
5. Use TB64VF( )L for HL278DK( ), HL278DU( ), HL278EG( ), HL278K( ), and HL278V( ).

**MATERIAL:** (1) Collar - A-286 high temperature alloy per AMS5731 or AMS5734.

**FINISH:** [3] HL278-( ) = Silver plate per AMS2410, except not baked, to .0002 thick on surfaces which can be touched by a .75 inch ball. Threads shall show evidence of plate but thickness requirement are waived.

HL278DK( ) = Kalgard FA solid film lube.  
 HL278DU( ) = Solid film lube per AS5272, Type I.  
 HL278EG( ) = Everlube 620 solid film lube.  
 HL278K( ) = Solid film lube per Lubeco 905.

[3] HL278GU( ) = Silver plate per AMS2410.  
 HL278PB( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL278V( ) = Solid film lube per Lubeco 2123.

**SPECIFICATION:** HI-LOK™ Product Specification 345. Test bolt requirement exceptions per note [5] above. (1)

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

**EXAMPLE:** HL278PB8 = 1/4-28 HI-LOK™ collar with cadmium plate, Type II, Class 2, and cetyl alcohol lube.

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

			TITLE  <b>HI-LOK™ COLLAR</b>  A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, TENSION APPLICATION FOR USE ON 1/64 OVERSIZE HI-LOK™ PINS	DRAWING NO.  <b>HL278</b>  1 of 1
	DATE	BY		
DRAWN	1966-03-31	BRIEJ		
APPROVED	1966-03-31	M.E.C.		
(1) REVISION	2018-02-12	M.BEARD/S.WILEY		