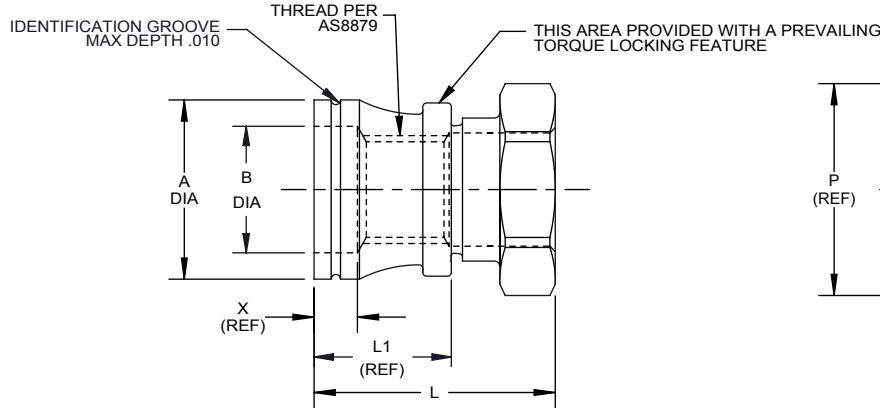




DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	Use HL94-6										
6	7/32	.1900-32 UNJF-3B	.332 .328	.227 .223	.470 .450	.290	.380	.346 .332	.122	2,750	25-35
8	9/32	.2500-28 UNJF-3B	.427 .423	.290 .286	.565 .545	.355	.484	.440 .425	.127	5,000	60-80
10	11/32	.3125-24 UNJF-3B	.548 .542	.356 .350	.685 .665	.445	.484	.440 .425	.137	8,300	130-160
12	13/32	.3750-24 UNJF-3B	.658 .652	.419 .413	.755 .735	.485	.557	.503 .488	.137	12,700	200-240
14	15/32	.4375-20 UNJF-3B	.775 .765	.481 .475	.862 .842	.565	.970	.878 .861	.152	19,000	270-330
16	17/32	.5000-20 UNJF-3B	.880 .870	.543 .537	.942 .922	.615	1.120	1.003 .986	.152	25,500	370-430
18	19/32	.5625-18 UNJF-3B	.925 .915	.613 .607	1.060 1.040	.700	1.120	1.003 .986	.165	29,500	500-575
20	21/32	.6250-18 UNJF-3B	1.000 .990	.678 .672	1.145 1.125	.755	1.120	1.003 .986	.165	32,000	625-750
24	25/32	.7500-16 UNJF-3B	1.185 1.175	.803 .797	1.415 1.385	.975	1.240	1.128 1.110	.175	42,000	900-1000
28	29/32	.8750-14 UNJF-3B	1.360 1.350	.924 .918	1.615 1.585	1.100	1.520	1.380 1.356	.190	62,000	1200-1325
32	1-1/32	1.0000-12 UNJF-3B	1.530 1.520	1.055 1.045	1.915 1.885	1.300	1.650	1.504 1.480	.210	84,000	1450-1600

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
 - Dimensions are in inches and apply after finish and before application of lubricants.
 - Use HL394 for oversize replacement.

④ Use TB64VF() L for HL294D(), and HL294DU().

MATERIAL: 303 Se stainless steel per ASTM A582.

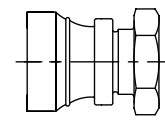
FINISH: HL294-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL294D() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 and solid film lubricant per MIL-PRF-46010, Type I.

⑨ HL294DU() = Solid film lube per MIL-PRF-46010, Type I.

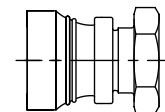
SPECIFICATION: HI-LOK™ Product Specification 345. Test bolt requirement exceptions per note ④ above.

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

EXAMPLE: HL294-8 = .2500-28 HI-LOK™ oversize collar with Type II cadmium plate.



VOI-SHAN
1 raised bead indicates
VOI-SHAN identification



STANDARD PRESSED STEEL
2 raised beads indicate **STANDARD PRESSED STEEL** identification.

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

DATE	BY	HI-LOK™ COLLAR TYPE 303 Se STAINLESS STEEL 1/16 GRIP VARIATION, SHEAR APPLICATION FOR USE ON 1/32 OVERSIZE HI-LOK™ PINS	DRAWING NO.
DRAWN	1962-06-12		HL294
APPROVED	1962-06-12		1 of 1
⑨ REVISION	2019-10-22		