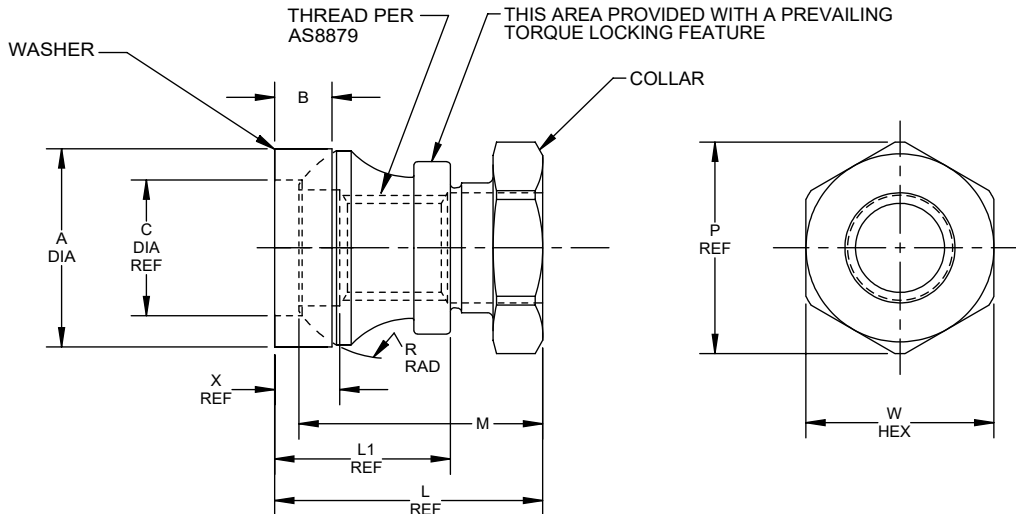




DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER. RAD	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
6	7/32	.1900-32 UNJF-3B	.400 .390	.120 .110	.295	.465	.290	.415 .395	.380	.23	.346 .332	.122	2,750	40-50
8	9/32	.2500-28 UNJF-3B	.505 .495	.170 .160	.370	.565	.355	.480 .460	.484	.26	.440 .425	.127	5,000	115-130
10	11/32	.3125-24 UNJF-3B	.645 .635	.170 .160	.453	.675	.445	.600 .580	.484	.34	.440 .425	.137	8,300	200-250
12	13/32	.3750-24 UNJF-3B	.825 .815	.185 .175	.526	.740	.485	.660 .640	.557	.38	.503 .488	.137	12,700	360-440
14	15/32	.4312-20 UNJF-3B	.935 .925	.225 .215	.605	.865	.575	.750 .730	.624	.45	.565 .550	.152	19,000	550-625
16	17/32	.5000-20 UNJF-3B	1.045 1.035	.255 .245	.685	.955	.625	.820 .800	.763	.51	.690 .675	.152	25,500	725-825
18	19/32	.5625-18 UNJF-3B	1.185 1.175	.270 .260	.807	1.055	.700	.920 .900	.970	.71	.878 .861	.165	32,400	950-1075

NOTES:

- Go thread gage penetration shall be 3/4 of one revolution minimum.
- For use on sloped surfaces up to 7° maximum.
- Dimensions are in inches and apply after finish and before application of lubricants.
- Use TB64VF()L for HL375DK()A, HL375DU()A, HL375TF()A, and HL375HK()A.

MATERIAL:

Collar - Type 303 Se stainless steel per ASTM A582 (AMS5640), 110-140 ksi UTS.
 Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

HEAT TREAT:

Collar - None.
 Washer - Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per AMS-H-6875.

FINISH:

Collar - HL375-()A = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, with cetyl alcohol lube per Hi-Shear Spec. 305.
 HL375DK()A = Kalgard FA, special cure for vacuum compatibility.
 HL375DU()A = Solid film lube per AS5272, Type I.
 HL375G()A = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL375TF()A = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
 HL375V()A = Solid film lube per "Lubeco" 2123.
 HL375HK()A = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
 Washer - HL375-()DKW = Kalgard FA, special cure for vacuum compatibility.
 HL375-()DW = Solid film lube per AS5272, Type I.
 HL375-()GW = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL375-()KW = Solid film lube per "Lubeco" 905.
 (11) HL375-()PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 HL375-()VW = Solid film lube per "Lubeco" 2123.
 HL375-()W = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.
 HL375-()WU = Passivate per AMS2700, Method 1, Type 8.

SPECIFICATION:

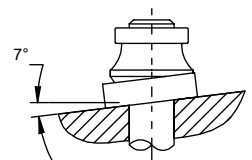
HI-LOK™ HI-TIGUE™ Product Specification 345. Test bolt requirement exceptions per note 4 above.

CODE:

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

EXAMPLE:

HL375-8AW = Assembly of HL375-8A collar and HL375-8W washer.
 HL375V8AVW = Assembly of HL375V-8A collar and HL375-8VW washer.



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

	DATE	BY	TITLE	DRAWING NO.
DRAWN	1972-12-08	VAN	HI-LOK™ COLLAR	HL375
APPROVED	1972-12-21	R. TING	SELF-ALIGNING COLLAR ASSEMBLY	
			303 STAINLESS STEEL	
			1/16 GRIP VARIATION, TENSION APPLICATION	
			FOR USE ON 1/32 OVERSIZE HI-LOK™ PINS	
(11) REVISION	2020-06-30	A. CHAE		1 of 1