

DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 (REF)	P (REF)	W HEX	X (REF)	TENSION PRELOAD POUNDS MIN	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	11/64	.1640-32UNJC-3B	.307 .303	.188 .184	.447 .427	.270	.344	.314 .302	.107	350	1,400	10-20
6	7/32	.1900-32UNJF-3B	.332 .328	.227 .223	.457 .437	.280	.344	.314 .302	.107	500	1,600	20-30
8	9/32	.2500-28UNJF-3B	.427 .423	.290 .286	.552 .532	.340	.380	.346 .332	.112	1,000	3,000	55-70
10	11/32	.3125-24UNJF-3B	.578 .572	.353 .347	.672 .652	.430	.484	.440 .425	.122	1,650	5,000	100-125
12	13/32	.3750-24UNJF-3B	.688 .682	.416 .410	.744 .724	.470	.557	.503 .488	.122	2,300	7,000	170-200
14	15/32	.4375-20UNJF-3B	.773 .767	.483 .477	.862 .842	.560	.624	.565 .550	.137	3,100	9,500	220-270
16	17/32	.5000-20UNJF-3B	.880 .870	.543 .537	.942 .922	.610	.763	.690 .675	.137	4,100	12,500	310-370

- 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. Use HL477 for oversize replacement.
 4. Use TB7075AA(J) L for thread lock inspection.

MATERIAL: 2024 aluminum alloy per QQ-A-430 or AMS-QQ-A-225/6.

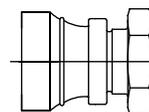
HEAT TREAT: Age tp T6 condition per Spec. AMS2770.

FINISH: HL377-() = Anodize per Spec. MIL-A-8625, dye color brown, and cetyl alcohol lubricant per Hi-Shear Spec. 305.
 HL377D-() = Anodize per MIL-A-8625 and solid film lube per AS5272.

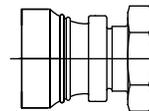
SPECIFICATION: ⑥ HI-LOK™ Product Specification 345, except tension preload as tabulated and test bolt requirement exception per note 4 above.

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

EXAMPLE: HL377-8 = 1/4-28 HI-LOK™ Collar with cetyl alcohol lubricant.



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

			TITLE	DRAWING NO.
	DATE	BY	HI-LOK™ COLLAR 2024-T6 ALUMINUM ALLOY 1/16 GRIP VARIATION - SHEAR APPLICATION FOR USE ON 1/64 OR 1/32 OVERSIZE ALUMINUM ALLOY HI-LOK™ PINS	HL377 1 of 1
DRAWN	1966-03-31	BRIEJ		
APPROVED	1966-03-31	MILLER		
⑥ REVISION	2018-11-1	S. WILEY		