



FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 DIA REF	B DIA	L	L1 MAX	L2 REF	L3 REF	P REF	W HEX	X REF	X1 REF	UTS LBS. MIN	TORQUE-OFF IN-LBS
5	5/32	.1640-32 UNJC-3B	.287 .283	.325	.173 .166	.447 .427	.272	.290	.460	.344	.314 .302	.107	.125	2,300	15-25
6	3/16	.1900-32 UNJF-3B	.307 .303	.345	.212 .208	.457 .437	.292	.295	.470	.344	.314 .302	.107	.125	2,750	22-32
8	1/4	.2500-28 UNJF-3B	.412 .408	.450	.272 .268	.552 .532	.347	.360	.565	.484	.440 .425	.112	.130	5,000	50-70
10	5/16	.3125-24 UNJF-3B	.518 .512	.560	.336 .330	.672 .652	.437	.460	.685	.624	.565 .550	.122	.145	8,300	80-110
12	3/8	.3750-24 UNJF-3B	.620 .614	.670	.398 .392	.744 .724	.479	.500	.760	.700	.628 .613	.122	.150	12,700	140-180

**GENERAL NOTES:**

- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
- Dimensions are in inches and to be met after finish and before application of lubricants.
- Use the following test bolts for thread lock inspection:  
 TB64VF(L) for HL379(-), HL379DL(), HL379TA(), and HL379V().  
 TB64EG(L) for HL379EG().

**MATERIAL:** Collar - 6Al-4V titanium alloy per AMS4928, AMS4930 or AMS4967 or 3Al-2.5V titanium alloy per AMS6940. (28)

Washer - 300 series stainless steel.

**FINISH:**

- Collar HL379(-) = Surface coating per Hi-Shear Spec. 306, Type II, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- HL379DL() = Solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL379EG() = Solid film lubricant per Everlube 620C.
- HL379TA() = Pretreat per Hi-Shear Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HL379V() = Pretreat Ticermet B and solid film lubricant per Lubeco 2123, Type II.
- HL379HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Collar & Washer:

- HL379VW() = Both collar and washer with solid film lube per Lubeco 2123, Type II.
- HL379DLW() = Collar finish is same as HL379DL() and washer is passivate.
- HL379W() = Collar finish is same as HL379(-) and washer is passivate.

**SPECIFICATION:** HI-LOK™ Product Specification 345. Use shear collar tension preload requirements. Test bolt requirement exceptions per note 3 above.

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

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

DATE	BY	TITLE	DRAWING NO.
1967-01-20	SHRODE	<b>HI-LOK™ COLLAR</b> TITANIUM ALLOY 1/16 GRIP VARIATION, SPECIAL APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LOK™ PINS	<b>HL379</b>
2018-12-03	J.SOCKETT		
2018-12-03	D. OZCELIK		
(28) REVISION			