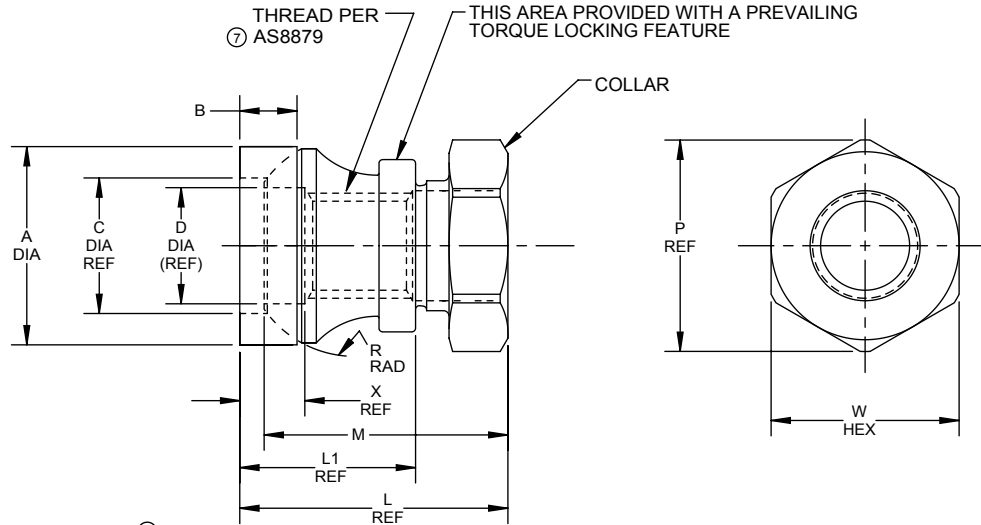




DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	D DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER RAD	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
6	7/32	.1900-32 UNJF-3B	.400 .390	.120 .110	.295	.226	.465	.290	.415 .395	.380	.23	.346 .332	.122	1,600	32-42
8	9/32	.2500-28 UNJF-3B	.505 .495	.170 .160	.370	.289	.565	.355	.480 .460	.484	.26	.440 .425	.127	3,000	75-90
10	11/32	.3125-24 UNJF-3B	.645 .635	.170 .160	.453	.352	.675	.445	.600 .580	.484	.34	.440 .425	.137	5,000	140-170
12	13/32	.3750-24 UNJF-3B	.825 .815	.185 .175	.526	.416	.740	.485	.660 .640	.557	.38	.503 .488	.137	7,000	220-260
14	15/32	.4312-20 UNJF-3B	.935 .925	.225 .215	.605	.479	.865	.575	.750 .730	.624	.45	.565 .550	.152	9,500	310-370
16	17/32	.5000-20 UNJF-3B	1.045 1.035	.255 .245	.685	.542	.955	.625	.820 .800	.763	.51	.690 .675	.152	12,500	410-470
18	19/32	.5625-18 UNJF-3B	1.185 1.175	.270 .260	.807	.615	1.055	.700	.920 .900	.970	.71	.878 .861	.165	14,500	575-650
20	21/32	.6250-18 UNJF-3B	1.375 1.360	.315 .305	.872	.695	1.135	.755	1.015 .995	1.120	.76	1.003 .986	.165	18,000	700-775
24	25/32	.7500-16 UNJF-3B	1.560 1.545	.390 .380	1.027	.815	1.400	.975	1.255 1.235	1.240	.81	1.128 1.110	.175	27,500	1000-1100

NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.

⑦ 2. Dimensions are in inches and apply after finish.

3. For use on sloped surfaces up to 7° maximum.

MATERIAL: ⑦ Collar - 2024 aluminum alloy per QQ-A-430 or AMS-QQ-A-225/6.
⑦ Washer - "W" = 17-4 PH stainless steel per AMS5643, or 17-7ph per AMS5528, or PH15-7Mo per AMS5520.
"C" = A-286 high temperature alloy per AMS5731 or AMS5737.

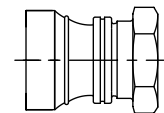
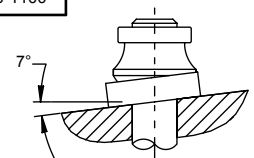
HEAT TREAT: ⑦ Collar - Age to T6 condition per AMS-H-6088.
Washer - "W" = Age to H-1025 condition for 17-4ph, age to TH1050 condition for 17-7PH and 15-7Mo per AMS-H-6875.
"C" = 90,000 psi shear minimum.

FINISH: Collar - HL382-()A = Anodize per MIL-A-8625, color gold, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL382K-()A = Anodize per MIL-A-8625, and solid film per "LUBECO" 905.
Washer - HL382-()CU = Passivate per Hi-Shear Spec. 258.
⑦ HL382-()DW = Solid film lube per AS5272, Type I.
⑦ HL382-()PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2..

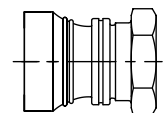
SPECIFICATION: HI-LOK™ HI-TIGUE™ Product Specification 345.

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

EXAMPLE: HL382-8ADW = Assembly of HL382-8A collar and HL382-8DW washer.
HL382-8APBW = Assembly of HL382-8A collar and HL382-8PBW washer.
HL382-8ACU = Assembly of HL382-8A collar and HL382-8CU washer.



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	TITLE	DRAWING NO.
DRAWN	1971-07-28	VAN	HI-LOK™ COLLAR	HL382
APPROVED	1971-07-29	R. TING	SELF-ALIGNING COLLAR ASSEMBLY (ALUMINUM COLLAR-STAINLESS STEEL WASHER) 1/16 GRIP VARIATION, SHEAR APPLICATION FOR USE ON 1/32 OVERSIZE HI-LOK™ PINS	1 of 1
⑦ REVISION	2017-12-13	KEVIN TRAN		