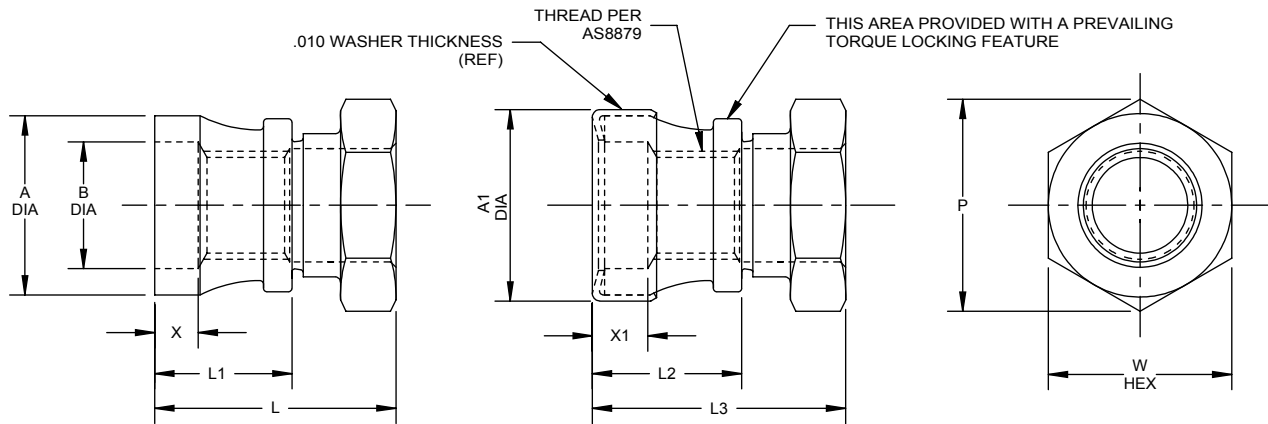


(34)



(34)

DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L LENGTH	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.287 .283	.320	.173 .166	.447 .427	.265	.280	.460	.344	.314 .302	.107	.120	2,300	30-40
6	3/16	.1900-32 UNJF-3B	.307 .303	.340	.212 .208	.457 .437	.275	.290	.470	.344	.314 .302	.107	.120	2,750	40-50
8	1/4	.2500-28 UNJF-3B	.412 .408	.442	.272 .268	.552 .532	.340	.355	.565	.484	.440 .425	.112	.125	5,000	110-130
10	5/16	.3125-24 UNJF-3B	.518 .512	.552	.336 .330	.672 .652	.430	.446	.685	.624	.565 .550	.122	.135	8,300	200-250
12	3/8	.3750-24 UNJF-3B	.620 .614	.665	.398 .392	.744 .724	.475	.490	.755	.715	.628 .613	.122	.135	12,700	360-420
14	7/16	.4375-20 UNJF-3B	.733 .727	.765	.463 .457	.862 .842	.560	.575	.875	.840	.753 .736	.137	.150	19,000	525-600
16	1/2	.5000-20 UNJF-3B	.848 .842	.880	.528 .522	.942 .922	.610	.625	.955	.970	.878 .861	.137	.150	25,500	725-825
18	9/16	.5625-18 UNJF-3B	.915 .905	.940	.598 .592	1.029 1.009	.670	.685	1.042	1.045	.941 .924	.145	.158	29,000	1000-1150
20	5/8	.6250-18 UNJF-3B	.995 .985	1.020	.661 .655	1.123 1.103	.735	.750	1.136	1.120	1.003 .986	.145	.158	32,000	1350-1550
24	3/4	.7500-16 UNJF-3B	1.120 1.110	1.190	.786 .780	1.371 1.351	.940	.960	1.485	1.240	1.128 1.110	.156	.170	42,000	1900-2200
28	7/8	.8750-14 UNJF-3B	1.345 1.335	1.365	.911 .905	1.575 1.545	1.060	1.080	1.585	1.520	1.380 1.356	.169	.182	62,000	3200-3600
32	1	1.0000-12 UNJF-3B	1.490 1.480	1.525	1.036 1.030	1.840 1.810	1.225	1.245	1.850	1.650	1.504 1.480	.186	.200	84,000	4500-5000

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

	DATE	BY	TITLE HI-LOK™ COLLAR A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, TENSION APPLICATION	DRAWING NO.
DRAWN	1960-11-31	R.K.L.		HL78
APPROVED	1960-11-31	M.E.C.		
(34) REVISION	2018-09-05	M.BEARD/S.WILEY		

GENERAL 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. Non-lubed collars must be used with lubed pin.
4. Use HL278 for oversize replacement.
5. Use the following test bolts for thread lock inspection:
TB64-() L for HL78DK(), HL78DU(), HL78DUW(), HL78V(), HL78ET() and HL78VW().
TB286PY() L for HL78EG().

MATERIAL: 34 Collar A-286 high temperature alloy per AMS5731 or AMS5734.
Washer Type 300 series stainless steel.

FINISH: Collar

HL78-()	= Collar only with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
HL78DK()	= Collar only with vacuum compatible Kalgard FA solid film lube.
34 HL78DR()	= Collar only with cadmium plate per AMS-QQ-P-416, Type III, Class 3, and solid film lube per "Drilube" 702.
HL78DU()	= Collar only with solid film lube per AS5272, Type I.
HL78EG()	= Collar only with Everlube 620 solid film lube.
HL78K()	= Collar only with solid film lube per Lubeco 905.
3 [HL78GU()]	= Collar only with silver plate per AMS2410.
HL78P()	= Collar only with cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL78PB()	= Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HL78V()	= Collar only with solid film lube per Lubeco 2123.
34 HL78ET()	= Collar only with solid film lube Tiodize 614 per AS1701, Type IV.

Collar & Washer

HL78DUW()	= Collar finish the same as HL78DU(), and washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2.
34 HL78DRPBW()	= Collar finish the same as HL78DR(), and washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2.
34 HL78PBW()	= Collar finish the same as HL78PB(), and washer with passivate per AMS2700.
34 HL78PW()	= Collar finish same as HL78P(), and washer with passivate per AMS2700.
34 HL78W()	= Collar with silver plate and cetyl alcohol lube, and washer with passivate per AMS2700.
HL78VW()	= Collar and washer both Lubeco 2123 solid film lube.

SPECIFICATION: HI-LOK™ Product Specification 345. Test bolt requirement exceptions per note 5 above. 34

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

EXAMPLE: HL78PBW8 = 1/4-28 HI-LOK™ collar with cadmium plate, Type II, Class 2, and cetyl alcohol lube. Washer is passivated.

DRAWING NO.

HL78

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