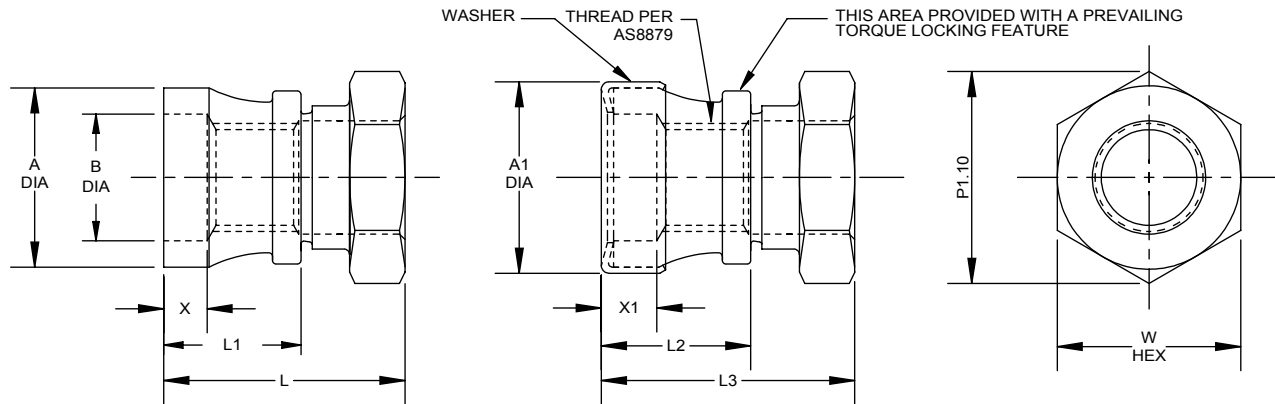




DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L LENGTH	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B			NOTE: USE HL86-5 for -.5 diameter pin.										
6	13/64	.1900-32 UNJF-3B	.307 .303	.340	.212 .208	.457 .437	.275	.290	.470	.344 .302	.314 .302	.107	.120	2,750	40-50
8	17/64	.2500-28 UNJF-3B	.412 .408	.442	.272 .268	.552 .532	.340	.355	.565	.380 .332	.346 .332	.112	.125	5,000	110-130
10	21/64	.3125-24 UNJF-3B	.518 .512	.552	.336 .330	.672 .652	.430	.445	.685	.484 .425	.440 .425	.122	.135	8,300	200-250
12	25/64	.3750-24 UNJF-3B	.628 .622	.665	.398 .392	.744 .724	.475	.490	.755	.557 .488	.503 .488	.122	.135	12,700	360-420
14	29/64	.4375-20 UNJF-3B	.733 .727	.775	.463 .457	.862 .842	.560	.575	.875	.840 .736	.753 .736	.137	.150	19,000	525-675
16	33/64	.5000-20 UNJF-3B	.848 .842	.895	.528 .522	.942 .922	.610	.625	.955	.970 .861	.878 .861	.137	.150	25,500	725-1000
18	37/64	.5625-18 UNJF-3B	.915 .905	.910	.598 .592	1.029 1.009	.670	.685	1.042	.970 .861	.878 .861	.145	.158	29,000	1000-1150
20	41/64	.6250-18 UNJF-3B	.995 .985	1.040	.661 .655	1.123 1.103	.735	.750	1.136	1.120 .986	1.003 .986	.145	.158	32,000	1350-1550
24	49/64	.7500-16 UNJF-3B	1.120 1.110	1.140	.786 .780	1.371 1.351	.940	.955	1.384	1.240 1.110	1.128 1.110	.156	.169	42,000	1900-2200
28	57/64	.8750-14 UNJF-3B	1.345 1.335	1.365	.911 .905	1.575 1.545	1.060	1.075	1.584	1.520 1.356	1.380 1.356	.169	.182	62,000	3200-3600
32	1-1/64	1.0000-12 UNJF-3B	1.490 1.480	1.510	1.036 1.030	1.840 1.810	1.225	1.240	1.849	1.650 1.480	1.504 1.480	.186	.199	84,000	4500-5000

- 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. Use HL93 for oversize replacement.
 4. Use HL273 for higher tension application.
 - 5 Use TB64VF()L for HL87D(), HL87DU(), and HL87DUW().

MATERIAL: Collar 303 Se stainless steel per ASTM A-582 (AMS5640).
 Washer 300 series stainless steel (.010 thick). 2024-T6 aluminum alloy (.020 thick) per AMS-QQ-A-250/4 or QQ-A-250/5 (sizes -6 through -12 only).

FINISH: Collar HL87-() = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL87D() = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and solid film lube per AS5272, Type I.
 HL87DU() = Collar only with solid film lube per AS5272, Type I.
 HL87DJ() = Collar only with solid film lube per AS5272, Type I, plus green identification on body of collar.
 HL87G() = Collar only with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL87KP() = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, color violet to purple, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL87T() = Collar with cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 Collar & Washer HL87DUW() = Collar finish same as HL87DU(), and steel washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2, no lube.
 HL87GGW() = Collar and steel washer both with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL87W() = Collar finish same as HL87-(), and steel washer with cadmium plate per AMS-QQ-P-416, Type I, Class 2.
 HL87KPW() = Collar finish same as HL87KP(), and steel washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2, no lube.
 HL87TW() = Collar with cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305, and aluminum washer anodize per MIL-A-8625, dye color blue (sizes -6 through -12 only).

SPECIFICATION: HI-LOK™ Product Specification 345. Test bolt requirement exceptions per note 5 above. 42

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

EXAMPLES: HL87G8 = 1/4-28 HI-LOK™ collar with silver plate.
 HL87W8 = 1/4-28 HI-LOK™ collar and steel washer, both with cadmium plate.

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

	DATE	BY	TITLE HI-LOK™ COLLAR TYPE 303 Se STAINLESS STEEL 1/16 GRIP VARIATION, TENSION APPLICATION FOR USE ON 1/64 OVERSIZE HI-LOK™ PINS	DRAWING NO.
DRAWN	1960-07-21	VAN		HL87
APPROVED	1960-07-21	MEC		
(42) REVISION	2018-08-13	S.WILEY		