



| 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 ±.005 | X1 (REF) | UTS LBS. MIN | TORQUE-OFF INCH-POUNDS |
|----------|-------------|----------------|--------------|--------------|--------------|--------------|----------|----------|----------|---------|--------------|---------|----------|--------------|------------------------|
| 5 | 5/32 | 8-32UNJC-3B | .287 .283 | .320 | .173 .166 | .447 .427 | .272 | .280 | .460 | .344 | .314 .302 | .107 | .120 | 2,300 | 20-30 |
| 6 | 13/64 | 10-32UNJF-3B | .307 .303 | .340 | .212 .208 | .457 .437 | .282 | .290 | .470 | .344 | .314 .302 | .107 | .120 | 2,750 | 35-45 |
| 7 | 15/64 | 12-32UNJEF-3B | .374 .370 | .405 | .240 .236 | .500 .480 | .310 | .313 | .513 | .484 | .440 .425 | .107 | .120 | 3,900 | 50-65 |
| 8 | 17/64 | 1/4-28UNJF-3B | .412 .408 | .442 | .272 .268 | .552 .532 | .347 | .355 | .565 | .484 | .440 .425 | .112 | .125 | 5,000 | 80-95 |
| 10 | 21/64 | 5/16-24UNJF-3B | .518 .512 | .552 | .336 .330 | .672 .652 | .437 | .445 | .685 | .624 | .565 .550 | .122 | .135 | 8,300 | 150-200 |
| 12 | 25/64 | 3/8-24UNJF-3B | .620 .614 | .665 | .398 .392 | .744 .724 | .479 | .490 | .755 | .700 | .628 .613 | .122 | .135 | 12,700 | 270-330 |
| 14 | 29/64 | 7/16-20UNJF-3B | .733 .727 | .775 | .463 .457 | .862 .842 | .567 | .575 | .875 | .840 | .763 .736 | .137 | .150 | 19,000 | 500-575 |
| 16 | 33/64 | 1/2-20UNJF-3B | .848 .842 | .895 | .528 .522 | .942 .922 | .617 | .625 | .955 | .970 | .878 .861 | .137 | .150 | 25,500 | 750-850 |

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 2. Dimensions apply after finish.

MATERIAL: Collar - 6Al-4V titanium alloy per AMS4928, AMS4930 or AMS4967.
 Washer - 300 series stainless steel.

FINISH: Collar - HL198-() = Surface coating per Hi-Shear Spec. 306, Type II and solid film lubricant per Electrofilm 4396.
 (22) HL198DL() = Surface coating per Hi-Shear Spec 306, Type II and solid film lube per AS5272. Type I and cetyl alcohol lube per Hi-Shear Spec. 305.
 HL198LJ() = Surface coating per Hi-Shear Spec. 306, Type II and solid film lube per AS5272, Type I.
 HL198V() = Pretreat Ticermet B and solid film lubricant per Lubeco 2123.
 Collar & Washer - HL198VW() = Both with solid film lube per Lubeco 2123.
 HL198W() = Collar finish same as HL198-(). Washer finish is solid film lube per Electrofilm 4396 only.

SPECIFICATION: Hi-Lok Product Specification 345.

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

EXAMPLES: HL198V8 = 1/4-28 Hi-Lok collar, finish is Lubeco 2123.
 HL198VW8 = 1/4-28 Hi-Lok collar and washer, finish is Lubeco 2123 on both collar and washer.

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| DATE | BY | TITLE | DRAWING NO. |
|---------------|--------|--|--------------|
| 2-7-66 | Brlej | HI-LOK® COLLAR TITANIUM ALLOY 1/16" GRIP VARIATION, TENSION APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LOK PINS | HL198 |
| 2-7-66 | JM | | |
| 09-23-08 | P. Luu | | |
| (22) REVISION | | | |