

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
5	5/32	8-32UNJC-3B	.365 .355	.095 .085	.255	.184	.455	.280	.420 .400	.420	.20	.378 .365	.107	2,300	30-40
6	3/16	10-32UNJF-3B	.365 .355	.095 .085	.255	.210	.455	.280	.420 .400	.420	.20	.378 .365	.107	2,750	40-50
8	1/4	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.270	.540	.340	.510 .490	.557	.26	.503 .488	.112	5,000	115-130
10	5/16	5/16-24UNJF-3B	.620 .610	.130 .120	.417	.333	.660	.430	.617 .597	.624	.34	.565 .550	.122	8,300	200-250
12	3/8	3/8-24UNJF-3B	.685 .675	.145 .135	.490	.395	.730	.470	.677 .657	.715	.38	.628 .613	.122	12,700	360-440
14	7/16	7/16-20UNJF-3B	.805 .795	.180 .170	.570	.456	.855	.562	.772 .752	.840	.45	.753 .736	.137	19,000	550-625
16	1/2	1/2-20UNJF-3B	.915 .905	.205 .195	.648	.518	.925	.612	.842 .832	.970	.51	.878 .861	.137	25,500	725-625

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
  2. For use on sloped surfaces up to 7° maximum on standard and 1/64 oversize Hi-Lok tension head pins.
  3. Dimensions apply after finish.

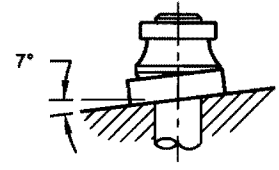
**MATERIAL:** Collar - A-286 alloy per AMS5731.  
 Washer - A-286 alloy per AMS5731.

**HEAT TREAT:** Collar - None.  
 Washer - 90,000 psi shear minimum.

**FINISH:**

Collar - HL275-( )A = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL275DR( )A = Cadmium plate per AMS-QQ-P-416, Type III, Class 3, and solid film lube per "DriLube" 701.  
 HL275DU( )A = Solid film lube per AS5272, Type I.  
 HL275LP( )A = Solid film lube per AS5272, Type II.  
 HL275PB( )A = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

Washer - HL275-( )W = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL275-( )DW = Solid film lube per AS5272, Type I.  
 HL275-( )LPW = Solid film lube per AS5272, Type II.  
 HL275-( )PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.  
 HL275-( )WU = Passivate per Hi-Shear Spec. 258.



**SPECIFICATION:** Hi-Lok Product Specification 345.

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

**EXAMPLE:** HL275-8AWU = Assembly of HL275-8A collar and HL275-8WU washer.

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DATE	BY	TITLE	DRAWING NO.
DRAWN 11-28-66	BRLEJ	<b>HI-LOK® COLLAR</b> SELF-ALIGNING COLLAR ASSEMBLY A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION, TENSION APPLICATION	<b>HL275</b>
APPROVED 11-28-66	J.MILLER		
9 REVISION 7-7-2011	J.F.Obispo		