



DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L LENGTH	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.287 .263	.173 .166	.447 .427	.265	.344	.314 .302	.107	2,300	30-40
6	13/64	10-32UNJF-3B	.307 .303	.212 .208	.457 .437	.275	.344	.314 .302	.107	2,750	40-50
8	17/64	1/4-28UNJF-3B	.412 .408	.272 .268	.552 .532	.340	.484	.440 .425	.112	5,000	115-130
10	21/64	5/16-24UNJF-3B	.518 .512	.336 .330	.672 .652	.430	.624	.565 .550	.122	8,300	200-250
12	25/64	3/8-24UNJF-3B	.620 .614	.398 .392	.744 .724	.475	.715	.628 .613	.122	12,700	360-420
14	29/64	7/16-20UNJF-3B	.733 .727	.463 .457	.862 .842	.565	.840	.753 .736	.137	19,000	525-675
16	33/64	1/2-20UNJF-3B	.848 .842	.528 .522	.942 .922	.615	.970	.878 .861	.137	25,500	725-1000

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
  - Dimensions apply after finish.
  - Non-lubed collars must be used with lubed pin.
  - Use HL478 for oversize replacement.

**MATERIAL:** Collar - A-286 high temperature alloy per AMS5731, AMS5734, or AMS5736.

- FINISH:**
- HL278(-) = Silver plate per AMS2410, except not baked, to .0002 thick on surfaces which can be touched by a .75 inch ball. Threads shall show evidence of plate but thickness requirement are waived.
  - HL278DK( ) = Katgard FA solid film lube.
  - HL278DU( ) = Solid film lube per AS5272, Type I.
  - HL278EG( ) = Evertube 620 solid film lube.
  - HL278K( ) = Solid film lube per Lubeco 905.
  - HL278GU( ) = Silver plate per AMS2410.
  - HL278PB( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HL278V( ) = Solid film lube per Lubeco 2123.

**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:** HL278PB8 = 1/4-28 HI-Lok collar with cadmium plate, Type II, Class 2, and cetyl alcohol lube.

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			TITLE	DRAWING NO.
DATE	BY		<b>HI-LOK® COLLAR</b> A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION, TENSION APPLICATION FOR USE ON 1/64" OVERSIZE HI-LOK PINS	<b>HL278</b>
DRAWN	3-31-66	BRLEJ		
APPROVED	3-31-66	M.E.C.		
REVISION	2-7-2012	J.F.Obispo		