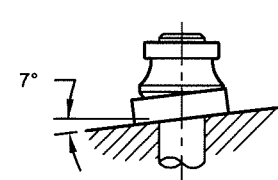


DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	L	L1 (REF)	M (REF)	P (REF)	R SPHER. RAD	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.365 .355	.095 .085	.255	.457 .427	.275	.410	.380	.20	.346 .332	.107	2,300	30-40
6	3/16	10-32UNJF-3B	.365 .355	.095 .085	.255	.457 .427	.275	.410	.380	.20	.346 .332	.107	2,750	40-50
8	1/4	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.552 .522	.340	.500	.380	.26	.346 .332	.112	5,000	110-130
10	5/16	5/16-24UNJF-3B	.620 .610	.130 .120	.417	.672 .642	.430	.607	.484	.34	.440 .425	.122	8,300	200-250
12	3/8	3/8-24UNJF-3B	.790 .780	.145 .135	.490	.745 .715	.470	.667	.557	.38	.503 .488	.122	12,700	360-440
14	7/16	7/16-20UNJF-3B	.895 .885	.180 .170	.570	.867 .837	.562	.762	.840	.45	.753 .736	.137	19,000	550-625
16	1/2	1/2-20UNJF-3B	1.005 .995	.205 .195	.648	.939 .909	.610	.832	.970	.51	.878 .861	.137	25,500	725-825
18	9/16	9/16-18UNJF-3B	1.125 1.115	.270 .260	.763	1.065 1.035	.700	.950	.970	.71	.878 .861	.145	29,000	950-1075
20	5/8	5/8-18UNJF-3B	1.305 1.290	.315 .305	.855	1.160 1.130	.765	1.025	1.120	.76	1.003 .986	.145	32,000	1350-1550

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
  - For use on sloped surfaces up to 7° maximum on standard and 1/64 oversize Hi-Lok tension head pins.
  - Non-lubed collars must be used with lubed pins.
  - Dimensions apply after finish.
  - Use HL375 for oversize replacement.
  - For -12, -14, and -16 washers, chamfer or radius .040-.060.

- MATERIAL:** Collar - 303 Se stainless steel per ASTM A582 (AMS5640).  
 Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.
- HEAT TREAT:** Collar - None.  
 Washer - Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per AMS-H-6875.
- FINISH:** Collar - HL75-( )A = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, with cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL75DU( )A = Solid film lube per AS5272, Type I.  
 HL75G( )A = Silver plate per AMS2410 (.0002-.0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL75GU( )A = Silver plate per AMS2410 (.0002-.0004 thick).  
 HL75K( )A = Solid film lube per Lubeco 905.  
 HL75N( )A = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.  
 HL75PB( )A = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL75TF( )A = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.  
 HL75V( )A = Solid film lube per "Lubeco" 2123.  
 Washer - HL75-( )DW = Solid film lube per AS5272, Type I.  
 HL75-( )GW = Silver plate per AMS2410 (.0002-.0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HL75-( )KW = Solid film lube per "Lubeco" 905.  
 HL75-( )PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.  
 HL75-( )VW = Solid film lube per "Lubeco" 2123.  
 HL75-( )W = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.  
 HL75-( )WU = Passivate per Hi-Shear Spec. 258.  
 HL75-( )TFW = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.  
 HL75-( )EW = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.



**SPECIFICATION:** Hi-Lok Product Specification 345.  
**CODE:** Dash number indicates nominal thread size in 1/32nds.  
 Code letter "A" following dash number indicates Hi-Lok collar.  
 See "Finish" note for explanation of code letters.  
**EXAMPLE:** HL75-8AW = Assembly of HL75-8A collar and HL75-8W washer.  
 HL75K8AKW = Assembly of HL75K8A collar and HL75-8KW washer.

"Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation

			TITLE	DRAWING NO.
			<b>HI-LOK<sup>®</sup> COLLAR</b>	<b>HL75</b>
			SELF-ALIGNING COLLAR ASSEMBLY	
			303 STAINLESS STEEL	
			1/16" GRIP VARIATION, TENSION APPLICATION	
DATE	BY			
DRAWN 3-16-60	RKL			
APPROVED 3-16-60	MMS			
REVISION 9-3-2008	J.F.O.			