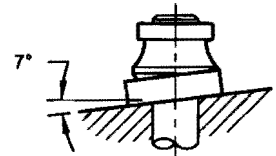


DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	D DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER. RAD	W HEX	X (MAX)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.365 .355	.095 .085	.255	.184	.445	.272	.420 .400	.344	.20	.314 .302	.115	1,400	22-32
6	3/16	10-32UNJF-3B	.365 .355	.095 .085	.255	.210	.445	.272	.420 .400	.344	.20	.314 .302	.115	1,600	32-42
6	1/4	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.270	.570	.337	.540 .520	.484	.28	.440 .425	.121	3,000	75-90
10	5/16	5/16-24UNJF-3B	.620 .610	.130 .120	.417	.333	.690	.427	.647 .627	.557	.34	.503 .488	.133	5,000	140-170
12	3/8	3/8-24UNJF-3B	.685 .675	.145 .135	.490	.395	.730	.470	.677 .657	.624	.38	.565 .550	.133	7,000	220-260
14	7/16	7/16-20UNJF-3B	.805 .795	.180 .170	.570	.456	.855	.562	.772 .752	.624	.45	.565 .550	.146	9,500	310-370
16	1/2	1/2-20UNJF-3B	.915 .905	.205 .195	.648	.518	.925	.604	.842 .822	.783	.51	.690 .675	.146	12,500	410-470
18	9/16	9/16-18UNJF-3B	1.005 .995	.205 .195	.736	.592	1.030	.680	.922 .902	.970	.71	.878 .861	.153	14,500	575-650
20	5/8	5/8-18UNJF-3B	1.305 1.290	.315 .305	.855	.645	1.125	.745	1.017 .997	1.120	.76	1.003 .986	.153	18,000	700-775
24	3/4	3/4-16UNJF-3B	1.500 1.485	.390 .380	.985	.773	1.405	.980	1.285 1.255	1.240	.81	1.128 1.110	.165	27,500	1000-1100
28	7/8	7/8-14UNJF-3B	1.740 1.720	.450 .435	1.155	.905	1.600	1.100	1.470 1.440	1.520	.92	1.380 1.356	.180	37,500	1275-1400
32	1	1-12UNJF-3B	2.000 1.980	.505 .490	1.345	1.035	1.900	1.300	1.755 1.725	1.650	1.11	1.504 1.480	.200	50,000	1550-1700

- 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 pins.
  3. Dimensions apply after finish.
  4. Use HL382 for oversize replacement.

- 36 MATERIAL:** Collar - 2024 aluminum alloy per AMS-QQ-A-430 or AMS-QQ-A-225/6.  
Washer - "W" - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.  
"C" - A-286 high temperature alloy per AMS5731 or AMS5737.
- 36 HEAT TREAT:** Collar - Age to T6 condition per AMS2770.  
Washer - "W" - Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per AMS-H-6875.  
"C" - 90,000 psi shear minimum.
- 36 FINISH:** Collar - HL82-( )A = Anodize per MIL-A-8625, color red, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HL82-( )DA = Anodize per MIL-A-8625, color natural, and solid film lube per AS5272, Type I.  
HL82CM( )A = Chemical conversion coat per MIL-C-5541, Class 1A, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HL82K( )A = Anodize per MIL-A-8625 and "Lubeco" 905 solid film lube.  
HL82LP( )A = Anodize per MIL-A-8625, color natural, and solid film lube per AS5272, Type II.  
Washer - HL82-( )CU = Passivate per Hi-Shear Spec. 258.  
HL82-( )DW = Solid film lube per AS5272, Type I.  
HL82-( )GW = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.  
HL82-( )KW = Solid film lube per "Lubeco" 905.  
HL82-( )LPW = Solid film lube per AS5272, Type II.  
HL82-( )PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.  
HL82-( )JW = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.  
HL82-( )WU = Passivate per Hi-Shear Spec. 258.



**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.

**EXAMPLES:** HL82-8AW = Assembly of HL82-8A collar and HL82-8W washer.  
HL82-8DADW = Assembly of HL82-8DA collar and HL82-8DW washer.

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DATE	BY	TITLE	DRAWING NO.
10-12-60	R.K.L.	<b>HI-LOK® COLLAR</b> SELF-ALIGNING COLLAR ASSEMBLY (ALUMINUM COLLAR - STAINLESS STEEL WASHER) 1/16" GRIP VARIATION, SHEAR APPLICATION	<b>HL82</b>
10-12-60	V.R.D.		
01-04-2012	J.F.O.		