

DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B	C DIA. (REF.)	D DIA. (REF.)	L (REF.)	L1 (REF.)	R SPHER. RAD.	M	P (REF.)	W HEX.	X (MAX.)	UTS LBS. MIN.	TORQUE OFF IN. LBS.
-5	5/32	8-32UNJC-3B	.365 .355	.125 .115	.263	.184	.475	.302	.20	.420 .400	.344	.314 .302	.145	1,400	22-32
-6	3/16	10-32UNJF-3B	.365 .355	.125 .115	.263	.210	.475	.302	.20	.420 .400	.344	.314 .302	.145	1,600	32-42
-8	1/4	1/4-28UNJF-3B	.475 .465	.150 .140	.342	.270	.600	.367	.26	.540 .520	.484	.440 .425	.151	3,000	75-90
-10	5/16	5/16-24UNJF-3B	.583 .573	.160 .150	.423	.333	.720	.457	.34	.647 .627	.557	.503 .488	.163	5,000	140-170
-12	3/8	3/8-24UNJF-3B	.655 .645	.175 .165	.497	.395	.760	.500	.38	.677 .657	.624	.565 .550	.163	7,000	220-260
-14	7/16	7/16-20UNJF-3B	.805 .795	.210 .200	.576	.456	.885	.592	.45	.772 .752	.624	.565 .550	.176	9,500	310-370
-16	1/2	1/2-20UNJF-3B	.915 .905	.235 .225	.655	.518	.955	.634	.51	.842 .822	.763	.690 .675	.176	12,500	410-470

- 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, 3/32 grip variation, Hi-Lok pins.  
3. Dimensions apply after finish.  
4. Use HL783 for oversize replacement.

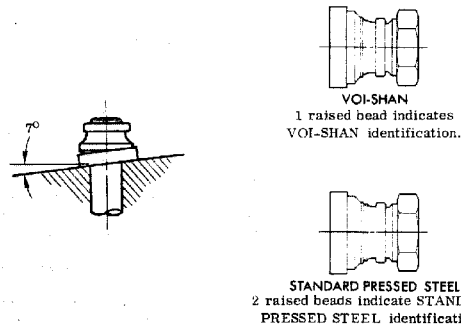
MATERIAL: Collar — 2024 aluminum alloy per QQ-A-430 or QQ-A-225/6.  
Washer — 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5525, or PH15-7Mo per AMS5520.

HEAT TREAT: Collar — Age to T6 condition per MIL-H-6088.  
Washer — Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and 15-7Mo per MIL-H-8875.

FINISH: Collar — HL83-( )A = Anodize per MIL-A-8625, color natural, and solid film lube per MIL-L-8937.  
HL83LP-( )A = Anodize per MIL-A-8625, color natural, and solid film lube per MIL-L-46010.  
Washer — HL83-( )W = Cadmium plate per QQ-P-416, Type I, Class 2.  
HL83-( )PBW = Cadmium plate per QQ-P-415, Type II, Class 2.  
HL83-( )LPW = Solid film lube per MIL-L-46010.  
HL83-( )DW = Solid film lube per MIL-L-8937.

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: HL83-8AW = Assembly of HL83-8A collar and HL83-8W washer.  
HL83LP-8ALPW = Assembly of HL83LP-8A collar and HL83LPW washer.



U.S. patents 2,882,773; 2,927,491; 2,940,495; 3,027,789; 3,138,987; design patent 191,883; other U.S. and Foreign patents granted and pending; property of Hi-Shear Corporation. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

DRAWN	DATE	BY
	7-18-60	R. K. L.
APPROVED	7-18-60	M. E. C.
REVISION	9-25-73	Jan

TITLE

## hi-Lok® COLLAR

SELF-ALIGNING COLLAR ASSEMBLY  
(ALUMINUM COLLAR — STAINLESS STEEL WASHER)  
3/32" GRIP VARIATION — SHEAR APPLICATION

DRAWING NUMBER
<b>HL83</b>