THIS AREA PROVIDED WITH A PREVAILING TORQUE LOCKING FEATURE

DASH NO. | PIN NOM DIA. | THREAD | A DIA | B | C DIA (REF) | D DIA (REF) | L | L1 (REF) | M | P (REF) | W | X (REF) | UTS LBS. MIN | TORQUE-OFF INCH-POUNDS
--- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | ---
6 | 7/32 | 10-32UNJF-3B | .400 | .120 | .295 | .226 | .500 | .480 | .320 | .423 | .380 | .346 | .332 | .149 | 1,800 | 32-42
8 | 9/32 | 1/4-28UNJF-3B | .505 | .170 | .370 | .289 | .605 | .585 | .395 | .515 | .484 | .449 | .425 | .183 | 3,000 | 75-90
14 | 15/32 | 7/16-20UNJF-3B | .975 | .325 | .605 | .479 | .835 | .815 | .540 | .797 | .624 | .565 | .550 | .207 | 9,500 | 310-370
16 | 17/32 | 1/2-20UNJF-3B | 1.045 | .385 | .685 | .542 | 1.016 | .995 | .685 | .868 | .763 | .690 | .675 | .207 | 12,500 | 410-470
18 | 19/32 | 9/16-18UNJF-3B | 1.185 | .455 | .760 | .610 | 1.120 | 1.100 | .760 | .968 | .970 | .878 | .861 | .227 | 14,500 | 575-650

NOTES:
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. For use on sloped surfaces up to 7° maximum.
3. Dimensions apply after finish.

MATERIAL:
Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

HEAT TREAT:
Collar - Age to T6 condition per AMS2770.
Washer - Age to H-1026 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per AMS-H-6875.

FINISH:
Collar - HL271-{A} = Anodize per MIL-A-8625, color orange, and cetyl alcohol lube per HI-Shear Spec. 305.
HLT271DU{A} = Solid film lube per AS5272, Type I.
HLT271LP{A} = Anodize per MIL-A-8625, color natural, and solid film lube per AS5272, Type II.

Washer - HL271-{W} = Cadmium plate per AMS-QQ-F-416, Type I, Class 2.
HLT271-{WU} = Solid film lube per AS5272, Type II.
HLT271-{IW} = Passivate per HI-Shear Spec. 256 and solid film lube per AS5272, Type I.
HLT271-{LP} = Solid film lube per AS5272, Type II.
HLT271-{JPW} = Passivate per HI-Shear Spec. 256.

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

CODE:
Dash number indicates nominal thread size in 1/32nds.
Code letter "A" following dash number indicates Hi-Lok Hi-Tigue collar.
See "Finish" note for explanation of code letters.

EXAMPLE:
HLT271-8ALPW = Assembly of HLT271-8A collar and HLT271-8LPW washer.
HLT271LP8ALPW = Assembly of HLT271LP8A collar and HLT271-8LPW washer.

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