

DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	D DIA (REF)	L	L1 (REF)	M (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.365 .355	.105 .095	.235	.184	.462 .442	.282	.410	.344	.314 .302	.118	1,400	22-32
6	3/16	10-32UNJF-3B	.365 .355	.105 .095	.261	.210	.462 .442	.282	.410	.344	.314 .302	.118	1,600	32-42
8	1/4	1/4-28UNJF-3B	.475 .465	.135 .125	.339	.270	.592 .572	.352	.530	.484	.440 .425	.127	3,000	75-90
10	5/16	5/16-24UNJF-3B	.620 .600	.145 .135	.423	.333	.712 .692	.442	.637	.557	.503 .488	.139	5,000	140-170
12	3/8	3/8-24UNJF-3B	.685 .675	.160 .150	.496	.395	.755 .735	.485	.667	.624	.565 .550	.139	7,000	210-260
14	7/16	7/16-20UNJF-3B	.805 .795	.210 .200	.575	.456	.892 .872	.592	.762	.624	.565 .550	.157	9,500	310-370
16	1/2	1/2-20UNJF-3B	.915 .905	.235 .225	.654	.518	.964 .944	.634	.832	.763	.690 .675	.157	12,500	410-470
18	9/16	9/16-18UNJF-3B	1.125 1.115	.270 .260	.763	.592	1.060 1.040	.700	.947	.970	.878 .861	.171	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.
 4. Use HLT271 for oversize replacement.

MATERIAL:

Collar - 2024 aluminum alloy per QQ-A-430 or 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.

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.

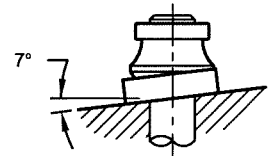
FINISH:

Collar - HLT71-()JA = Anodize per MIL-A-8625, dye color "copper" -5 size only, other sizes blue, and cetyl alcohol lube per Hi-Shear Spec. 305. (14)
HLT71DU()JA = Solid film lube per AS5272, Type I.
HLT71LP()JA = Anodize per MIL-A-8625, color natural, and solid film lube per AS5272, Type II.
Washer - HLT71-()JW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
HLT71-()DUW = Solid film lube per AS5272, Type I.
HLT71-()DW = Passivate per Hi-Shear 258 and solid film lube per AS5272, Type I.
HLT71-()LPW = Solid film lube per AS5272, Type II.
HLT71-()PW = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.
HLT71-()JC = Passivate per Hi-Shear 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLT71-()LPC = Solid film lube per AS5272, Type II.

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: HLT71-8ALPW = Assembly of HLT71-8A collar and HLT71-8LPW washer.
HLT71LP8ALPC = Assembly of HLT71LP8A collar and HLT71-8LPC washer.



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			TITLE	DRAWING NO.
			HI-LOK® HI-TIGUE™ COLLAR	HLT71
			SELF-ALIGNING COLLAR ASSEMBLY (ALUMINUM COLLAR AND STAINLESS STEEL WASHER) 1/16" GRIP VARIATION, SHEAR APPLICATION	
DATE	BY			
DRAWN	4-5-69	Van		
APPROVED	4-28-69	V. Miller		
REVISION	1-23-2009	J.F. Obispo		