

DASH NO.	PIN NOM DIA	④⑨ 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	.1640-32 UNJC-3B .355	.365 .355	.095 .085	.255	.457 .427	.275	.410	.380	.20	.346 .332	.107	2,300	30-40
6	3/16	.1900-32 UNJF-3B .355	.365 .355	.095 .085	.255	.457 .427	.275	.410	.380	.20	.346 .332	.107	2,750	40-50
8	1/4	.2500-28 UNJF-3B .465	.475 .465	.120 .110	.333	.552 .522	.340	.500	.380	.26	.346 .332	.112	5,000	110-130
10	5/16	.3125-24 UNJF-3B .610	.620 .610	.130 .120	.417	.672 .642	.430	.607	.484	.34	.440 .425	.122	8,300	200-250
12	3/8	.3750-24 UNJF-3B .780	.790 .780	.145 .135	.490	.745 .715	.470	.667	.557	.38	.503 .488	.122	12,700	360-440
14	7/16	.4375-20 UNJF-3B .885	.895 .885	.180 .170	.570	.867 .837	.562	.762	.840	.45	.753 .736	.137	19,000	550-625
16	1/2	.5000-20 UNJF-3B .995	1.005 .995	.205 .195	.648	.939 .909	.610	.832	.970	.51	.878 .861	.137	25,500	725-825
18	9/16	.5625-18 UNJF-3B 1.115	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	.6250-18 UNJF-3B 1.290	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.
- After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL:

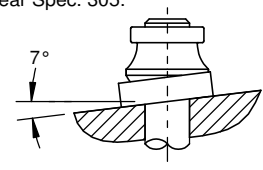
Collar - 303 Se stainless steel per ASTM A582 (AMS5640).
 Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

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.

④⑨ 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 1, 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-()JW = 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.
 ⑦ HL75-()EW = HI-KOTE™ 1 aluminum pigmented 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.

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			TITLE	DRAWING NO.
DATE	BY		HI-LOK™ COLLAR SELF-ALIGNING COLLAR ASSEMBLY 303 STAINLESS STEEL 1/16 GRIP VARIATION, TENSION APPLICATION	HL75
DRAWN	3-16-60	RKL		
APPROVED	3-16-60	MMS		
④⑥ REVISION	11-10-15	F.C.		