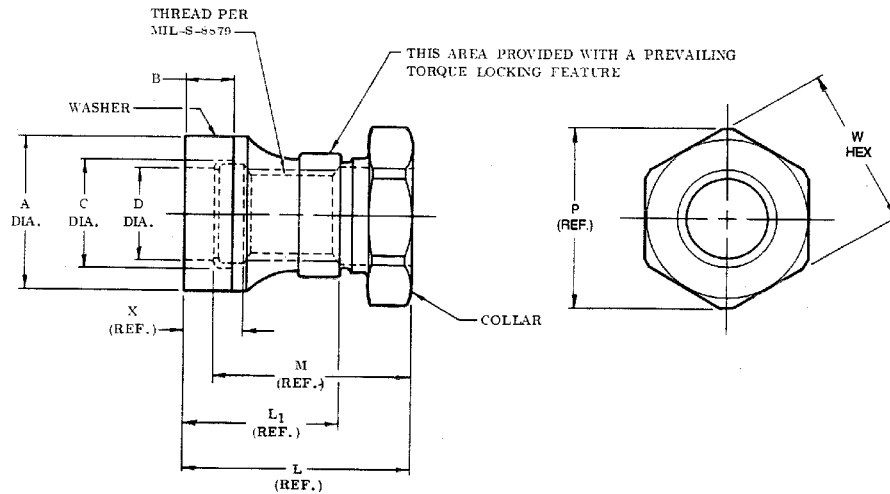




DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B	C DIA. (REF.)	D DIA.	L LENGTH (REF.)	L1 (REF.)	M (REF.)	P (REF.)	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE OFF IN. LBS.
-5	5/32"	8-32UNJC-3B	.300 .290	.140 .130	.200	.172 .167	.520	.350	.425	.344	.314 .302	.172	2,300	25-35
-6	3/16"	10-32UNJF-3B	.320 .310	.140 .130	.228	.198 .193	.530	.360	.435	.380	.346 .332	.172	2,750	30-40
-8	1/4"	1/4-28UNJF-3B	.420 .410	.160 .150	.294	.258 .253	.635	.435	.530	.484	.440 .425	.182	5,000	60-80
-10	5/16"	5/16-24UNJF-3B	.540 .530	.180 .170	.370	.322 .316	.735	.500	.620	.484	.440 .425	.192	8,300	130-160
-12	3/8"	3/8-24UNJF-3B	.650 .640	.200 .190	.430	.385 .380	.825	.560	.700	.557	.503 .488	.205	12,700	200-340

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions apply after finish.
 3. For use on Hi-Lok pin with mechanical lock application, such as HL227, HL233, or HL252.
 4. Use HL684 for oversize replacement.

MATERIAL: Collar - 303 Se stainless steel per QQ-S-764 and 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 15-7Mo per MIL-H-6875.

① FINISH: Collar - Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
 Washer - Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.

SPECIFICATION: Hi-Lok Product Specification 345.

CODE: Dash number indicates nominal thread size in 1/32nds.
 See the "Finish" note for explanation of code letters.

EXAMPLE: HL584-8AW = Assembly of HL584-8A Collar and HL584-8W Washer.

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DATE	BY	TITLE	DRAWING NUMBER
DRAWN 10-4-76	D. P. S.	hi-lok COLLAR	HL584
APPROVED 10-4-76 R. L. S.		MECHANICAL LOCK COLLAR ASSEMBLY STAINLESS STEEL 1/16" GRIP VARIATION - SOLID FILM LUBED	
⑥ REVISION 1-28-88	D. P. S.		