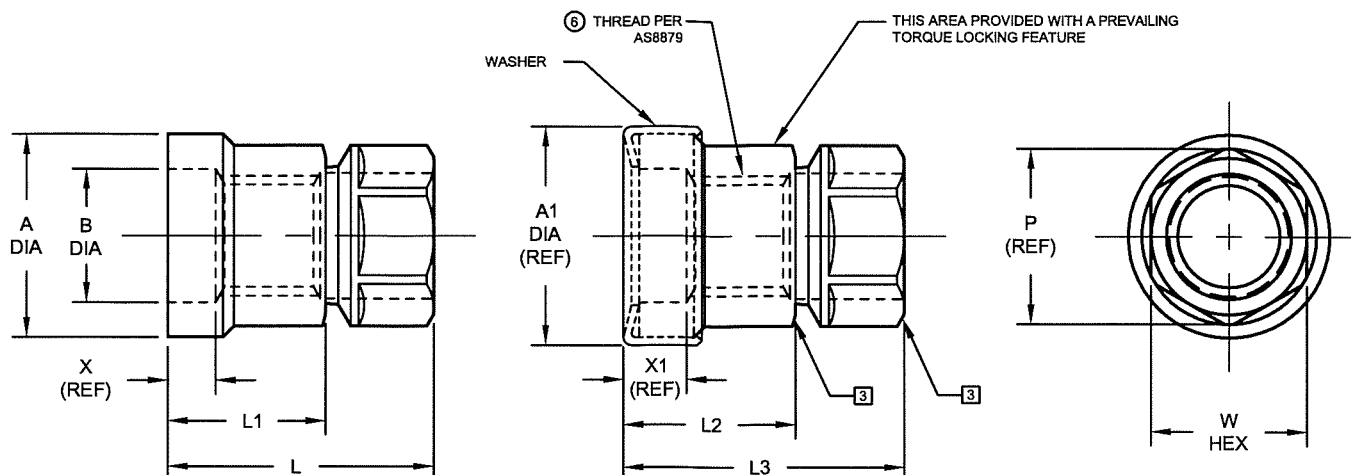




DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.287 .283	.320	.173 .169	.435 .415	.235	.250	.450	.250	.220 .213	.107	.120	2,300	30-40
6	13/64	10-32UNJF-3B	.307 .303	.340	.212 .208	.450 .430	.250	.265	.465	.280	.251 .244	.107	.120	2,750	40-50
8	17/64	1/4-28UNJF-3B	.412 .408	.440	.276 .272	.550 .530	.300	.315	.565	.350	.314 .302	.112	.125	5,000	105-130
10	21/64	5/16-24UNJF-3B	.518 .512	.550	.340 .334	.670 .650	.370	.385	.685	.420	.377 .365	.122	.135	8,300	200-250
12	25/64	3/8-24UNJF-3B	.628 .622	.660	.403 .397	.740 .720	.410	.425	.755	.490	.439 .425	.122	.135	12,700	360-420
14	29/64	7/16-20UNJF-3B	.735 .725	.775	.466 .460	.930 .910	.560	.575	.935	.573	.505 .490	.137	.150	19,000	525-675
16	33/64	1/2-20UNJF-3B	.850 .840	.895	.528 .522	1.020 1.000	.610	.625	1.025	.643	.565 .550	.137	.150	25,500	725-1000

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 2. Dimensions apply after finish.
 3. Burrs from cutoff process and cutting torque-off groove allowed.
 4. HL1087ATW is available in sizes -5, -6, -8, -10, and -12 only.
Due to .020" aluminum washer thickness, caution should be taken when HL1087ATW is used in max stack-up condition. ⑥

MATERIAL:

Collar - S30430 (302HQ) stainless steel per ASTM A493, Type XM-7, or 302 or 305 stainless steel per AMS-QQ-S-763 and AMS5686, or 303Se series stainless steel per ASTM A582 (AMS5640).

Washer - 300 series stainless steel (.010 thick).
2024-T6 aluminum alloy (.020 thick) per AMS-QQ-A-250/4 or AMS-QQ-A-250/5 (sizes -5 through -12 only).

FINISH:

HL1087A-() = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.

HL1087APBW() = Collar with cadmium plate per AMS-QQ-P-416, Type II, Class 2, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305. Steel washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and no lube.

④ HL1087ATW() = Collar with cadmium plate per AMS-QQ-P-416, Type II, Class 2, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305. Aluminum washer anodize per MIL-A-8625, dye color blue (sizes -5 through -12 only).

SPECIFICATION: Hi-Lok Product Specification 345.

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

EXAMPLE: HL1087A-8 = 1/4-28 Hi-Lok collar with blue cadmium plate.

"Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation

	DATE	BY	TITLE	DRAWING NO.
DRAWN	8-11-83	D.P.S.	HI-LOK® COLLAR STAINLESS STEEL 1/16" GRIP VARIATION, SPECIAL TENSION APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LOK PINS	HL1087A
APPROVED	8-16-83	JGWilcox		
⑥ REVISION	11-12-12	J.F.Obispo		