

DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B DIA.	L	L ₁ (REF.)	P (REF.)	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE OFF IN. LBS.
-5	5/32	8-32UNJC-3B	.292 .288	.179 .175	.447 .427	.267	.344	.314 .302	.118	1,400	15-25
-6	3/16	10-32UNJF-3B	.307 .303	.205 .201	.457 .437	.277	.344	.314 .302	.118	1,600	25-35
-8	1/4	1/4-28UNJF-3B	.412 .408	.265 .261	.550 .530	.350	.380	.346 .332	.127	3,000	60-80
-10	5/16	5/16-24UNJF-3B	.518 .512	.330 .324	.670 .650	.425	.484	.440 .425	.139	5,000	130-160
-12	3/8	3/8-24UNJF-3B	.628 .622	.393 .387	.745 .725	.475	.557	.503 .488	.139	7,000	200-240
-14	7/16	7/16-20UNJF-3B	.713 .707	.456 .450	.860 .840	.560	.624	.565 .550	.157	9,500	270-330
-16	1/2	1/2-20UNJF-3B	.815 .809	.519 .513	.940 .920	.610	.763	.690 .675	.157	12,500	370-430
-18	9/16	9/16-18UNJF-3B	.978 ① .861	.582 .576	1.030 1.010	.670	.970	.878 .861	.171	14,500	500-575
-20	5/8	5/8-18UNJF-3B	1.003 ② .986	.650 .644	1.125 1.105	.735	1.120	1.003 .986	.171	18,000	625-700

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. Dimensions apply after finish.
3. Use HLT277 for oversize replacement.

MATERIAL: 2024 aluminum alloy per QQ-A-430 or QQ-A-225/6.

HEAT TREAT: Age to T6 condition per MIL-H-6088.

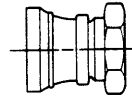
FINISH: HLT77-() = Anodize per MIL-A-8625, dye color -5 size "copper", other sizes blue, and cetyl alcohol lube per Hi-Shear Spec. 305.

HLT77LP-() = Anodize per MIL-A-8625, color natural, and solid film lube per MIL-L-46010.

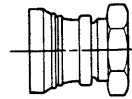
SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 345.

CODE: Dash number indicates nominal thread size in 1/32nds. See "Finish" note for explanation of finish code letters. "AL" following dash number indicates "Auto Load" collars, pre-packaged for automatic loading in "Collar-Matic" tools, for -5 and -6 sizes only. See HLT477 for -8AL size. "AL" code letters to be used on Purchase Orders or related documents only.

EXAMPLE: HLT77-8 = 1/4-28 Hi-Tigue Collar with cetyl alcohol lube.
HLT77-6AL = 10-32 Hi-Tigue Collar, cetyl alcohol lube, pre-packaged for automatic loading in Collar-Matic tools.



VOI-SHAN
1 raised bead indicates
VOI-SHAN identification.



STANDARD PRESSED STEEL
2 raised beads indicate STANDARD
PRESSED STEEL identification.

U.S. patents 2,882,773; 2,947,491; 2,940,495; 3,027,789; 3,138,987; 3,578,167; design patent 191,883; other U.S. and Foreign patents granted and pending; property of Hi-Shear Corporation. "Hi-Lok" and "Hi-Tigue" are Registered Trademarks of Hi-Shear Corporation.

DATE		BY	TITLE	DRAWING NUMBER
DRAWN	4-22-70	Van		
APPROVED	4-22-70	JG Walscott	hi-lok® hi-tigue® COLLAR 2024-T6 ALUMINUM ALLOY 1/16" GRIP VARIATION — SHEAR APPLICATION	HLT77
REVISION	5-15-72	Van		