

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
6	7/32	10-32UNJF-3B	.400 .390	.120 .110	.295	.226	.500 .480	.320	.423	.380	.346 .332	.149	1,600	32-42
8	9/32	1/4-28UNJF-3B	.505 .495	.170 .160	.370	.289	.605 .585	.395	.515	.484	.440 .425	.183	3,000	75-90
10	11/32	5/16-24UNJF-3B	.645 .635	.170 .160	.453	.352	.735 .715	.495	.638	.557	.503 .488	.181	5,000	140-170
12	13/32	3/8-24UNJF-3B	.825 .815	.185 .175	.526	.416	.810 .790	.540	.703	.624	.565 .550	.181	7,000	210-260
14	15/32	7/16-20UNJF-3B	.935 .925	.225 .215	.605	.479	.935 .915	.835	.797	.624	.565 .550	.207	9,500	310-370
16	17/32	1/2-20UNJF-3B	1.045 1.035	.255 .245	.885	.542	1.015 .995	.685	.868	.763	.690 .675	.207	12,500	410-470
18	19/32	9/16-18UNJF-3B	1.185 1.175	.270 .260	.808	.610	1.120 1.100	.760	.968	.970	.878 .861	.227	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.

MATERIAL: Collar - 2024 aluminum alloy per QQ-A-430 or QQ-A-225/6.
 Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

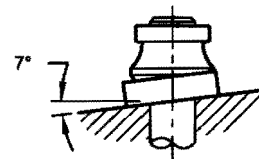
HEAT TREAT: Collar - Age to T6 condition per AMS2770.
 Washer - Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per AMS-H-6875.

FINISH: Collar - HLT271-()A = Anodize per MIL-A-8625, color orange, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLT271DU()A = Solid film lube per AS5272, Type I.
 HLT271LP()A = Anodize per MIL-A-8625, color natural, and solid film lube per AS5272, Type II.
 Washer - HLT271-()JW = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.
 HLT271-()DUW = Solid film lube per AS5272, Type I.
 HLT271-()DW = Passivate per Hi-Shear Spec. 258 and solid film lube per AS5272, Type I.
 HLT271-()LPW = Solid film lube per AS5272, Type II.
 HLT271-()PW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 (2) HLT271-()UW = Passivate per Hi-Shear Spec. 258.

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: HLT271-8ALPW = Assembly of HLT271-8A collar and HLT271-8LPW washer.
 HLT271LP8ALPW = Assembly of HLT271LP8A collar and HLT271-8LPW washer.



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	DATE	BY
DRAWN	10-3-69	Van
APPROVED	10-3-69	JGWilcox R.Ting
(12) REVISION	8-2-2011	J.F.Obispo

TITLE
HI-LOK® HI-TIGUE™ COLLAR
 SELF-ALIGNING COLLAR ASSEMBLY
 (ALUMINUM COLLAR AND STAINLESS STEEL WASHER)
 1/16" GRIP VARIATION, SHEAR APPLICATION
 FOR USE ON 1/64" AND 1/32" OVERSIZE HI-TIGUE PINS

DRAWING NO.

HLT271