

DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B DIA.	L	L1 (REF.)	P (REF.)	W HEX.	X (REF.)	LOCKING TORQUE MAX.	UTS LBS. MIN.	TORQUE OFF IN. LBS.
-5	11/64	8-32UNJC-3B	.320 .315	.194 .190	.525 .505	.345	.344	.314 .302	.185	10	1,400	15-25
-6	7/32	10-32UNJF-3B	.370 .365	.235 .231	.555 .535	.375	.344	.314 .302	.205	15	1,600	25-35
-8	9/32	1/4-28UNJF-3B	.460 .455	.295 .291	.665 .645	.455	.380	.346 .332	.225	20	3,000	60-80
-10	11/32	5/16-24UNJF-3B	.590 .580	.360 .354	.800 .780	.560	.484	.440 .425	.250	35	5,000	130-160
-12	13/32	3/8-24UNJF-3B	.700 .690	.424 .418	.875 .855	.605	.557	.503 .488	.255	40	7,000	200-240
-14	15/32	7/16-20UNJF-3B	.800 .790	.486 .480	1.015 .995	.715	.624	.565 .550	.285	60	9,500	270-330
-16	17/32	1/2-20UNJF-3B	.905 .895	.550 .544	1.100 1.080	.770	.763	.690 .675	.295	85	12,500	370-430
-20	21/32	5/8-18UNJF-3B	1.130 1.120	.690 .680	1.305 1.285	.910	1.380	1.255 1.235	.325	130	18,000	625-700
-24	25/32	3/4-16UNJF-3B	1.255 1.240	.820 .810	1.565 1.545	1.135	1.520	1.380 1.360	.355	200	27,500	900-1000

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

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

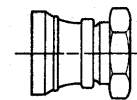
HEAT TREAT: Age to T6 condition per MIL-H-6088.

FINISH: HLT370-( ) = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.

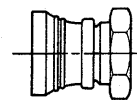
① SPECIFICATION: Hi-Lok Hi-Tigue Product Specification 345.

CODE: Dash number indicates nominal thread size in 1/32nds.

EXAMPLE: HLT370-8 = 1/4-28 Hi-Tigue Collar with cetyl alcohol lube.



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



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

① U.S. patents 2,882,773; 2,947,491; 2,940,495; 3,027,789; 3,138,987; 3,578,367; 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.

DRAWN	DATE	BY
	11-10-69	Van
APPROVED	11-11-69	J. W. [Signature]
	11-11-69	R. TING
⑤ REVISION	2-1-72	Van

**hi-Lok® hi-tigue® COLLAR**

2024-T6 ALUMINUM ALLOY  
1/16" GRIP VARIATION — SHEAR APPLICATION  
FOR USE ON 1/64" AND 1/32" OVERSIZE HI-TIGUE PINS  
(INCREASED DEPTH OF COUNTERBORE)

DRAWING NUMBER

**HLT370**