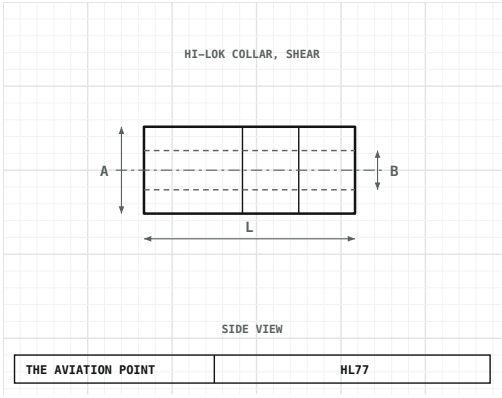
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HL77 collar — shear, aluminum alloy

Hi-Lok Collar, Shear, Aluminum Alloy, for Standard-Size Pins: dimensions by size, strength and torque-off.



HL77



Engineering drawing · dimensions in inches

Specification

Item	Value
Type	Hi-Lok collar, shear
Material	2024-T6 aluminum alloy
Strength	Shear application
Status	Check the current issue before design use.

Dimensions by size

Dimension, in	8-32UNJC-3B	10-32UNJF-3B	1/4-28UNJF-3B	5/16-24UNJF-3B
Pin nominal diameter	5/32	3/16	1/4	5/16
A — Collar diameter (max / min)	.292 - .288	.307 - .303	.412 - .408	.518 - .512
B — Bore diameter (max / min)	.173 - .166	.200 - .192	.261 - .252	.325 - .314
L — Length	.447 - .427	.457 - .437	.552 - .532	.672 - .652
Thread	8-32UNJC-3B	10-32UNJF-3B	1/4-28UNJF-3B	5/16-24UNJF-3B
Collar UTS, lb min	1,400	1,600	3,000	5,000
Torque-off, in-lb	10-20	20-30	55-70	100-125
Tension preload, lb min	350	500	1,000	1,650

Dimensions as tabulated in the catalogue, by dash number (pin nominal diameter). Max - min where a tolerance is shown.

Part numbers

Part no.	Size	Torque-off, in-lb
HL77-5	5/32	10-20
HL77-6	3/16	20-30
HL77-8	1/4	55-70
HL77-10	5/16	100-125

Every collar dash number listed, by pin diameter.

How to read the part number

Part	Meaning
Format	HL77-<dash>
Example	HL77-5 — 5/32 nominal pin diameter

Notes

- Tension preload minimums by size are tabulated for this collar: 350, 500, 1,000 and 1,650 lb.
- Max - min values shown as max - min. Approved data governs.
- Pins this collar is listed for in the catalogue: standard-size aluminum alloy pins (HL22, HL23).

SOURCES · HL77 — Hi-Lok Collar, Shear, Aluminum Alloy, for Standard-Size Pins

SCAN · OPEN THIS DATA SHEET
theaviationpoint.com/parts/hi-lok/hl77/

Reference data. The aircraft manufacturer's documentation (SRM / IPC) takes precedence.

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