



FIRST 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-LB
5	5/32	.1640-32 UNJC-3B	.287 .283	.320	.173 .169	.425 .405	.220	.235	.440	.250	.220 .213	.085	.100	1,940	20-30
6	3/16	.1900-32 UNJF-3B	.307 .303	.340	.212 .208	.435 .415	.230	.245	.450	.280	.251 .244	.085	.100	2,500	25-35
8	1/4	.2500-28 UNJF-3B	.412 .408	.440	.276 .272	.525 .505	.270	.285	.540	.350	.314 .302	.090	.105	4,300	50-70
10	5/16	.3125-24 UNJF-3B	.518 .512	.550	.340 .334	.625 .605	.315	.330	.640	.420	.377 .365	.095	.110	6,300	80-110
12	3/8	.3750-24 UNJF-3B	.628 .622	.660	.403 .397	.695 .675	.355	.370	.710	.490	.439 .425	.095	.110	8,700	140-180
14	7/16	.4375-20 UNJF-3B	.733 .727	.775	.468 .462	.775 .755	.405	.420	.790	.560	.502 .490	.100	.115	12,100	190-250

- GENERAL NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 2. Dimensions are in inches and apply after finish and before application of lubricants.
 - [3] Burrs from cutoff process and cutting torque-off groove allowed.
 - [4] Use TB64AP()L for thread lock inspection.

MATERIAL: Collar 3Al-2.5V titanium alloy per AMS6940
 6Al-4V titanium alloy per AMS4928, AMS4930 or AMS4967

(11) Washer WT - Commercially pure titanium per AMS4901 or ASTM B265 grades 1 through 4.

FINISH: Collar HST1071TA() = Anodize per Hi-Shear Ti-Shield III and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color orange identification on body of collar plus cetyl alcohol lube per Hi-Shear Spec. 305.

Collar & Washer HST1071TAWT() = Collar finish same as HST1071TA(). Washer finish per Hi-Shear Spec. 306, Type I, color brown, and cetyl alcohol lube per Hi-Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 381. Test bolt requirement exceptions per note [4] above.

CODE: Dash number indicates nominal diameter in 1/32nds.
 See Finish note for explanation of code letters.

EXAMPLE: HST1071TA8 = .2500-28 HI-LITE™ collar with HI-KOTE™ 2 solid film lube and cetyl alcohol lube.
 HST1071TAWT8 = .2500-28 HI-LITE™ collar with HI-KOTE™ 2 solid film lube and cetyl alcohol lube with washer.

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			TITLE	DRAWING NO.
	DATE	BY	HI-LITE™ COLLAR TITANIUM ALLOY 1/16 GRIP VARIATION, SHEAR APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS	HST1071 1 OF 1
DRAWN	1985-09-30	D.P.S.		
APPROVED	1985-09-30	J.Rausch		
(11) REVISION	2021-05-25	B. CHAN		