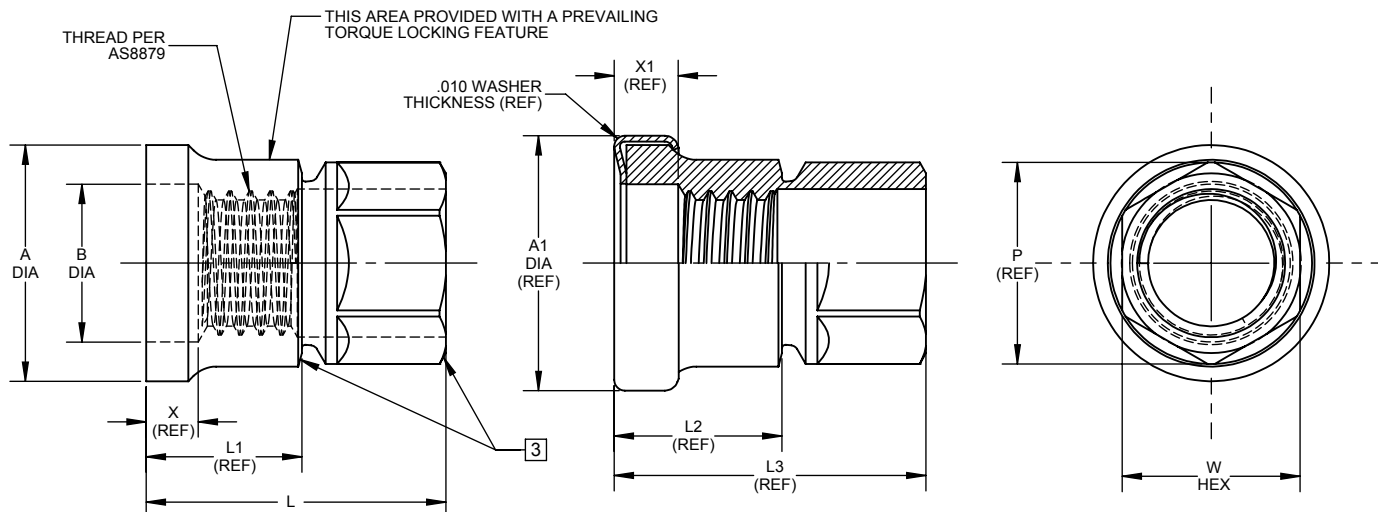




FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-LBS
5	5/32	.1640-32 UNJC-3B	.287 .283	.320	.173 .169	.425 .405	.220	.235	.440	.250	.220 .213	.085	.100	2,300	35 25
6	3/16	.1900-32 UNJF-3B	.307 .303	.340	.212 .208	.435 .415	.230	.245	.450	.280	.251 .244	.085	.100	2,750	45 35
8	1/4	.2500-28 UNJF-3B	.412 .408	.440	.276 .272	.525 .505	.270	.285	.540	.350	.314 .302	.090	.105	5,000	95 80
10	5/16	.3125-24 UNJF-3B	.518 .512	.550	.340 .334	.625 .605	.315	.330	.640	.420	.377 .365	.095	.110	8,300	200 150
12	3/8	.3750-24 UNJF-3B	.628 .622	.660	.403 .397	.695 .675	.355	.370	.710	.490	.439 .425	.095	.110	12,700	330 270

- 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 TB64TA()L or TB64TB()L for thread lock inspection.

MATERIAL: Collar 6Al-4V titanium alloy alloy per AMS4928, AMS4930 or AMS4967, or
④ 3Al-2.5V titanium alloy per AMS6940.
Washer Commercial pure titanium per AMS-T-9046, CP-4 composition.

FINISH: Collar HST1072TA-() = Pretreat per Hi-Shear Ti-Shield III, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, plus cetyl alcohol lube per Hi-Shear Spec. 305.

Collar & Washer HST1072TAWT-() = Collar finish same as HST1072TA.
Washer finish per Hi-Shear Spec. 306, Type I, color brown, and cetyl alcohol lube per Hi-Shear 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: HST1072TA-8 = 1/4-28 HI-LITE™ collar.
HST1072TAWT-8 = 1/4-28 HI-LITE™ collar with washer.

"HI-LITE" AND "HST" ARE INTERNATIONAL
REGISTERED TRADEMARKS OF HI-SHEAR CORPORATION

DATE	BY	TITLE	DRAWING NO.
DRAWN 1987-04-07	D.P.S.	HI-LITE™ COLLAR	HST1072
APPROVED 1987-04-07	N.POTO	6AL-4V OR 3AL-2.5V TITANIUM ALLOY 1/16 GRIP VARIATION, TENSION APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS	1 OF 1
④ REVISION 2018-02-19	S.WILEY		