



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 IN-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	25-35
6	3/16	.1900-32 UNJF-3B	.307 .303	.340	.212 .208	.435 .415	.230	.245	.450	.280	.251 .244	.085	.100	2,750	30-40
8	1/4	.2500-28 UNJF-3B	.412 .408	.440	.276 .272	.525 .505	.270	.285	.540	.350	.314 .302	.090	.105	5,000	80-95
10	5/16	.3125-24 UNJF-3B	.518 .512	.550	.340 .334	.625 .605	.315	.330	.640	.420	.377 .365	.095	.110	8,300	150-200
12	3/8	.3750-24 UNJF-3B	.628 .622	.660	.403 .397	.695 .675	.355	.370	.710	.490	.439 .425	.095	.110	12,700	260-360
14	7/16	.4375-20 UNJF-3B	.733 .727	.775	.468 .462	.775 .755	.405	.420	.790	.560	.502 .490	.100	.115	19,000	390-460
16	1/2	.5000-20 UNJF-3B	.848 .842	.895	.533 .527	.845 .825	.435	.450	.860	.632	.565 .550	.100	.115	25,500	640-800
18	9/16	.5625-18 UNJF-3B	.915 .905	.947	.598 .592	.950 .930	.520	.535	.965	.775	.690 .675	.105	.120	29,000	1,000-1,150
20	5/8	.6250-18 UNJF-3B	.995 .985	1.040	.661 .655	1.035 1.015	.575	.590	1.050	.850	.753 .736	.105	.120	32,000	1,350-1,550

- GENERAL NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
  - Dimensions are in inches and apply after finish and before application of lubricants.
  - Burrs from cutoff process and cutting torque-off groove allowed.
  - Use TB64AP(L) for HST1087TF( ), HST1087TP( ), and HST1087TPWU( ).  
Use TB8740PB(L) for HST1087-( ), HST1087W( ), HST1087DU( ), HST1087DUWU( ), HST1087TB( ), HST1087TBWU( ), HST1087DK( ), HST1087DK( ), HST1087MA( ), and HST1087HK( ).

**MATERIAL:** Collar S30430 stainless steel per ASTM A493, Type XM-7, or 305 stainless steel per AMS-QQ-S-763 and AMS5686, or 302 stainless steel per AMS-QQ-S-763, or 303 Se stainless steel per ASTM A582 (AMS5640).

Washer 300 series stainless steel.

**FINISH:** Collar HST1087-( ) = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 (21) HST1087DK( ) = Collar only with Kalgard FA solid film lube with special cure.  
 HST1087DU( ) = Collar only with solid film lube per AS5272, Type I, plus orange identification on body of collar per MIL-PRF-23377.  
 HST1087MA( ) = Collar only with solid film lube per Kalgard RA per AS5272, Type II.  
 HST1087TB( ) = Collar only with HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HST1087TF( ) = Collar only with HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.  
 HST1087TP( ) = Collar only with HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, color orange on body of collar, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HST1087HK( ) = Collar only with HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.  
 Collar & Washer HST1087DUWU( ) = Collar finish same as HST1087DU( ) and washer is passivated.  
 HST1087TBWU( ) = Collar finish same as HST1087TB( ) and washer is passivated.  
 HST1087TPWU( ) = Collar finish same as HST1087TP( ) and washer is passivated.  
 HST1087W( ) = Collar finish same as HST1087-( ) and washer is passivated.

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

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

**EXAMPLE:** HST1087-8 = .2500-28 HI-LITE™ collar with cadmium plate and cetyl alcohol lube.

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

DATE	BY	TITLE	DRAWING NO.
DRAWN 1983-03-21	D.P.S.	<b>HI-LITE™ COLLAR</b>	<b>HST1087</b>
APPROVED 1983-03-21	R.TING	STAINLESS STEEL	
(21) REVISION 2023-04-07	C.Artos	1/16 GRIP VARIATION, TENSION APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS	1 of 1