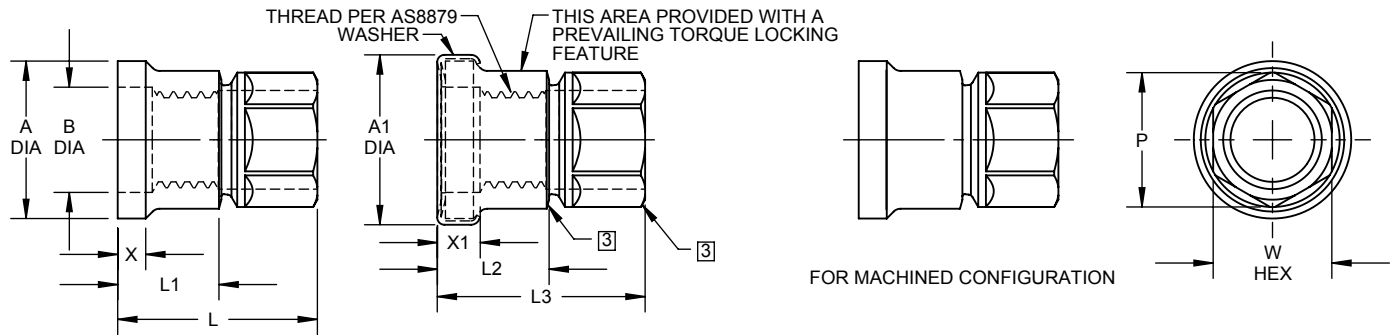




DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.287 .283	.320	.173 .169	.425 .405	.220	.235	.440	.250	.220 .213	.085	.100	2,300	15-25
6	3/16	.1900-32 UNJF-3B	.307 .303	.340	.212 .208	.435 .415	.230	.245	.450	.280	.251 .244	.085	.100	2,750	25-35
8	1/4	.2500-28 UNJF-3B	.412 .408	.440	.276 .272	.525 .505	.270	.285	.540	.350	.314 .302	.090	.105	5,000	60-80
10	5/16	.3125-24 UNJF-3B	.518 .512	.550	.340 .334	.625 .605	.315	.330	.640	.420	.377 .365	.095	.110	8,300	130-160
12	3/8	.3750-24 UNJF-3B	.628 .622	.660	.403 .397	.695 .675	.355	.370	.710	.490	.439 .425	.095	.110	12,700	200-240
14	7/16	.4375-20 UNJF-3B	.733 .727	.775	.468 .462	.775 .755	.405	.420	.790	.560	.502 .490	.100	.115	19,000	270-330
16	1/2	.5000-20 UNJF-3B	.848 .842	.895	.533 .527	.845 .825	.435	.450	.860	.632	.565 .550	.100	.115	25,500	370-430
18	9/16	.5625-18 UNJF-3B	.915 .905	.947	.603 .597	.950 .930	.520	.535	.965	.775	.690 .675	.105	.120	29,000	500-575
20	5/8	.6250-18 UNJF-3B	.995 .985	1.040	.666 .661	1.035 .1.015	.575	.590	1.050	.850	.753 .736	.105	.120	32,000	625-750
24	3/4	.7500-16 UNJF-3B	1.120 1.110	1.140	.791 .785	1.255 1.235	.755	.770	1.270	.994	.878 .861	.120	.135	42,000	900-1000
28	7/8	.8750-14 UNJF-3B	1.345 1.335	1.365	.916 .911	1.475 1.455	.895	.910	1.480	1.140	1.003 .985	.125	.140	62,000	1200-1325
32	1	1.0000-12 UNJF-3B	1.490 1.480	1.510	1.041 1.035	1.725 1.705	1.030	1.045	1.740	1.280	1.128 1.110	.130	.145	84,000	1450-1600

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

DATE	BY	TITLE	DRAWING NO.
DRAWN	1985-01-29	D.P.S.	
APPROVED	1985-01-30	R. TING	
REVISION	2019-11-04	F.CARINGELLA	

HI-LITE™ COLLAR
STAINLESS STEEL

1/16 GRIP VARIATION, SHEAR APPLICATION
FOR USE ON STANDARD AND 1/64 OVERSIZE
HI-LITE™ PINS

HST1094

1 OF 2

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 2. Dimensions are in inches and to be met after finish and before application of lubricants.
 - 3 Burrs from cutoff process and cutting torque-off groove allowed.
 - 4 Use TB64VF()L for HST1094DU(), HST1094MA(), HST1094TF(), HST1094YL(), HST1094UH(), HST1094HK(), HST1094DUW(), HST1094DUWT(), HST1094DUWU(), HST1094UHWU(), and HST1094DUDW() thread lock inspection.

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	W and WU - 300 series stainless steel. WT - Commercial pure titanium per AMS4940, CP-4 composition.

FINISH:

Collar	HST1094-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305. HST1094DU() = Solid film lube per AS5272, Type I, plus orange identification on body of collar. HST1094KP() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color purple, and cetyl alcohol lube per Hi-Shear Spec. 305. HST1094MA() = Solid film lube per Kalgard RA. HST1094TF() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292. ⑯ HST1094YL() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 plus yellow identification on body of collar. ⑯ HST1094UH() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305 plus yellow identification on body of collar. HST1094HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397
Collar & Washer	HST1094DUW() = Collar finish same as HST1094DU. Washer with cadmium plate per AMS-QQ-P-416, Type II, Cass 2, and no lube. HST1094DUWT() = Collar finish same as HST1094DU6. Washer per Hi-Shear Spec. 306 Typel. color brown, and cetyl alcohol lube per Hi-Shear Spec. 305. HST1094DUWU() = Collar finish same as HST1094DU, Washer is passivate. HST1094UHWU() = Collar finish same as HST1094UH(), Washer is passivate. HST1094DUDW() = Collar finish same as HST1094DU(), Washer is passivate.

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

CODE: Dash number indicates nominal thread size in 1/32nds.
See finish note for explanation of code letters.

EXAMPLE: HST1094-8 = 1/4-28 HI-LITE™ collar with Type II, Class 2 cadmium plate.

DRAWING NO.

HST1094

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