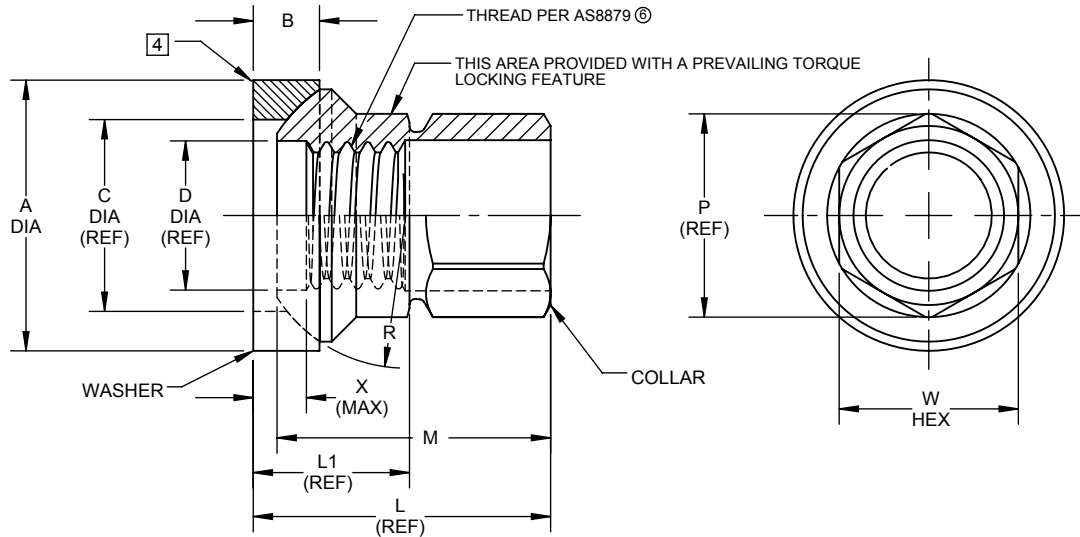




FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	C DIA REF	D DIA REF	L REF	L1 REF	M	P REF	R SPHER. RAD	W HEX	X MAX	UTS LBS. MIN	TORQUE-OFF INCH-LB
5	5/32	.1640-32 UNJC-3B	.365 .355	.095 .085	.255	.171	.415	.220	.400 .380	.250	.20	.220 .213	.095	2,300	30 15
6	3/16	.1900-32 UNJF-3B	.365 .355	.095 .085	.255	.198	.425	.230	.400 .380	.280	.20	.251 .244	.095	2,750	40 25
8	1/4	.2500-28 UNJF-3B	.475 .465	.120 .110	.333	.259	.515	.270	.485 .465	.350	.26	.314 .302	.100	5,000	90 60
10	5/16	.3125-24 UNJF-3B	.620 .610	.130 .120	.417	.322	.615	.315	.570 .550	.420	.34	.377 .365	.105	8,300	160 110
12	3/8	.3750-24 UNJF-3B	.790 .780	.145 .135	.490	.385	.685	.355	.630 .610	.490	.38	.439 .425	.105	12,700	220 160
14	7/16	.4375-20 UNJF-3B	.895 .885	.180 .170	.570	.447	.765	.405	.695 .675	.557	.45	.503 .490	.110	19,000	300 220
16	1/2	.5000-20 UNJF-3B	1.005 .995	.205 .195	.648	.510	.835	.435	.760 .740	.624	.51	.565 .550	.110	25,500	430 340

- GENERAL NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. For used on sloped surfaces up to 7° maximum on HI-LITE™ shear head pins.
 - ③ 3. Dimensions are in inches and apply after finish.
 - ④ 4. For -12, -14, and -16 washers, chamfer or radius .040-.060.

MATERIAL: Collar - 6Al-4V titanium alloy per AMS4928, AMS4930 or AMS4967, or
③ 3Al-2.5V titanium alloy per AMS4943 (AMS6940).
Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or
PH15-7Mo per AMS5520.

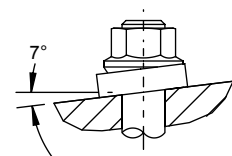
HEAT TREAT: Collar - None.
Washer - Age to H1025 condition for 17-4PH, age to TH1050 condition for 17-7PH,
③ and PH15-7Mo per AMS-H-6875.

FINISH: Collar HST1096TA-()A = Pretreat per Hi-Shear Ti-Shield III, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color orange identification on barrel, plus cetyl alcohol lube per Hi-Shear Spec. 305.
③ HST1096HK-()A = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
Washer ③ HST1096-()DW = Solid film lube per AS5272, Type 1.
HST1096-()TFW = Passivate per Hi-Shear Spec. 258, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
HST1096-()WU = Passivate per Hi-Shear Spec. 258.

SPECIFICATION: HI-LITE™ Product Specification 381.

CODE: Dash number indicates nominal diameter in 1/32nds.
Code letter "A" following dash number indicates HI-LITE™ collar.
See Finish note for explanation of code letters.

EXAMPLES: HST1096TA-8ATFW = Assembly of HST1096TA-8A collar and HST1096-8TFW washer.



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

DATE	BY	TITLE	DRAWING NO.
DRAWN	1985-10-10	D.P.S.	
APPROVED	1985-10-10	J.RAUSCH	
⑥ REVISION	2017-10-24	F.CARINGELLA	

HI-LITE™ COLLAR
SELF-ALIGNING COLLAR ASSEMBLY
6AL-4V OR 3AL-2.5V TITANIUM ALLOY COLLAR
STAINLESS STEEL WASHER
1/16 GRIP VARIATION, SHEAR APPLICATION

HST1096

1 of 1