



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	1,940	15-25
6	3/16	.1900-32 UNJF-3B	.307 .303	.340	.212 .208	.435 .415	.230	.245	.450	.280	.251 .244	.085	.100	2,500	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	60-80
10	5/16	.3125-24 UNJF-3B	.518 .512	.550	.340 .334	.625 .605	.315	.330	.640	.420	.377 .365	.095	.110	6,300	130-160
12	3/8	.3750-24 UNJF-3B	.628 .622	.660	.403 .397	.695 .675	.355	.370	.710	.490	.439 .425	.095	.110	8,700	200-240

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 TB64VF (JL for HST1097DU(), HST1097TF(), HST1097HK(), HST1097DUWU(), and HST1097DUW().

MATERIAL:

Collar A-286 high temperature alloy per AMS5731.
Washer Type 300 series stainless steel.

FINISH:

Collar HST1097-() = Collar only with silver plate per AMS2410 (.0002-.0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.
HST1097DU() = Collar only with solid film lube per AS5272, Type I, plus orange identification on body of collar.
HST1097TF() = Collar only with HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
HST1097HK() = Collar only with HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
Collar & Washer 12 HST1097DUWU() = Collar finish same as HST1097DU. Washer with passivate per AMS2700.
HST1097DUW() = Collar finish same as HST1097DU. Washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2.

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:

HST1097-8 = 1/4-28 HI-LITE™ collar with silver plate and cetyl alcohol lube.
HST1097DUWU-8 = 1/4-28 HI-LITE™ collar with solid film lube and with washer.

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DATE	BY	TITLE	DRAWING NO.
1985-01-29	D.P.S.	HI-LITE™ COLLAR	HST1097
1985-01-30	R.TING	A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, SHEAR APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS	1 of 1
2021-12-13	B. CHAN		