

FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	D DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER. RAD	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-LB
5	5/32	.1640-32 UNJC-3B													
NOTE: USE HST1076-6															
6	3/16	.1900-32 UNJF-3B	.395 .385	.088 .078	.285	.225	.435	.240	.410 .390	.280	.245 .235	.251 .244	.095	2,750	25-40
8	1/4	.2500-28 UNJF-3B	.515 .505	.123 .113	.365	.288	.525	.280	.495 .475	.350	.305 .295	.314 .302	.100	5,000	60-90
10	5/16	.3125-24 UNJF-3B	.660 .650	.160 .150	.450	.348	.625	.325	.580 .560	.420	.385 .375	.377 .365	.105	8,300	110-160
12	3/8	.3750-24 UNJF-3B	.790 .780	.180 .170	.525	.413	.695	.365	.640 .620	.490	.445 .435	.439 .425	.105	12,700	160-220
14	7/16	.4375-20 UNJF-3B	.893 .883	.237 .227	.605	.478	.775	.415	.705 .685	.557	.505 .495	.503 .490	.110	19,000	220-300
16	1/2	.5000-20 UNJF-3B	1.005 .995	.265 .255	.690	.540	.845	.445	.770 .750	.624	.565 .555	.565 .550	.110	25,500	340-430
① 18	9/16	.5625-18 UNJF-3B	1.185 1.175	.270 .260	.807	.605	.950	.530	.855 .835	.775	.715 .705	.690 .675	.115	29,000	525-625
① 20	5/8	.6250-18 UNJF-3B	1.375 1.360	.315 .305	.872	.668	1.125	.585	.940 .920	.850	.760 .750	.753 .736	.115	32,000	650-750

GENERAL NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 2. For used on sloped surfaces up to 7° maximum on HI-LITE™ tension head pins.
 ③ Dimensions are in inches and apply after finish.

④ For -12, -14, and -16 washers, chamfer or radius .040-.050.

⑤ Hardness and UTS requirement in ASTM A582/A582M and/or AMS5640 are not applicable to the raw material.
 Raw material can be supplied in cold worked condition in order to meet the product UTS requirement.

MATERIAL: ⑤ Collar - S30430 (302 HQ) stainless steel per Spec. ASTM A193, Type XM-7, 303 stainless steel per AMS-QQ-S-763 and AMS5686; or 303 Se stainless steel per ASTM A582 and AMS5640.
 Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

HEAT TREAT: Collar - None.

① Washer - Age to H1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per AMS2759.

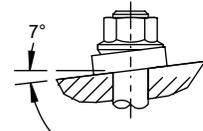
FINISH: Collar ① HST1176-()JA = Cadmium plate per AMS-QQ-P-416, Type I, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
 ① HST1176DU()JA = Solid film lube per AS5272, Type I plus orange identification on body of collar per MIL-PRF-23377.
 ① HST1176PB()JA = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
 ① HST1176TF()JA = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
 ① HST1176HK()JA = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Washer ① HST1176-()DW = Solid film lube per AS5272, Type I.
 ① HST1176-()PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 ① HST1176-()JW = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.
 ① HST1176-()JWU = Passivate per AMS2700, Method 1, Type 8, Class 1.

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: HST1176-8AW = Assembly of HST1176-8A collar and HST1176-8W washer.
 ① HST1176TF8AWU = Assembly of HST1176TF8A collar and HST1176-8WU washer.



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			TITLE	DRAWING NO.
	DATE	BY	HI-LITE™ COLLAR SELF-ALIGNING COLLAR ASSEMBLY (STAINLESS STEEL COLLAR-STAINLESS STEEL WASHER) SHEAR APPLICATION, 1/16 GRIP VARIATION FOR USE ON STANDARD AND 1/32 OVERSIZE HI-LITE™ PINS	HST1176
DRAWN	1986-02-19	D.P.S.		
APPROVED	1986-02-19	J.RAUSCH		
① REVISION	2021-01-27	A.CHAE		