

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-POUNDS
5	5/32	.1640-32 UNJC-3B	.365 .355	.095 .085	.255	.171	.415	.220	.400 .380	.250	.20	.220 .213	.095	2,300	25-35
6	3/16	.1900-32 UNJF-3B	.365 .355	.095 .085	.255	.210	.425	.230	.400 .380	.280	.20	.251 .244	.095	2,750	40-50
8	1/4	.2500-28 UNJF-3B	.475 .465	.120 .110	.333	.270	.515	.270	.485 .465	.350	.26	.314 .302	.100	5,000	105-130
10	5/16	.3125-24 UNJF-3B	.620 .610	.130 .120	.417	.334	.615	.315	.570 .550	.420	.34	.377 .365	.105	8,300	200-250
12	3/8	.3750-24 UNJF-3B	.790 .780	.145 .135	.490	.395	.685	.355	.630 .610	.490	.38	.439 .425	.105	12,700	360-440
14	7/16	.4375-20 UNJF-3B	.895 .885	.180 .170	.570	.460	.765	.405	.700 .680	.557	.45	.503 .490	.110	19,000	550-625
16	1/2	.5000-20 UNJF-3B	1.005 .995	.205 .195	.648	.525	.835	.435	.760 .740	.624	.51	.565 .550	.110	25,500	725-825

GENERAL NOTES:

1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
2. Dimensions are in inches and apply after finish and before application of lubricants.
3. Burrs from cutoff process and cutting torque-off groove allowed.
4. For use on sloped surfaces up to 7° maximum on HI-LITE™ Pins.
5. For -12, -14, and -16 washers, chamfer or radius .040-.060.
6. Use TB64AP()L for thread lock inspection.

MATERIAL: Collar S30430 (302 HQ) stainless steel per ASTM A 493, Type XM-7; 305 stainless steel per AMS-QQ-S-763 and AMS5686; or 303 stainless steel per ASTM A 582 (AMS5640); or 302 stainless steel per AMS-QQ-S-763.
 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 and 15-7Mo per AMS-H-6875.

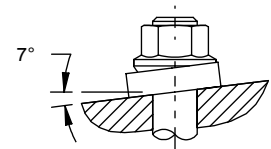
FINISH: Collar HST1275JV()A = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305, and color orange identification on body of collar.
 HST1275TP()A = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305, and color orange identification on body of collar.
 ⑤ HST1275HK()A = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Washer HST1275-()WU = Passivate per Hi-Shear Spec. 258.

SPECIFICATION: HI-LITE™ Product Specification 381. Test bolt requirement exception per note ⑥ above. ⑥

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

EXAMPLE: HST1275TP8AWU = Assembly of HST1275TP8A collar and HST1275-8WU washer.



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

DATE	BY	TITLE	DRAWING NO.
DRAWN	1994-04-19	J. F. OBISPO	HST1275
APPROVED	1994-05-09	J.G. WILCOX	
⑥ REVISION	2018-01-26	S.WILEY	
HI-LITE™ COLLAR SELF-ALIGNING COLLAR ASSEMBLY STAINLESS STEEL 1/16 GRIP VARIATION, TENSION APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS			1 of 1