

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	T MIN	W HEX	X MIN	UTS LBS. MIN
5	5/32	.1640-32 UNJC-3B	.345 .335	.071 .061	.255	.184	.395	.230	.375 .355	.248	.205 .195	.090	.220 .213	.100	2,300
6	3/16	.1900-32 UNJF-3B	.395 .385	.088 .078	.285	.225	.405	.240	.380 .360	.285	.245 .235	.098	.252 .241	.100	2,750
7	7/32	.2160-28 UNJF-3B	.470 .460	.095 .085	.320	.257	.455	.265	.430 .410	.320	.270 .260	.098	.283 .271	.100	3,750
8	1/4	.2500-28 UNJF-3B	.515 .505	.123 .113	.365	.288	.475	.280	.445 .425	.355	.310 .300	.098	.314 .302	.104	5,000
10	5/16	.3125-24 UNJF-3B	.660 .650	.160 .150	.450	.348	.555	.325	.510 .490	.430	.385 .375	.115	.378 .365	.106	8,300
12	3/8	.3750-24 UNJF-3B	.790 .780	.180 .170	.525	.413	.625	.365	.590 .570	.573	.445 .435	.130	.503 .490	.108	12,700
14	7/16	.4375-20 UNJF-3B	.893 .883	.237 .227	.605	.478	.705	.445	.640 .620	.643	.505 .495	.142	.565 .550	.112	19,000
16	1/2	.5000-20 UNJF-3B	1.005 .995	.265 .255	.690	.540	.765	.485	.675 .655	.788	.565 .555	.165	.690 .675	.114	25,500
18	9/16	.5625-18 UNJF-3B	1.185 1.175	.270 .260	.807	.605	.855	.515	.800 .780	.860	.715 .705	.185	.753 .736	.118	29,000
20	5/8	.6250-18 UNJF-3B	1.375 1.360	.315 .305	.872	.668	.940	.560	.870 .850	.860	.760 .750	.200	.753 .736	.118	32,000

**NOTES:**

- Go thread gage penetration shall be 3/4 of one revolution minimum.
- Dimensions are in inches and apply after plating or before solid film lube as applicable.
- Burrs from cutoff process and cutting torque-off groove allowed.
- For use on sloped surfaces up to 7° maximum on HI-LITE™ Tension head pins.
- 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.
- After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in the UK and European Union.

**MATERIAL:**

- Collar - S30430 (302 HQ) stainless steel per ASTM A493, Type XM-7; 305 stainless steel per AMS-QQ-S-763 and AMS5686; or 303 Se stainless steel per ASTM A582 (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 H-1025 condition for 17-4 PH, age to TH1050 condition for 17-7PH and 15-7Mo per AMS2759

**FINISH:**

- Collar - HST1475-( )A = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST1475TB( )A = Passivate per AMS2700, Method 1, Type 8, Class 1 and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST1475HKA( )A = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- Washer - HST1475-( )W = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
- HST1475-( )WU = Passivate per AMS2700, Method 1, Type 8, Class 1.

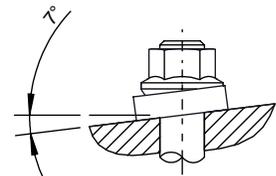
**SPECIFICATION:**

**CODE:**

- HI-LITE™ Product Specification 382.
- 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 washer.
- See "Finish" note for explanation of other code letters.

**EXAMPLE:**

- HST1475-8AW = Assembly of HST1475-8A collar and HST1475-8W washer.
- HST1475TB8AW = Assembly of HST1475TB8A collar and HST1475-8W washer.
- HST1475TB8AWU = Assembly of HST1475TB8A collar and HST1475-8WU washer.



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

			TITLE	DRAWING NO.
			<b>HI-LITE™ COLLAR</b>	<b>HST1475</b>
			SELF-ALIGNING COLLAR ASSEMBLY	
			STAINLESS STEEL WASHER	
			1/16 GRIP VARIATION, SPECIAL APPLICATION FOR USE ON STANDARD AND 1/32 OVERSIZE HI-LITE™ PINS	
DATE	BY			1 of 1
DRAWN	1989-01-17	J.F.O.		
APPROVED	1989-01-20	N.POTO		
8 REVISION	2023-02-23	D. PEÑA		