



FIRST 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	PRELOAD	
															MAX	MIN
5	5/32	.1640-32 UNJC-3B	.287 .283	.320	.173 .169	.395 .375	.220	.235	.400	.344	.314 .302	.085	.100	2,300	1,300	650
6	3/16	.1900-32 UNJF-3B	.307 .303	.340	.212 .208	.405 .395	.230	.245	.410	.344	.314 .302	.085	.100	2,750	1,900	950
8	1/4	.2500-28 UNJF-3B	.412 .408	.442	.272 .268	.475 .455	.270	.285	.480	.484	.440 .425	.090	.105	5,000	3,500	1,750
10	5/16	.3125-24 UNJF-3B	.518 .512	.552	.336 .330	.555 .535	.315	.330	.545	.624	.565 .550	.095	.110	8,300	5,500	2,760
12	3/8	.3750-24 UNJF-3B	.620 .614	.665	.398 .392	.625 .605	.355	.370	.630	.715	.628 .613	.095	.110	12,700	8,400	4,200
14	7/16	.4375-20 UNJF-3B	.733 .727	.765	.463 .457	.705 .685	.405	.420	.710	.840	.753 .736	.100	.115	19,000	11,300	5,670
16	1/2	.5000-20 UNJF-3B	.848 .842	.880	.528 .522	.765 .745	.425	.450	.770	.970	.878 .861	.100	.115	25,500	15,360	7,680
18	9/16	.5625-18 UNJF-3B	.915 .905	.910	.598 .592	.875 .855	.520	.535	.890	.970	.878 .861	.105	.120	29,000	19,440	9,720
20	5/8	.6250-18 UNJF-3B	.995 .985	1.040	.661 .655	.960 .940	.575	.590	.975	1.120	1.003 .986	.105	.120	32,000	24,600	12,300
24	3/4	.3750-16 UNJF-3B	1.120 1.110	1.140	.786 .780	1.185 1.165	.755	.770	1.205	1.240	1.128 1.110	.120	.135	42,000	35,700	17,850
28	7/8	.8750-16 UNJF-B	1.345 1.335	1.365	.911 .905	1.400 1.380	.895	.910	1.420	1.520	1.380 1.356	.125	.140	62,000	46,500	23,250
32	1	1.0000-12 UNJF-3B	1.490 1.480	1.510	1.036 1.030	1.635 1.615	1.030	1.045	1.655	1.650	1.504 1.480	.130	.145	84,000	60,000	30,000

GENERAL NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 ① 2. Dimensions are in inches and to be met after finish.

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

FINISH: Collar - HST178GU(-) = Collar with silver plate per AMS2410.
 Washer - HST178GUW(-) = Collar with silver plate per AMS2410. Washer with passivated per Hi-Shear Spec. 258.

SPECIFICATION: HI-LITE™ Product Specification 381 except preload as tabulated.

CODE: Dash number indicates nominal thread size in 1/32nds.
 See Finish note for explanation of code letters.

EXAMPLE: HST178GUW-8 = 1/4-28 HI-LITE™ collar assembly. Collar finish is silver plate per AMS2410. Washer is passivated.

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			TITLE	DRAWING NO.
DATE	BY		HI-LITE™ COLLAR A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, SPECIAL APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS	HST178 1 of 1
DRAWN	1989-07-27	D.P.S.		
APPROVED	1989-07-31	JGWILCOX		
① REVISION	2017-12-18	F.CARINGELLA		