



FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 REF	P REF	W HEX	X REF	UTS LBS. MIN	TORQUE-OFF IN-LBS
5			NOTE: USE HST97() ⁶								
6	7/32	.1900-32 UNJF-3B	.332 .328	.228 .223	.405 .385	.230	.380	.346 .332	.095	2,500	25-35
8	9/32	.2500-28 UNJF-3B	.427 .423	.288 .283	.475 .455	.270	.484	.440 .425	.100	4,300	60-80
10	11/32	.3125-24 UNJF-3B	.560 .554	.350 .345	.555 .535	.315	.624	.565 .550	.105	6,300	130-160
12	13/32	.3750-24 UNJF-3B	.683 .675	.413 .407	.625 .605	.355	.788	.690 .675	.105	8,700	200-240
14	15/32	.4375-20 UNJF-3B	.748 .740	.476 .470	.705 .685	.405	.840	.753 .736	.110	12,100	270-330
16	17/32	.5000-20 UNJF-3B	.870 .860	.538 .532	.765 .745	.435	.970	.878 .861	.110	15,300	370-430
18	19/32	.5625-18 UNJF-3B	.925 .915	.613 .607	.875 .855	.520	1.045	.941 .924	.115	20,500	500-575
20	21/32	.6250-18 UNJF-3B	1.000 .990	.678 .672	.960 .940	.575	1.120	1.003 .986	.115	25,700	625-700
24	25/32	.7500-16 UNJF-3B	1.185 .1175	.803 .797	1.185 .1165	.755	1.240	1.128 .1110	.130	37,300	900-1,000

GENERAL NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 2. Dimensions are in inches and to be met after finish and before application of lubricants.
 3. Use TB64VF() L for HST197TF() and HST197HK().

MATERIAL: 6 A-286 high temperature alloy per AMS5731 or AMS5734.

FINISH: HST197-() = Silver plate per AMS2410 (.0002-.0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST197DJ() = Solid film lube per AS5272, Type I, plus green identification on body of collar.
 HST197DU() = Solid film lube per AS5272, Type I, plus orange identification on body of collar per MIL-PRF-23377.
 HST197TF() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
 6 HST197HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LITE™ Product Specification 381. Test bolt requirement exceptions per note 3 above. 6

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

EXAMPLE: HST197-8 - Collar with silver plate and cetyl alcohol lube.

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

			TITLE	DRAWING NO.
DATE	BY		HI-LITE™ COLLAR	HST197
DRAWN	D.P.S.		A-286 HIGH TEMPERATURE ALLOY	
APPROVED	E.E.B.		1/16 GRIP VARIATION, SHEAR APPLICATION	
6 REVISION	M.BEARD/S.WILEY		FOR USE ON 1/32 OVERSIZE HI-LITE™ PINS	
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