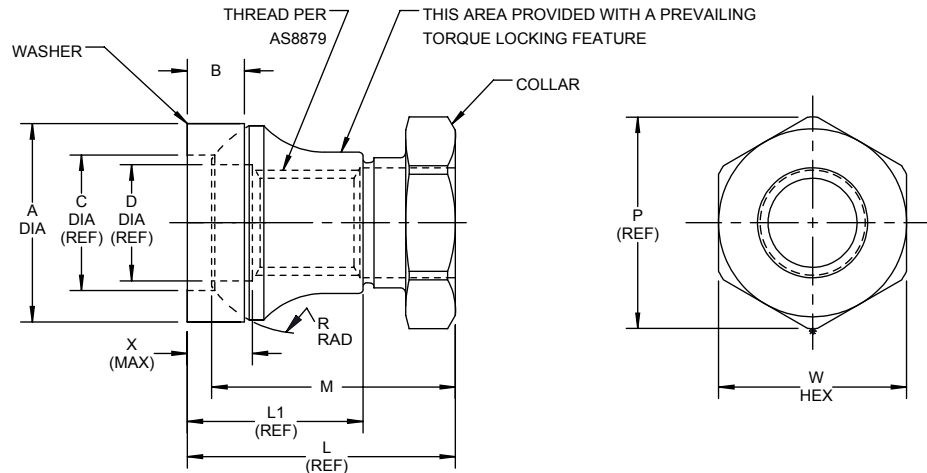


②

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[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)



②

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 MAX.	UTS LBS. MIN.	TENSION PRELOAD LBS. MIN.	TORQUE-OFF INCH-LBS.
5	5/32	.1640-32 UNJC-3B	.365 .355	.095 .085	.255	.171	.385	.220	.370 .350	.344	.20	.314 .302	.095	940	350	10-20
6	3/16	.1900-32 UNJF-3B	.365 .355	.095 .085	.255	.198	.395	.230	.370 .350	.380	.20	.346 .332	.095	1,240	500	20-30
8	1/4	.2500-28 UNJF-3B	.475 .465	.120 .110	.333	.259	.465	.270	.435 .415	.484	.26	.440 .425	.100	2,170	1,000	55-70
10	5/16	.3125-24 UNJF-3B	.620 .610	.130 .120	.417	.322	.545	.315	.500 .480	.484	.34	.440 .425	.105	3,020	1,400	90-115
12	3/8	.3750-24 UNJF-3B	.685 .675	.145 .135	.490	.385	.615	.355	.560 .540	.557	.38	.503 .488	.105	4,370	1,950	100-130
14	7/16	.4375-20 UNJF-3B	.805 .795	.180 .170	.570	.447	.695	.405	.625 .605	.624	.45	.565 .550	.110	6,000	3,000	160-200
16	1/2	.5000-20 UNJF-3B	.915 .905	.205 .195	.648	.510	.755	.435	.680 .660	.763	.51	.690 .675	.110	7,600	3,800	200-250

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
  2. Dimensions are in inches and apply after finish.
  3. For use on sloped surfaces up to 7° maximum on HI-LITE™ pins.
  4. Use HST677 for oversize replacement.
  5. Cetyl alcohol may be applied to HST577DU at manufacturer's option.

**MATERIAL:** ② Collar - 7075 aluminum alloy per AMS-QQ-A-225/9.  
Washer - 17-4PH stainless steel per AMS5643,  
or 17-7PH per AMS5528,  
or PH15-7Mo per AMS5520.

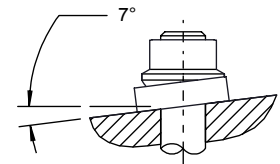
**HEAT TREAT:** ② Collar - Age to T73 condition per AMS2770.  
② Washer - Age to H-1025 condition for 17-4PH, age to TH1050  
condition for 17-7PH and PH15-7Mo per AMS-H-6875.

**FINISH:** ② Collar - HST577CK-( )A = Anodize per MIL-A-8625, dye color black,  
and cetyl alcohol lube per Hi-Shear Spec. 305.  
HST577CY-( )A = Anodize per MIL-A-8625, dye color orange,  
and cetyl alcohol lube per Hi-Shear Spec. 305.  
HST577DU-( )A = Anodize per MIL-A-8625, color natural,  
and solid film lube per AS5272, Type I. [5]  
② Washer - HST577-( )DW = Solid film lube per AS5272, Type I.  
HST577-( )PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.  
HST577-( )W = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.  
HST577-( )WU = Passivate per Hi-Shear Spec. 258.

**SPECIFICATION:** HI-LITE™ Product Specification 381.

**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 washer.  
See "Finish" note for explanation of code letters.

**EXAMPLE:** HST577CY-8AW = Assembly of HST577CY-8A collar and HST577-8W washer.  
HST577DU-8AWU = Assembly of HST577DU-8A collar and HST577-8WU washer.  
HST577DU-8ADW = Assembly of HST577DU-8A collar and HST577-8DW washer.



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

DATE	BY	TITLE	DRAWING NO.
DRAWN	1987-05-19	D.P.S.	
APPROVED	1987-05-19	N.POTO	
② REVISION	2017-12-18	M.BEARD	

**HI-LITE™ COLLAR**  
SELF-ALIGNING COLLAR ASSEMBLY  
(ALUMINUM COLLAR - STAINLESS STEEL WASHER)  
1/16 GRIP VARIATION, SHEAR APPLICATION  
FOR ALUMINUM HI-LITE™ PINS

**HST577**

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