



| 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 MIN | X1 MIN | UTS LBS. MIN | TORQUE-OFF IN. - LBS. |
|----------|-------------|------------------|--------------|--------------|--------------|--------------|----------|----------|----------|---------|--------------|-------|--------|--------------|-----------------------|
| 5 | 5/32 | .1640-32 UNJC-3B | .287 .283 | .320 | .173 .169 | .445 .425 | .250 | .265 | .460 | .250 | .220 .213 | .113 | .128 | 1,400 | 15-25 |
| 6 | 3/16 | .1900-32 UNJF-3B | .307 .303 | .340 | .212 .208 | .465 .445 | .260 | .275 | .480 | .280 | .251 .244 | .113 | .128 | 1,600 | 25-35 |
| 8 | 1/4 | .2500-28 UNJF-3B | .412 .408 | .440 | .276 .272 | .555 .535 | .300 | .315 | .570 | .350 | .314 .302 | .117 | .132 | 3,000 | 60-80 |
| 10 | 5/16 | .3125-24 UNJF-3B | .518 .512 | .550 | .340 .334 | .655 .635 | .350 | .360 | .670 | .420 | .377 .365 | .119 | .134 | 5,000 | 110-140 |
| 12 | 3/8 | .3750-24 UNJF-3B | .628 .622 | .660 | .403 .397 | .725 .705 | .390 | .400 | .740 | .490 | .439 .425 | .121 | .136 | 7,000 | 160-200 |

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
 - Dimensions are in inches and apply after finish.
 - Burrs from cutoff process and cutting torque-off groove allowed.

MATERIAL: ④ Collar - 7050 aluminum alloy per AMS4340 or 7075 aluminum alloy per AMS-QQ-A-225/9
 ④ Washer - Commercial pure titanium per AMS-T-9046, CP-4 composition.

HEAT TREAT: ④ Collar - Age to T73 condition per AMS2770.
 Washer - None.

FINISH: Collar - HST690CK(-) = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST690CY(-) = Anodize per MIL-A-8625, dye color orange, and cetyl alcohol lube per Hi-Shear Spec. 305.
 ④ HST690LP(-) = Anodize per MIL-A-8625, dye color natural, and solid film lube per AS5272, Type I.
 Collar & Washer - HST690LPWT(-) = Collar finish same as HST690LP. Washer finish per Hi-Shear Spec. 306, Type 1, color brown, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 381.

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

EXAMPLE: HST690CY-8 = 1/4-28 HI-LITE™ collar with dye color orange and cetyl alcohol lube.
 HST690LPWT-8 = 1/4-28 HI-LITE™ collar, anodize and solid film lube, with washer.

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

| | | | TITLE | DRAWING NO. |
|------------|--------------|--|---|-------------------------|
| DATE | BY | | HI-LITE™ COLLAR 7075 ALUMINUM ALLOY 3/32 GRIP VARIATION - SHEAR APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS | HST690 1 of 1 |
| DRAWN | D.P.S. | | | |
| APPROVED | P.WONG | | | |
| ④ REVISION | F.CARINGELLA | | | |