



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	TORQUE-OFF IN-LBS
5	5/32	.1640-32 UNJC-3B	.287 .283	.320	.173 .166	.395 .375	.220	.235	.400	.344	.314 .302	.085	.100	1,940	15-25
6	3/16	.1900-32 UNJF-3B	.307 .303	.340	.212 .208	.405 .385	.230	.245	.410	.344	.314 .302	.085	.100	2,500	22-32
8	1/4	.2500-28 UNJF-3B	.413 .408	.440	.272 .268	.475 .455	.270	.285	.480	.484	.440 .425	.090	.105	4,300	50-70
10	5/16	.3125-24 UNJF-3B	.518 .512	.550	.336 .330	.555 .535	.315	.330	.590	.624	.565 .550	.095	.110	6,300	80-110
12	3/8	.3750-24 UNJF-3B	.628 .622	.660	.398 .392	.625 .605	.355	.370	.630	.700	.628 .613	.095	.110	8,700	140-180
14	7/16	.4375-20 UNJF-3B	.733 .727	.777	.463 .457	.705 .685	.405	.420	.710	.840	.753 .736	.100	.115	12,100	190-250
16	1/2	.5000-20 UNJF-3B	.848 .842	.897	.528 .522	.765 .745	.435	.450	.770	.970	.878 .861	.100	.115	15,400	290-350

- GENERAL NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 - Dimensions are in inches and apply after finish and before application of lubricants.
 - Use HST171 for oversize replacement.
 - Use TB64VF()L for thread lock inspection.

MATERIAL: Collar 6Al-4V titanium alloy per AMS4928, AMS4930, AMS4967, or 3Al-2.5V titanium alloy per AMS6940 (MIL-T-9047).
 Washer 300 series stainless steel.

FINISH: Collar HST71TA() ⑦ = Collar only with pretreat per Hi-Shear Ti-Shield III and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 Collar & Washer HST71TAW() = Collar finish same as HST71TA(), and washer is passivated per Hi-Shear Spec. 258.

SPECIFICATION: HI-LITE™ Product Specification 381. Test bolt requirement exceptions per note ④ above. ⑦

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

EXAMPLE: HST71TA8 = .2500-28 HI-LITE™ Collar with HI-KOTE™ 2 and cetyl alcohol lube.
 HST71TAW8 = .2500-28 HI-LITE™ Collar with HI-KOTE™ 2 and cetyl alcohol lube and washer is passivated.

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

DATE	BY	TITLE	DRAWING NO.
DRAWN 1985-09-30	J.F.OBISPO	HI-LITE™ COLLAR	HST71
APPROVED 1985-09-30	J.RAUSCH	TITANIUM ALLOY	
⑦ REVISION 2018-01-17	F.CARINGELLA/S.WILEY	SHEAR APPLICATION, 1/16 GRIP VARIATION FOR USE ON STD. & 1/64 OVERSIZE HI-LITE™ PINS	1 of 1