



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 INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.287 .283	.320	.179 .169	.415 .395	.235	.250	.420	.344	.314 .302	.085	.100	3,050	30-40
6	3/16	.1900-32 UNJF-3B	.307 .303	.340	.212 .208	.435 .415	.245	.260	.440	.344	.314 .302	.085	.100	4,000	40-50
8	1/4	.2500-28 UNJF-3B	.413 .407	.445	.272 .268	.490 .470	.279	.295	.495	.380	.346 .332	.090	.105	7,500	110-135
10	5/16	.3125-24 UNJF-3B	.518 .512	.550	.336 .330	.575 .555	.333	.343	.580	.484	.440 .425	.095	.110	11,750	200-250
12	3/8	.3750-24 UNJF-3B	.620 .614	.660	.398 .392	.645 .625	.373	.388	.650	.557	.503 .488	.095	.110	18,000	360-420
14	7/16	.4375-20 UNJF-3B	.733 .727	.765	.463 .457	.725 .705	.425	.440	.730	.840	.753 .736	.100	.115	23,250	525-600
16	1/2	.5000-20 UNJF-3B	.848 .842	.880	.528 .522	.785 .765	.455	.470	.790	.970	.878 .861	.100	.115	32,000	725-825
18	9/16	.5625-18 UNJF-3B	.915 .905	.910	.598 .592	.900 .880	.540	.555	.905	1.050	.940 .924	.105	.120	39,000	1000-1250
20	5/8	.6250-18 UNJF-3B	.995 .985	1.040	.661 .655	.980 .960	.595	.610	.985	1.120	1.003 .986	.105	.120	49,000	1350-1550
24	3/4	.7500-16 UNJF-3B	1.120 1.110	1.140	.786 .780	1.205 1.185	.775	.825	1.210	1.240	1.128 1.110	.120	.135	70,000	1900-2200

NOTES:

- Go thread gage penetration shall be 3/4 of one revolution minimum.
- Dimensions are in inches and apply after finish and before application of lubricants.
- For use on tension head Inconel 718 HI-LITE™ pins heat treated to 125,000 psi shear minimum. Do not use on titanium pins.
- Use the following test bolts for thread lock inspection:
 TB64VF() L for HST73DU(), HST73DY(), HST73LP(), HST73V(), HST73HK(), HST73DUW(), and HST73VW().
 TB64AP() L for HST73KB(), HST73TP(), HST73KBWU().

MATERIAL: Collar 17-4PH stainless steel per AMS5643.
 Washer 300 series stainless steel.

HEAT TREAT: ⑬ Collar To condition H1025 per AMS2759.
 Washer None.

FINISH: Collar ⑬ HST73-() = Silver plate per AMS2410 (.0002-.0004 thick), color identification blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST73DU() = Solid film lube per AS5272, Type I.
 HST73DY() = Solid film lube per AS5272, Type I plus yellow identification on body of collar.
 HST73KB() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and optional cetyl alcohol lube per Hi-Shear Spec. 305, and green identification on body of collar.
 HST73LP() = Solid film lubricant per AS5272, Type II.
 HST73PB() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST73TP() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305, and orange identification on body of collar.
 HST73V() = Solid film lubricant per Lubeco 2123, Type II.
 HST73HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
 Collar & Washer HST73DUW() = Both with solid film lube per AS5272, Type I.
 ⑬ HST73KBWU() = Collar finish same as HST73KB(), and washer is passivated per AMS2700, Method 1, Type 8, Class 1.
 HST73VW() = Both with Lubeco 2123 solid film lubricant.
 ⑬ HST73W() = Collar finish same as HST73-(), and washer is passivated per AMS2700, Method 1, Type 8, Class 1.
 HST73VW() = Collar finish same as HST73-(), and washer is solid film lube per Lubeco 2123.

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

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

EXAMPLES: HST73-8 = 1/4-28 HI-LITE™ collar.
 HST73W8 = 1/4-28 HI-LITE™ collar with washer.

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

DATE	BY	TITLE	DRAWING NO.
DRAWN 1983-12-20	D.P.S.	HI-LITE™ COLLAR	HST73
APPROVED 1983-12-20	E.E.BEELES	17-4PH STAINLESS STEEL	
⑬ REVISION 2022-12-19	K. PHAM	1/16 GRIP VARIATION, TENSION APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS	1 of 1