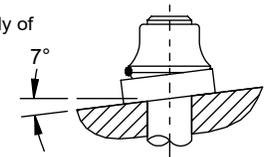


DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	D DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER. RAD (REF)	W HEX	X (MAX)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.365 .355	.095 .085	.255	.171	.385	.220	.370 .350	.380	.20	.346 .332	.095	2,300	30-40
6	3/16	.1900-32 UNJF-3B	.365 .355	.095 .085	.255	.198	.395	.230	.370 .350	.380	.20	.346 .332	.095	2,750	40-50
8	1/4	.2500-28 UNJF-3B	.475 .465	.120 .110	.333	.259	.465	.270	.435 .415	.484	.26	.440 .425	.100	5,000	115-130
10	5/16	.3125-24 UNJF-3B	.620 .610	.130 .120	.417	.322	.545	.315	.500 .480	.484	.34	.440 .425	.105	8,300	200-250
12	3/8	.3750-24 UNJF-3B	.790 .780	.145 .135	.490	.385	.615	.355	.560 .540	.557	.38	.503 .488	.105	12,700	360-440
14	7/16	.4375-20 UNJF-3B	.895 .885	.180 .170	.570	.447	.695	.405	.625 .605	.840	.45	.753 .736	.110	19,000	550-625
16	1/2	.5000-20 UNJF-3B	1.005 .995	.205 .195	.648	.510	.755	.435	.680 .660	.970	.51	.878 .861	.110	25,000	725-825

- GENERAL 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 used on sloped surfaces up to 7° maximum on HI-LITE™ tension head pins.
 - For -12, -14, and -16 washers, chamfer or radius .040-.050.
 - Cetyl alcohol lube per Hi-Shear Spec. 305 may be applied, at manufacturer's option to meet procurement specification requirements.
 - Use the following test bolts for thread lock inspection:
 TB64VF()L for HST75DU()A.
 TB64AP()L for HST75TP()A and HST75HK()A
 - Hardness and UTS requirement in ASTM A582/A582M and/or AMS5640 are not applicable to the raw material. Raw material can be supplied in cold worked condition in order to meet the product UTS requirement

- MATERIAL:** ④ Collar 303 Se stainless steel per ASTM A582/A582M and AMS5640.
 Washer 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.
- HEAT TREAT:** Collar None.
 ④ Washer Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and 15-7Mo per AMS2759
- FINISH:** Collar HST75-()A = Cadmium plate per AMS-QQ-P-416, Type I, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
 ⑤ HST75DU()A = Solid film lube per AS5272, Type I.
 HST75PB()A = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 ⑤ HST75TF()A = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
 HST75TP()A = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, color orange on body of collar, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST75HK()A = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
 Washer HST75-()DW = Solid film lube per AS5272, Type I.
 HST75-()PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 HST75()WU = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.
 ④ HST75-()WU = Passivate per AMS2700, Method 1, Type 8, Class 1



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

CODE: Dash number indicates nominal thread size in 1/32nds.
 Code letter "A" following dash number indicates HI-LITE™ collar.
 See "Finish" note for explanation of other code letters.

EXAMPLE: HST75-8AW = Assembly of HST75-8A collar and HST75-8W washer.
 HST75TF8AWU = Assembly of HST75TF8A collar and HST75-8WU washer.

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

DATE	BY	TITLE	DRAWING NO.
DRAWN 1983-12-23	D.P.S.	④ HI-LITE™ COLLAR SELF-ALIGNING COLLAR ASSEMBLY (303 SE STAINLESS STEEL COLLAR, STAINLESS STEEL WASHER) 1/16 GRIP VARIATION, TENSION APPLICATION	HST75 1 of 1
APPROVED 1983-12-23	R.TING		
④ REVISION 2024-01-30	C.ARTOS		