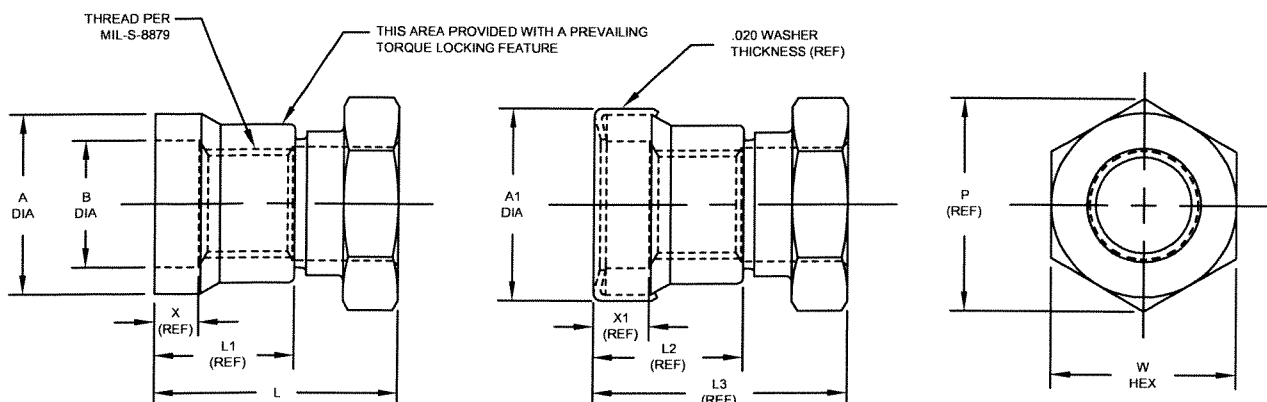


hi-shear
CORPORATION

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HI-SHEAR CORPORATION, U.S.A. — (Patent Holder) — CAGE No. 73197
a GFI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. — (Licensee - U.S.A. & Canada) — CAGE No. 06725
SPS TECHNOLOGIES, U.S.A. — (Licensee) — CAGE No. 56878
FAIRCHILD - SIMMONDS S.A. France — (Licensee) — CAGE No. 92215

BLANC AERO INDUSTRIEIS UK LIMITED — (Licensee) — CAGE No. 0LB68
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BLANC AERO S.A. France — (Licensee - ECC Countries)
a GFI AEROSPACE Company
TOKYO SCREW COMPANY, Japan — (Licensee - Japan)



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	TENSION PRELOAD LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.292 .288	.337	.173 .169	.395 .375	.220	.250	.415	.344	.314 .302	.085	.115	940	350	10-20
6	3/16	10-32UNJF-3B	.307 .303	.360	.200 .196	.405 .385	.230	.260	.425	.380	.346 .332	.085	.115	1,240	500	20-30
8	1/4	1/4-28UNJF-3B	.412 .408	.462	.261 .257	.475 .455	.270	.300	.495	.484	.440 .425	.090	.120	2,170	1,000	55-70
10	5/16	5/16-24UNJF-3B	.518 .512	.575	.325 .319	.555 .535	.315	.345	.575	.484	.440 .425	.095	.125	3,020	1,400	90-115
12	3/8	3/8-24UNJF-3B	.628 .622	.690	.388 .382	.625 .605	.355	.385	.645	.557	.503 .488	.095	.125	4,370	1,950	100-125
14	7/16	7/16-20UNJF-3B	.713 .707	.770	.450 .444	.705 .685	.405	.435	.725	.624	.565 .550	.100	.130	6,000	3,000	160-200
16	1/2	1/2-20UNJF-3B	.815 .809	.872	.513 .507	.765 .745	.435	.465	.785	.763	.690 .675	.100	.130	7,600	3,800	200-250

NOTES:

- Go thread gage or mid-pitch test pin penetration shall be 3/4 of one revolution minimum.
- Dimensions apply after finish.
- Cetyl alcohol may be applied to DU finish at manufacturer's option.
- Use HST377 for oversize replacement.

MATERIAL:

Collar - 7075 aluminum alloy per QQ-A-225/9.
Washer - 2024 aluminum alloy per QQ-A-225/6.

HEAT TREAT:

Collar - Age to T73 condition per AMS-H-6088.
Washer - Age to T6 condition per AMS-H-6088.

FINISH:

Collar - HST77-() = Anodize per AMS-A-8625, dye color brown, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST77CM() = Chemical conversion coat per MIL-C-5541, Class 1A, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST77DU() = Anodize per AMS-A-8625, and solid film lube per AS5272, Type I. 5
HST77EY() = Anodize per AMS-A-8625, dye color yellow, and cetyl alcohol lube per Hi-Shear Spec. 305.
Collar & Washer - HST77DUDW() = Collar finish same as HST77DU(). Washer finish is solid film lube per AS5272, Type I.
HST77TW() = Collar finish same as HST77-(). Washer finish is anodize per AMS-A-8625, dye color blue.

SPECIFICATION:

Hi-Lite Product Specification 381, except tension preload as tabulated.

CODE:

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

EXAMPLE:

HST77-8 = 1/4-28 Hi-Lite ST collar with cetyl alcohol lube.

U.S. Patents 4,326,825; 4,485,510 and 4,957,401.
Other U.S. and foreign patents pending.
"Hi-Lite" and "HST" are registered trademarks and
"Hi-Lite ST" is a trademark of Hi-Shear Corporation

DATE	BY	TITLE	DRAWING NO.
DRAWN	9-29-83	S.Graphics	HST77
APPROVED	10-4-83	E.E.Beeles	
REVISION	5-31-01	J.F.Obispo	
9			

HI-LITE® ST™ COLLAR
7075-T73 ALUMINUM ALLOY
1/16 GRIP VARIATION, SHEAR APPLICATION
FOR ALUMINUM HI-LITE ST PINS