



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	.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

- GENERAL NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 2. Dimensions are in inches and to be met before application of solid film lubricant.
 3. Locking torque, breakaway and preload are tested on epoxy chromate plate using preload releasing fixture.
 4. Use HST925 for oversize replacement.

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

HEAT TREAT: Collar - Age to H-1025 condition per AMS-H-6875.
 Washer - None.

FINISH: Collar - HST915TP() - 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.
 ① HST915HK() - HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
 Collar & Washer - HST915TPW() - Collar finish same as HST915TP(), and washer is solid film lube per AS5272, Type I.
 HST915TPWU() - Collar finish same as HST915TP(), and washer is passivated per Hi-Shear Spec. 258.

SPECIFICATION: HI-LITE™ Product Specification 381, except ③ and test bolt is TB64AP()M.

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

EXAMPLE: HST915TP8 = .2500-28 HI-LITE™ Collar with HI-KOTE™ 2 and cetyl alcohol lube.
 HST915TPWU8 = .2500-28 HI-LITE™ Collar with HI-KOTE™ 2 and cetyl alcohol lube and washer is passivated.

"HI-LITE" AND "HST" ARE INTERNATIONAL
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	DATE	BY	TITLE HI-LITE™ COLLAR 17-4PH STAINLESS STEEL TENSION APPLICATION, 1/16 GRIP VARIATION FOR USE ON STD, 1/64 OVERSIZE HI-LITE™ PINS	DRAWING NO.
DRAWN	2017-03-03	J.F. OBISPO		HST915
APPROVED	2017-03-07	E. E. BEELES		
① REVISION	2017-08-30	KEVIN TRAN		