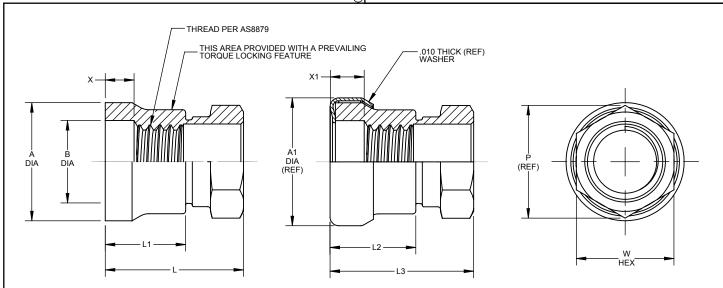


For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:

HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



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.

① 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.

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

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

- 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. - HST915TP() FINISH: Collar

- HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397. ① HST915HK()

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 REGISTERED TRADEMARKS OF HI-SHEAR CORPORATION

	DATE	BY
DRAWN	2017-03-03	J.F. OBISPO
APPROVED	2017-03-07	E. E. BEELES
1 REVISION	2017-08-30	KEVIN TRAN

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.

HST915