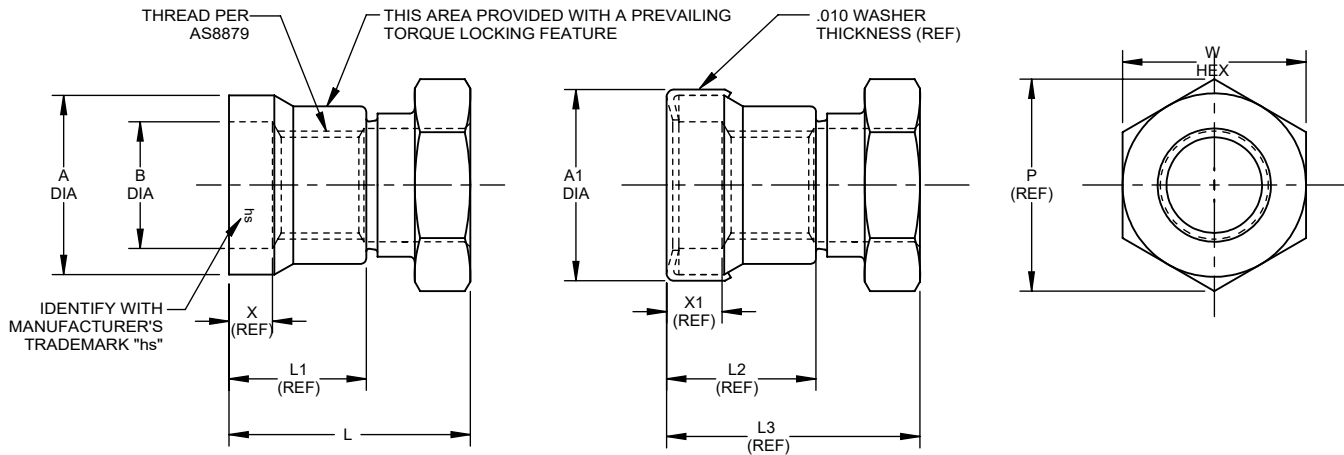




DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.287 .283	.324	.173 .169	.395 .375	.220	.235	.400	.344	.314 .302	.085	.100	1,940	15-25
6	3/16 13/64	.1900-32 UNJF-3B	.307 .303	.357	.212 .208	.405 .385	.230	.245	.410	.344	.314 .302	.085	.100	2,500	25-35
8	1/4 17/64	.2500-28 UNJF-3B	.412 .408	.457	.272 .268	.475 .455	.270	.285	.480	.484	.440 .425	.090	.105	4,300	60-80
10	5/16 21/64	.3125-24 UNJF-3B	.518 .512	.573	.336 .330	.555 .535	.315	.330	.545	.624	.565 .550	.095	.110	6,300	130-160
12	3/8 25/64	.3750-24 UNJF-3B	.620 .614	.683	.398 .392	.625 .605	.355	.370	.630	.715	.628 .613	.095	.110	8,700	200-240
14	7/16 29/64	.4375-20 UNJF-3B	.733 .727	.777	.463 .457	.705 .685	.405	.420	.710	.840	.753 .736	.100	.115	12,100	270-330
16	1/2 33/64	.5000-20 UNJF-3B	.848 .842	.897	.528 .522	.765 .745	.435	.450	.770	.970	.878 .861	.100	.115	15,300	370-430
18	9/16 37/64	.5625-18 UNJF-3B	.915 .905	.910	.598 .592	.875 .855	.520	.535	.890	1.045	.941 .924	.105	.120	20,500	500-575
20	5/8 41/64	.6250-18 UNJF-3B	.995 .985	1.040	.661 .655	.960 .940	.575	.590	.975	1.120	1.003 .986	.105	.120	25,700	625-700
24	3/4 49/64	.7500-16 UNJF-3B	1.120 1.110	1.140	.786 .780	1.185 1.165	.755	.770	1.205	1.240	1.128 1.110	.120	.135	37,300	900-1000
28	7/8 57/64	.8750-14 UNJF-3B	1.345 1.335	1.365	.911 .905	1.400 1.380	.895	.910	1.420	1.520	1.380 1.356	.125	.140	50,900	1200-1325
32	1 65/64	1.0000-12 UNJF-3B	1.490 1.480	1.510	1.036 1.030	1.635 1.615	1.030	1.045	1.655	1.650	1.504 1.480	.130	.145	67,000	1450-1600

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

DATE	BY	TITLE	DRAWING NO.
1984-02-27	D.P.S.	HI-LITE™ COLLAR	HST97
1984-02-28	E.E.B.	A-286 HIGH TEMPERATURE ALLOY	1 of 2
2020-12-03	K. PHAM	1/16 GRIP VARIATION, SHEAR APPLICATION	
REVISION		FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS	

NOTES:

1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. Dimensions are in inches and apply after finish and before application of lubricants.
3. Use HST197 for oversize replacement.
- 4 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.
- 5 Use the following test bolts for thread lock inspection:
TB64VF()L for HST97TF(), HST97DU(), HST97DUWU(), HST97DJ(), HST97DUWK(),
HST97V(), HST97EV(), and HST97HK().
TB64TF()L for HST97MA().

MATERIAL:

- 19 Collar A-286 high temperature alloy per AMS5731, AMS5734 or AMS5737.
Washer 300 series stainless steel.

FINISH:

- | | | |
|--------|--------------|---|
| Collar | HST97-() | = Collar only with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305. |
| | HST97DJ() | = Collar only with solid film lube per AS5272, Type I, plus green identification on body of collar. |
| | HST97DU() | = Collar only with solid film lube per AS5272, Type I, plus orange identification on body of collar. |
| | HST97DUWU() | = Collar with solid film lube per AS5272, Type I, plus orange identification on body of collar.
Washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2. |
| 4 | HST97DUWK() | = Collar with solid film lube per AS5272, Type I, plus orange identification on body of collar.
Washer with HI-KOTE™ 1 (minimum .0002 thickness) and optional cetyl alcohol lubrication. |
| 19 | HST97DUWU() | = Collar with solid film lube per AS5272, Type I, plus orange identification on body of collar.
Washer with passivate per AMS2700 Method 1 Type 8 Class 1. |
| | HST97MA() | = Collar only with Kalgard RA solid film lube. |
| | HST97PB() | = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305. |
| | HST97TF() | = Collar only with HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292. |
| | HST97V() | = Collar only with Lubeco 2123 solid film lube. |
| 19 | HST97W() | = Collar with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
Washer with passivate per AMS2700 Method 1 Type 8 Class 1. |
| | HST97HK() | = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397. |
| | HST97EV() | = Collar only with Everlube 620C solid film lube per AS5272, Type 1, plus blue identification on body of collar. |

SPECIFICATION:

HI-LITE™ Product Specification 381. Test bolt requirement exceptions per note 5 above.

CODE:

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

EXAMPLE:

HST97DU8 = 1/4-28 HI-LITE™ collar with solid film lube per AS5272, Type I, plus orange identification on body of collar.

DRAWING NO.

HST97

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