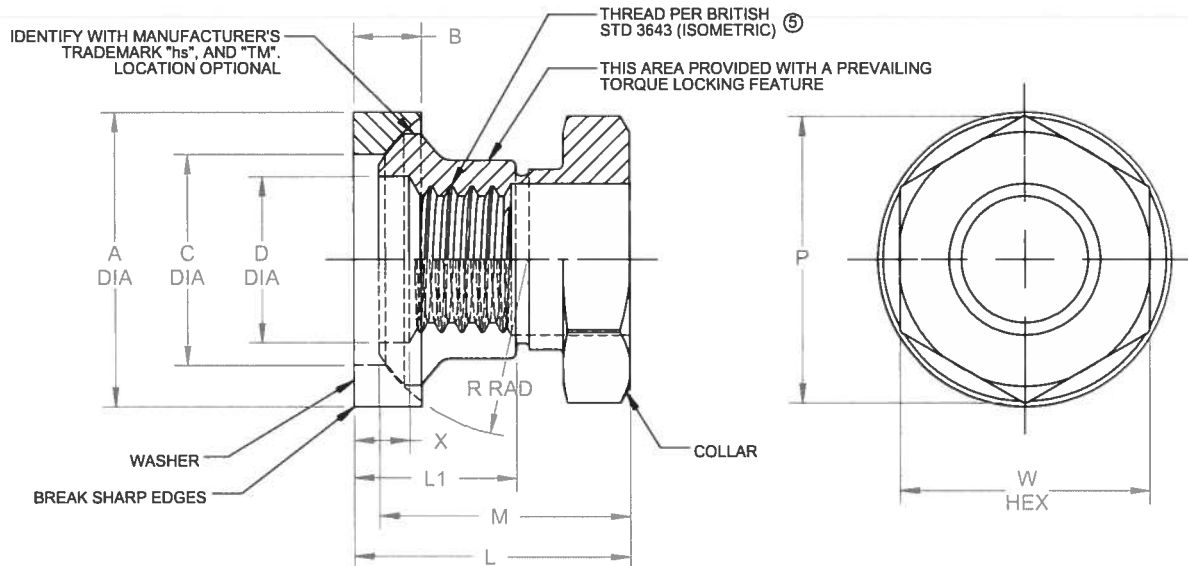




| DASH NO. (METRIC) | PIN NOM DIA | THREAD          | A DIA          | B DIA        | C DIA (REF) | D DIA (REF) | L (REF) | L1 (REF) | M              | P (REF) | R SPHER. RAD REF | W HEX          | X (REF) | TORQUE-OFF NEWTON-METER | ULT TNSN STR NEWTONS MINIMUM |
|-------------------|-------------|-----------------|----------------|--------------|-------------|-------------|---------|----------|----------------|---------|------------------|----------------|---------|-------------------------|------------------------------|
| 04                | 4           | M4 x 0.7-4H5H   | 9.27<br>9.01   | 1.99<br>1.72 | 6.0         | 4.2         | 9.90    | 5.58     | 8.94<br>8.43   | 8.87    | 5.1              | 8.00<br>7.78   | 1.7     | 2.9<br>1.7              | 5800                         |
| 05                | 5           | M5 x 0.8-4H5H   | 9.66<br>9.40   | 2.29<br>2.03 | 6.5         | 5.2         | 10.16   | 5.84     | 9.45<br>8.94   | 11.10   | 5.1              | 10.00<br>9.78  | 1.7     | 4.6<br>2.8              | 7300                         |
| 06                | 6           | M6 x 1.0-4H5H   | 11.69<br>11.43 | 2.67<br>2.41 | 8.1         | 6.2         | 11.68   | 6.60     | 10.92<br>10.41 | 12.12   | 6.7              | 11.00<br>10.73 | 2.3     | 9.1<br>5.6              | 12000                        |
| 08                | 8           | M8 x 1.0-4H5H   | 14.81<br>14.55 | 3.00<br>2.74 | 10.6        | 8.2         | 13.97   | 8.12     | 12.90<br>12.39 | 14.40   | 8.7              | 13.00<br>12.73 | 2.4     | 18.1<br>14.6            | 22200                        |
| 10                | 10          | M10 x 1.0-4H5H  | 18.55<br>18.29 | 3.94<br>3.68 | 13.0        | 10.2        | 16.13   | 9.52     | 14.80<br>14.29 | 15.56   | 11.4             | 14.00<br>13.73 | 2.4     | 28.3<br>23.7            | 33300                        |
| 12                | 12          | M12 x 1.25-4H5H | 22.10<br>21.84 | 4.58<br>4.32 | 15.7        | 12.2        | 18.54   | 10.92    | 16.72<br>16.21 | 18.90   | 13.0             | 17.00<br>16.73 | 2.5     | 43.0<br>36.1            | 48900                        |

**GENERAL NOTES:**

1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
2. Dimensions to be met after finish and before application of solid film lubricant.
3. For use on sloped up to 7° maximum on HI-LITE™ (Metric) standard pins.

**MATERIAL:** Collar - 7075 aluminum alloy per AMS-QQ-A-225/9.  
Washer - "W" - 4140 or 8740 alloy steel per AMS6382, AMS6349 or AMS-S-6049.  
"WU" - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

**HEAT TREAT:** Collar - Age to T73 condition per AMS2770.  
Washer - "W" - Austenitize and temper to RC 39-43 per AMS-H-6875.  
"WU" - Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and PH15-7Mo per AMS-H-6875.

**FINISH:** Collar - HSTM82-( )A - Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HSTM82D( )A - Anodize per MIL-A-8625, dye color natural, and solid film lube per AS5272, Type I.  
Washer - HSTM82-( )W - Cadmium plate per AMS-QQ-P-416, Type II, Class 2.  
HSTM82-( )WU - Passivate per Hi-Shear Spec. 258.

**SPECIFICATION:** HI-LITE™ Product Specification M381.

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

**EXAMPLE:** HSTM82-08AW - Assembly of HSTM82-08A HI-LITE™ collar and HSTM82-08W washer with cadmium plate.  
HSTM82D08AWU - Assembly of HSTM82D08A HI-LITE™ collar and HSTM82-08WU washer with passivate.  
HSTM82-08W - 8 mm swivel washer only with Type II, Class 2 cadmium plate.

"HI-LITE" and "HST" are international registered trademarks of Hi-Shear Corporation

|            |          |          |                                                                                                                                                                                                          |                                         |
|------------|----------|----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------|
|            | DATE     | BY       | <p>TITLE</p> <p><b>HI-LITE™ COLLAR</b></p> <p><b>(METRIC SERIES)</b></p> <p>ASSEMBLY, SELF-ALIGNING COLLAR</p> <p>(ALUMINUM COLLAR-ALLOY STEEL WASHER)</p> <p>1 mm GRIP VARIATION, SHEAR APPLICATION</p> | <p>DRAWING NO.</p> <p><b>HSTM82</b></p> |
| DRAWN      | 3-23-83  | D.P.S.   |                                                                                                                                                                                                          |                                         |
| APPROVED   | 3-30-83  | R.Ting   |                                                                                                                                                                                                          |                                         |
| ⑤ REVISION | 3-1-2017 | J.Obispo |                                                                                                                                                                                                          |                                         |