



FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	M	L1 REF	P REF	W HEX	X REF	UTS LBS. MIN	TORQUE-OFF IN-LBS
5	5/32	.1640-32 UNJC-3B	.352 .348	.173 .169	.420 .405	.040 .020	.220	.248	.223 .213	.085	2,300	25-35
6	13/64	.1900-32 UNJF-3B	.388 .384	.212 .208	.435 .415	.040 .020	.230	.280	.254 .244	.085	2,750	30-40
8	17/64	.2500-28 UNJF-3B	.509 .504	.276 .272	.525 .505	.055 .035	.290	.344	.314 .302	.090	5,000	80-95
10	21/64	.3125-24 UNJF-3B	.636 .630	.340 .334	.625 .605	.055 .035	.315	.414	.378 .365	.095	8,300	150-200
12	25/64	.3750-24 UNJF-3B	.720 .714	.403 .397	.695 .675	.060 .040	.355	.484	.440 .425	.095	12,700	260-360

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 after finish and before application of solid film lubricant.
3. Burrs from cutoff process and cutting torque-off groove allowed.

MATERIAL: Collar - S30430 (302HQ) stainless steel per ASTM A493, Type XM-7, or 305 stainless steel per AMS-QQ-S-763 and AMS5686, or 303Se stainless steel per ASTM A582 (AMS5640).
Insert - Teflon per ASTM D1710.

FINISH: Collar - HST1084PB() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST1084DU() = Solid film lube per AS5272, Type I.
HST1084TB() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, color orange on body of collar, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST1084TF() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292
⑤ HST1084HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LITE™ Product Specification 381.

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

EXAMPLE: HST1084PB8 = .2500-28 HI-LITE™ sealing collar with Teflon insert and Type II cadmium plating.

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DATE	BY	TITLE	DRAWING NO.
1985-07-26	D.P.S.	HI-LITE™ COLLAR	HST1084
1985-08-05	J.RAUSCH	(SEALING TYPE) STAINLESS STEEL	
1985-08-05	J.RAUSCH	1/16 GRIP VARIATION, TENSION APPLICATION	
1985-08-05	J.RAUSCH	FOR USE ON STANDARD AND 1/64 OVERSIZE	
1985-08-05	J.RAUSCH	HI-LITE™ PINS	
2019-04-29	F.CARINGELLA		1 of 1