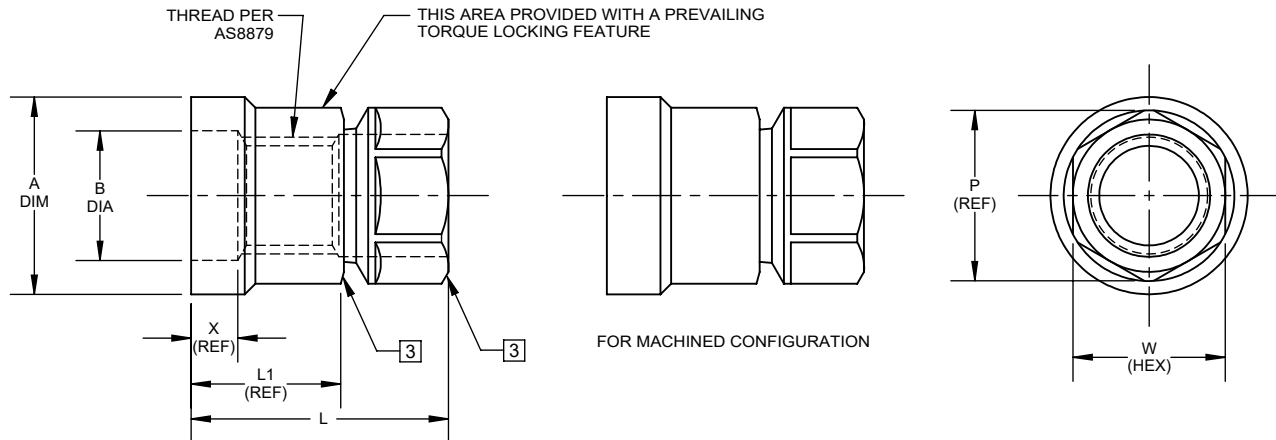




DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJF-3B									
NOTE: USE HST1094-6											
6	7/32	.1900-32 UNJF-3B	.355 .345	.228 .223	.435 .415	.240	.280	.254 .244	.095	2,750	25-35
8	9/32	.2500-28 UNJF-3B	.440 .430	.288 .283	.525 .505	.280	.344	.314 .302	.100	5,000	60-80
10	11/32	.3125-24 UNJF-3B	.535 .525	.350 .345	.625 .605	.325	.414	.378 .365	.105	8,300	130-160
12	13/32	.3750-24 UNJF-3B	.635 .625	.413 .407	.695 .675	.365	.484	.440 .425	.105	12,700	200-240
14	15/32	.4375-20 UNJF-3B	.735 .725	.476 .470	.775 .755	.415	.560	.502 .490	.110	19,000	270-330
16	17/32	.5000-20 UNJF-3B	.850 .840	.538 .532	.845 .825	.445	.632	.565 .550	.110	25,500	370-430
18	19/32	.5625-18 UNJF-3B	.925 .915	.613 .607	.950 .930	.530	.775	.690 .675	.115	29,000	500-575
20	21/32	.6250-18 UNJF-3B	1.000 .990	.678 .672	1.035 .1015	.585	.850	.753 .736	.115	32,000	625-750
24	25/32	.7500-16 UNJF-3B	1.185 1.175	.803 .797	1.255 1.235	.765	.994	.878 .861	.130	42,000	900-1,000

NOTES:

- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
- Dimensions are in inches and apply after finish and before application of lubricants.
- Burrs from cutoff process and cutting torque-off groove allowed.
- Use TB64-()L for HST1294DU(), HST1294TF(), and HST1294YL().

MATERIAL:

S30430 stainless steel per ASTM A493, Type XM-7, or 305 stainless steel per AMS-QQ-S-763 and AMS5686, or 302 stainless steel per AMS-QQ-S-763, or 303 Se stainless steel per ASTM A582 (AMS5640).

FINISH:

- HST1294-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST1294DU() = Solid film lube per AS5272, Type I, plus orange identification on body of collar.
- HST1294TB() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST1294TF() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- ⑨ HST1294UH() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305 plus Yellow DYKEM or Yellow MIL-PRF-23377 identification on body of collar.
- ⑨ HST1294YL() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 plus Yellow DYKEM or Yellow MIL-PRF-23377 identification on body of collar.
- HST1294HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION:

HI-LITE™ Product Specification 381. Test bolt requirement exceptions per note 4 above.

CODE:

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

EXAMPLE:

HST1294-8 = 1/4-28 HI-LITE™ collar with Type II cadmium plate.

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

DATE	BY	TITLE	DRAWING NO.
1985-07-26	D.P.S.	HI-LITE™ COLLAR	HST1294
1985-08-05	J.RAUSCH	STAINLESS STEEL	
2020-04-10	K. MURKER	1/16 GRIP VARIATION, SHEAR APPLICATION FOR USE ON STANDARD AND 1/32 OVERSIZE HI-LITE™ PINS	1 OF 1