



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	.320	.173 .169	.445 .425	.235	.255	.460	.250	.220 .213	.085	.100	2,300	15-25
6	3/16	.1900-32 UNJF-3B	.307 .303	.340	.212 .208	.455 .435	.245	.265	.470	.280	.251 .244	.085	.100	2,750	25-35
8	1/4	.2500-28 UNJF-3B	.412 .408	.440	.276 .272	.525 .505	.270	.285	.540	.350	.314 .302	.090	.105	5,000	60-80
10	5/16	.3125-24 UNJF-3B	.518 .512	.550	.340 .334	.633 .613	.323	.338	.650	.420	.377 .365	.095	.110	8,300	130-160
12	3/8	.3750-24 UNJF-3B	.628 .622	.660	.403 .397	.703 .683	.363	.378	.720	.490	.439 .425	.102	.123	12,700	200-240

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
  2. Dimensions are in inches and apply after finish and before application of lubricants.
  3. Burrs from cutoff process and cutting torque-off groove allowed.
  4. Use TB64VF ( ) L for thread lock inspection.

**MATERIAL:** Collar - A-286 high temperature alloy per AMS5731.  
 Washer - 300 series stainless steel.

**FINISH:** Collar HST1397DU( ) = Collar only with solid film lube per AS5272, plus orange identification on body of collar.  
 2 HST1397PB( ) = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HST1397TF( ) = Collar only with HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.  
 2 HST1397HK( ) = Collar only with HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Collar & Washer:

2 HST1397TFW( ) = Collar with HI-KOTE™ 2 solid film lube. Washer with passivate per AMS2700, Method 1, Type 8.

**SPECIFICATION:** HI-LITE™ Product Specification 381. Test bolt requirement exceptions per note 4 above. 2

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

**EXAMPLE:** HST1397PB8 = 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.
DRAWN 1985-09-19	D.P.S.	<b>HI-LITE™ COLLAR</b>	<b>HST1397</b>
APPROVED 1985-09-30	J. RAUSCH	A-286 HIGH TEMPERATURE ALLOY	
2 REVISION 2018-02-09	K. TRAN/S. WILEY	1/16 GRIP VARIATION, SHEAR APPLICATION	
		FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS	1 of 1