



DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 (REF)	P (REF)	T MIN	W HEX	X MIN	UTS LBS. MIN
5	5/32	.1640-32 UNJC-3B	.294 .286	.173 .169	.405 .385	.230	.250	.090	.220 .213	.100	2,300
6	3/16	.1900-32 UNJF-3B	.355 .345	.227 .223	.415 .395	.240	.285	.098	.252 .241	.100	2,750
7	7/32	.2160-28 UNJF-3B	.390 .380	.260 .255	.465 .445	.260	.320	.098	.283 .271	.100	3,750
8	1/4	.2500-28 UNJF-3B	.440 .430	.290 .286	.485 .465	.280	.355	.098	.314 .302	.104	5,000
10	5/16	.3125-24 UNJF-3B	.535 .525	.353 .347	.565 .545	.325	.430	.115	.378 .365	.108	8,300
12	3/8	.3750-24 UNJF-3B	.683 .673	.416 .410	.635 .615	.365	.573	.130	.503 .490	.108	12,700
14	7/16	.4375-20 UNJF-3B	.775 .765	.481 .475	.715 .695	.415	.643	.142	.565 .550	.112	19,000
16	1/2	.5000-20 UNJF-3B	.880 .870	.543 .537	.775 .755	.445	.788	.165	.690 .675	.114	25,500
18	9/16	.5625-18 UNJF-3B	.925 .915	.610 .602	.865 .845	.505	.860	.185	.753 .736	.118	29,000
20	5/8	.6250-18 UNJF-3B	1.000 .990	.672 .664	.950 .930	.560	.860	.200	.753 .736	.118	32,000

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- GENERAL 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.
  - UTS to be verified on first production run.

- 5 Use the following test bolts for thread lock inspection:  
 TB64CE( )L for HST1487( ) (5-12)  
 10 TB64VF( )L for HST1487( ) (14-20).

**MATERIAL:** S30430 (302HQ) stainless steel per ASTM A493, Type XM-7; 305 stainless steel per AMS-QQ-S-763 and AMS5686; or 303 Se stainless steel per ASTM A582 (ASM5640); or 302 stainless steel per AMS-QQ-S-763.

**FINISH:** HST1487-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HST1487TB( ) = Passivate per AMS2700, Method 1, Type 8 and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HST1487HKA( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

**SPECIFICATION:** HI-LITE™ Product Specification 382. Test bolt requirement exceptions per note 5 above.

**CODE:** Dash number indicates nominal thread size in 1/32nds.

**EXAMPLE:** HST1487-8 = 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.
DRAWN	1989-01-17	J.F.O.	<b>HI-LITE™ COLLAR</b>	<b>HST1487</b>
APPROVED	1989-01-20	R.TING	<b>STAINLESS STEEL</b>	
			<b>1/16 GRIP VARIATION, SPECIAL APPLICATION</b>	
10 REVISION	2022-05-10	K. PHAM	<b>FOR USE ON STANDARD AND 1/32 OVERSIZE HI-LITE™ PINS</b>	1 of 1