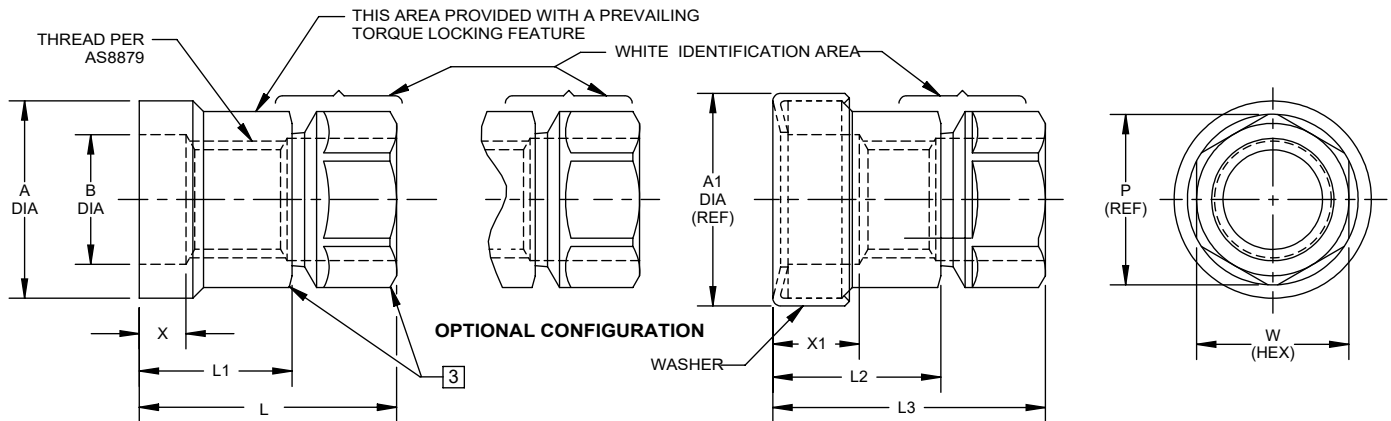


⑤

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④

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	PRELOAD POUNDS	TORQUE-OFF INCH-LB. (REF)
5	5/32	.1640-32 UNJC-3B	.292 .288	.337	.173 .169	.425 .405	.220	.250	.445	.250	.220 .213	.085	.115	1,400	1260 700	20
6	3/16	.1900-32 UNJF-3B	.307 .303	.360	.200 .196	.435 .415	.230	.260	.455	.280	.251 .244	.085	.115	1,600	1440 800	30
8	1/4	.2500-28 UNJF-3B	.412 .408	.462	.261 .257	.525 .505	.270	.300	.545	.350	.314 .302	.090	.120	3,000	2700 1500	70
10	5/16	.3125-24 UNJF-3B	.518 .512	.575	.325 .319	.625 .605	.315	.345	.645	.420	.377 .365	.095	.125	5,000	4500 2500	125
12	3/8	.3750-24 UNJF-3B	.628 .622	.690	.388 .382	.695 .675	.355	.385	.715	.490	.439 .425	.095	.125	7,000	6300 3500	180
14	7/16	.4375-20 UNJF-3B	.713 .707	.770	.450 .444	.775 .755	.405	.435	.795	.557	.503 .490	.100	.130	9,500	8500 4925	250
16	1/2	.5000-20 UNJF-3B	.815 .809	.872	.513 .507	.845 .825	.435	.465	.865	.624	.565 .550	.100	.130	12,500	11200 6250	375

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
  - ⑤ 2. Dimensions are in inches and apply after finish.
  - ③ 3. Burrs from cutoff process and cutting torque-off groove allowed.
  - ④ 4. These are reference torque-off values only and shall not be used for acceptance or rejection of collars.
  5. For use on titanium HI-LITE™ pins with HI-KOTE™ 1 and cetyl alcohol lubricant.

**MATERIAL:** Collar - 7075 aluminum alloy per AMS-QQ-A-225/9.

⑤ Washer - "WT" - Commercially pure Titanium per AMS4901, or ASTM B265 grades 1 through 4  
 "TW" - 2024 aluminum alloy per AMS-QQ-A-250/4 or AMS-QQ-A-250/5, .020 thick.

**HEAT TREAT:** Collar: Age to T73 condition per AMS-H-6088.  
 Washer: "WT" = None.  
 "TW" = Age to T6 condition per AMS2770.

**FINISH:** Collar HST1570CY( ) = Anodize per MIL-A-8625, dye color orange and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HST1570ZB( ) = Anodize per MIL-A-8625, dye color orange and cetyl alcohol lube per Hi-Shear Spec. 305 and white identification.  
 Collar & Washer HST1570ZBWT( ) = Collar same as HST1570ZB( ), and washer finish is Hi-Shear spec 306 color brown and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HST1570CYWT( ) = Collar same as HST1570CY( ), and washer finish is Hi-Shear spec 306 color brown and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HST1570ZBTW( ) = Collar same as HST1570ZB( ), and washer finish is anodize per MIL-A-8625, dye color blue.  
 HST1570CYTW( ) = Collar same as HST1570CY( ), and washer finish is anodize per MIL-A-8625, dye color blue.

**SPECIFICATION:** HI-LITE™ product specification No. 381, except preload as noted and test bolt is TB32VAP.

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

**EXAMPLES:** HST1570CY8 = 1/4-28 HI-LITE™ collar with dye color orange and cetyl alcohol lube.  
 HST1570ZBTW8 = Assembly of 1/4-28 HST1570ZB8 HI-LITE™ collar and HST1570TW8 captive washer.

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

DATE	BY	TITLE	DRAWING NO.
1994-05-05	J.F.OBISPO	<b>HI-LITE™ COLLAR</b>	<b>HST1570</b>
1994-05-05	J.G.WILCOX	ALUMINUM ALLOY	
2021-06-01	B. CHAN	1/16 GRIP VARIATION, SHEAR APPLICATION	1 of 1