

DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA REF	D DIA REF	L REF	L1 REF	M	P REF	R SPHER RAD REF	W HEX	X MAX	UTS LBS. MIN	TORQUE-OFF INCH-LB REF	PRELOAD POUNDS
5	NOTE: USE HST1596YN6AWU															
6	7/32	.1900-32 UNJF-3B	.400 .390	.120 .110	.295	.226	.440	.286	.385 .365	.280	.23	.251 .244	.095	2,750	30	1,800 800
8	9/32	.2500-28 UNJF-3B	.505 .495	.170 .160	.370	.289	.530	.328	.460 .440	.350	.26	.314 .302	.100	5,000	70	3,350 1,500
10	11/32	.3125-24 UNJF-3B	.645 .635	.170 .160	.453	.352	.625	.371	.545 .525	.420	.34	.377 .365	.105	8,300	125	4,500 2,500
12	13/32	.3750-24 UNJF-3B	.715 .705	.185 .175	.526	.416	.695	.385	.610 .590	.490	.38	.439 .425	.105	12,700	180	6,500 3,500
14	15/32	.4375-20 UNJF-3B	.935 .925	.225 .215	.605	.479	.789	.439	.685 .675	.557	.45	.503 .490	.110	19,000	250	9,000 4,725
16	17/32	.5000-20 UNJF-3B	1.045 1.035	.255 .245	.685	.542	.865	.515	.733 .723	.624	.51	.565 .550	.138	25,500	375	12,150 6,250

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 - Dimensions to be met after finish.
 - For use on sloped surfaces up to 7° maximum on HI-LITE™ pins.
 - These are reference torque-off values only and shall not be used for acceptance.
 - For use on 1/32 oversize titanium HI-LITE™ pins with HI-KOTE™ 1 or HI-KOTE™ 1 NC coating and cetyl alcohol lubricant.
 - Material 3Al-2.5V titanium to be used on -5 through -10 and 6Al-4V titanium to be used on -12 size and larger.
 - Locking Torque, breakaway and preload are tested on epoxy chromate plate and using preload releasing fixture.

MATERIAL: [6] Collar - 3Al-2.5V titanium alloy per AMS6940.
- 6Al-4V titanium alloy per AMS4967 or AMS4928.
Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

HEAT TREAT: [7] Collar - None or heat treat per AMS-H-81200 for 3Al-2.5V Ti only.
[7] Washer - Age to H1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and PH15-7Mo per AMS2759.

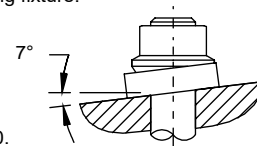
FINISH: Collar - HST1796YN()A = Pretreat per Hi-Shear Ti-Shield III, and HI-KOTE™ 2 solid film lube per Hi-Shear 292, with color orange identification on barrel, plus cetyl alcohol lube per Hi-Shear Spec. 305, and white identification.
Washer - HST1796-()WU = Passivate per AMS2700, Method 1, Type 8, Class 1.
HST1796-()TFW = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.

SPECIFICATION: HI-LITE™ Product Specification 381, except note [7], material and preload as noted and test bolt is TB64AP()M

CODE: Dash number indicates nominal thread size in 1/32nds.
Code letter "A" following dash number indicates HI-LITE™ collar.
See "Finish" note for explanation of other code letters.

EXAMPLE: HST1796YN8AWU = Assembly of HST1796YN8A HI-LITE™ collar and HST1796-8WU washer.

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



DATE	BY	TITLE	DRAWING NO.
DRAWN 1994-09-07	J.F. OBISPO	HI-LITE™ COLLAR	HST1796 1 of 1
APPROVED 1994-09-07	JG WILCOX	SELF-ALIGNING COLLAR ASSEMBLY	
[7] REVISION 2022-05-25	A.CHAE	3AL-2.5V TITANIUM ALLOY COLLAR & STAINLESS STEEL WASHER	
		1/16 GRIP VARIATION, SHEAR APPLICATION	
		FOR USE ON 1/32 OVERSIZE HI-LITE™ PINS	