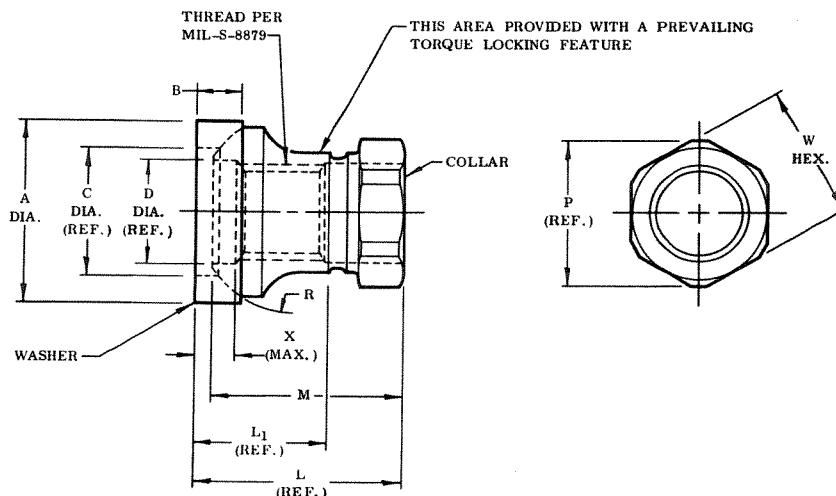


hi-shear
CORPORATION

2600 Skypark Drive
Torrance, California 90509 U.S.A.
Telephone (310) 326-8110
FAX (310) 784-4144

"CAGE" - Commercial And Government Entity

HI-SHEAR CORPORATION, U.S.A. (Patent Holder)	CAGE No. 73197	KAMAX-WERKE Germany (Licensee-EEC Countries)
Division of Hi-Shear Industries, Inc., U.S.A.		Rudolph Keller GmbH & Co. (Licensee-EEC Countries)
AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada)	CAGE No. 06725	BIMMONDS S.A. France (Licensee-EEC Countries-Collars)
SPS TECHNOLOGIES, U.S.A. (Licensee)	CAGE No. 56678	BL-CHAMOND GRANAT S.A. France (Licensee-EEC Countries)
HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee)	CAGE No. 01888	TOKYO SCREW COMPANY, Japan (Licensee-Japan)
Division of Hi-Shear Industries, Inc., U.S.A.		



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B	C DIA. REF.	D DIA. REF.	L REF.	L REF.	M	P REF.	R SPHER. RAD.	W HEX.	X MAX.	UTS LBS. MIN.	TENSION PRELOAD LBS. MIN.	TORQUE OFF INCH-LBS.
-5	4															
-6	13/64 7/32	10-32UNJF-3B	.395 .385	.088 .078	.285	.225	.405	.240	.380 .360	.380	.24	.346 .332	.095	1,240	500	20-30
-8	17/64 9/32	1/4-28UNJF-3B	.515 .505	.123 .113	.365	.288	.475	.280	.445 .425	.484	.30	.440 .425	.100	2,170	1,000	55-70
-10	21/64 11/32	5/16-24UNJF-3B	.660 .650	.160 .150	.450	.348	.555	.325	.510 .490	.484	.38	.440 .425	.105	3,020	1,400	90-115
-12	25/64 13/32	3/8-24UNJF-3B	.790 .780	.180 .170	.525	.413	.625	.365	.590 .570	.557	.44	.503 .488	.105	4,370	1,950	100-130
-14	29/64 15/32	7/16-20UNJF-3B	.893 .883	.237 .227	.605	.478	.705	.415	.640 .620	.624	.50	.565 .550	.110	6,000	3,000	160-200
-16	33/64 17/32	1/2-20UNJF-3B	1.005 .995	.265 .255	.690	.540	.765	.445	.675 .655	.763	.56	.690 .675	.110	7,600	3,800	200-250

- GENERAL NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
 - Dimensions apply after finish.
 - For use on sloped surfaces up to 7° maximum on Hi-Lite ST pins.
 - Use 3/16 standard diameter pin and HST577-6 collar as oversize for 5/32 diameter.
 - Cetyl alcohol may be applied to HST677DU- ()A at manufacturer's option.

MATERIAL:

Collar - 7075 aluminum alloy per QQ-A-225/9.
Washer - 17-4PH stainless steel per AMS5643,
or 17-7PH per AMS5528,
or PH15-7Mo per AMS5520.

HEAT TREAT:

Collar - Age to T73 condition per MIL-H-6088.
Washer - Age to H-1025 condition for 17-4PH, age to TH1050
condition for 17-7PH and PH15-7Mo per MIL-H-6875.

FINISH:

Collar - HST677CK- ()A = Anodize per MIL-A-8625, dye color black,
and cetyl alcohol lube per Hi-Shear Spec. 305.
HST677CY- ()A = Anodize per MIL-A-8625, dye color orange,
and cetyl alcohol lube per Hi-Shear Spec. 305.
HST677DU- ()A = Anodize per MIL-A-8625, color natural,
and solid film lube per MIL-L-46010, Type I. [5]

Washer - HST677- ()PBW = Cadmium plate per QQ-P-416, Type II, Class 2.
HST677- ()JW = Cadmium plate per QQ-P-416, Type I, Class 2.
HST677- ()WU = Passivate per Hi-Shear Spec. 258.

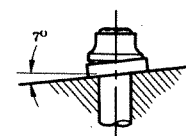
SPECIFICATION: Hi-Lite Product Specification 381, except tension preload as tabulated.

CODE:

Dash number indicates nominal thread size in 1/32nds.
Code letter "A" following dash number indicates Hi-Lite ST collar.
Code letter "W" following dash number indicates self-aligning washer.
See finish note for explanation of code letters.

EXAMPLE:

HST677CY-8AW = Assembly of HST677CY-8A collar and HST677-8W washer.
HST677DU-8AWU = Assembly of HST677DU-8A collar and HST677-8WU washer.



U.S. Patents 4,326,825; 4,485,510
and 4,957,401. Other U.S. and
foreign patents pending. "Hi-Lite"
is a registered trademark and
"Hi-Lite ST" is a trademark of Hi-
Shear Corporation.

DATE	BY	TITLE	DRAWING NUMBER
DRAWN	5-7-92	D.P.S.	
APPROVED	5-11-92	J. Wilcox	
REVISION			

HI-LITE® ST™ COLLAR

SELF-ALIGNING COLLAR ASSEMBLY
(ALUMINUM COLLAR - STAINLESS STEEL WASHER)
1/16" GRIP VARIATION - SHEAR APPLICATION
FOR USE ON STANDARD AND 1/32" OVERSIZE ALUMINUM HI-LITE ST PINS

HST677