



DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.292 .288	.173 .169	.395 .375	.220	.344	.314 .302	.085	1,400	15-25
6	3/16	.1900-32 UNJF-3B	.307 .303	.200 .196	.405 .385	.230	.380	.346 .332	.085	1,600	25-35
8	1/4	.2500-28 UNJF-3B	.412 .408	.261 .257	.475 .455	.270	.484	.440 .425	.090	3,000	60-80
10	5/16	.3125-24 UNJF-3B	.518 .512	.325 .319	.555 .535	.315	.484	.440 .425	.095	5,000	110-140
12	3/8	.3750-24 UNJF-3B	.628 .622	.388 .382	.625 .605	.355	.557	.503 .488	.095	7,000	160-200
14	7/16	.4375-20 UNJF-3B	.713 .707	.450 .444	.705 .685	.405	.624	.565 .550	.100	9,500	220-280
16	1/2	.5000-20 UNJF-3B	.815 .809	.513 .507	.765 .745	.435	.763	.690 .675	.100	12,500	340-410
18	9/16	.5625-18 UNJF-3B	.885 .875	.579 .573	.875 .855	.520	.970	.878 .861	.105	14,500	500-575
20	5/8	.6250-18 UNJF-3B	1.015 1.002	.647 .641	.960 .940	.575	1.120	1.003 .986	.105	18,000	625-700

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 - Dimensions are in inches and apply after finish before lubricant.
 - Use HST184 for oversize replacement.
 - Use TB64AP () M for locking feature and preload inspection. Preload to be tested using a primed aluminum plate under the collar.

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

HEAT TREAT: Age to T73 condition per AMS2770.

FINISH: HST70GG() = Anodize per MIL-A-8625, dye color green, and cetyl alcohol lube per Hi-Shear Spec. 305.

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

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

EXAMPLES: HST70GG8 = 1/4-28 HI-LITE™ collar with color dye green and cetyl alcohol lube.

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DATE	BY	TITLE	DRAWING NO.
1993-10-28	D.P.S.	HI-LITE™ COLLAR 7075-T73 ALUMINUM ALLOY 1/16 GRIP VARIATION, SHEAR APPLICATION	HST70 1 of 1
1993-10-28	JGWILCOX		
2022-01-18	A.CHAE		
5 REVISION			