



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	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.287 .283	.324	.173 .169	.395 .375	.220	.235	.400	.344	.314 .302	.085	.100	2,300	30-40
6	3/16	.1900-32 UNJF-3B	.307 .303	.357	.212 .208	.405 .385	.230	.245	.410	.344	.314 .302	.085	.100	2,750	40-50
8	1/4	.2500-28 UNJF-3B	.412 .408	.457	.272 .268	.475 .455	.270	.285	.480	.484	.440 .425	.090	.105	5,000	110-130
10	5/16	.3125-24 UNJF-3B	.518 .512	.573	.336 .330	.555 .535	.315	.330	.545	.624	.565 .550	.095	.110	8,300	200-250
12	3/8	.3750-24 UNJF-3B	.620 .614	.683	.398 .392	.625 .605	.355	.370	.630	.715	.628 .613	.095	.110	12,700	360-420
14	7/16	.4375-20 UNJF-3B	.733 .727	.777	.463 .457	.705 .685	.405	.420	.710	.840	.753 .736	.100	.115	19,000	525-600
16	1/2	.5000-20 UNJF-3B	.848 .842	.897	.528 .522	.765 .745	.435	.450	.770	.970	.878 .861	.100	.115	25,500	725-825
18	9/16 37/64	.5625-18 UNJF-3B	.915 .905	.910	.598 .592	.875 .855	.520	.535	.890	1.045	.941 .924	.105	.120	29,000	1000-1150
20	5/8 41/64	.6250-18 UNJF-3B	.995 .985	1.040	.661 .655	.960 .940	.575	.590	.975	1.120	1.003 .986	.105	.120	32,000	1350-1550
24	3/4 49/64	.7500-16 UNJF-3B	1.120 1.110	1.140	.786 .780	1.185 1.165	.755	.770	1.205	1.240	1.128 1.110	.120	.135	42,000	1900-2200
28	7/8 57/64	.8750-14 UNJF-3B	1.345 1.335	1.365	.911 .905	1.400 1.380	.895	.910	1.420	1.520	1.380 1.356	.125	.140	62,000	3200-3600
32	1 65/64	1.0000-12 UNJF-3B	1.490 1.480	1.510	1.036 1.030	1.635 1.615	1.030	1.045	1.655	1.650	1.504 1.480	.130	.145	84,000	4500-5000

NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.

2. Dimensions are in inches and apply after finish and before application of lubricants.

3. Use HST378 for oversize replacement.

4. After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

5. Use the following test bolts for thread lock inspection:
TB64TF()L or TB286TF()L for HST78DK() and HST78MA().
TB64VF()L for HST78DU(), HST78DUWK() and HST78DUWU().
TB64AP()L for HST78HK().

MATERIAL: Collar - A-286 high temperature alloy per AMS5731.
Washer - 300 series stainless steel.

FINISH: Collar - HST78() = Silver plate per AMS2410, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST78DK() = Solid film lube per Kalgard FA.
HST78DU() = Solid film lube per AS5272, Type I.
HST78GU() = Silver plate per AMS2410.
HST78KG() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color green, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST78MA() = Solid film lube per Kalgard RA.
HST78P() = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST78PB() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST78TB() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST78TP() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, color orange on body of collar, and cetyl alcohol per Hi-Shear Spec. 305.
HST78V() = Solid film lube per "Lubeco" 2123, Type II.
HST78HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
Collar & Washer - HST78GUW() = Collar finish same as HST78GU(). Washer is passivated per Hi-Shear Spec. 258.
HST78PBW() = Collar finish same as HST78PB(). Washer is passivated per Hi-Shear Spec. 258.
HST78PW() = Collar finish same as HST78P(). Washer is passivated per Hi-Shear Spec. 258.
HST78TBW() = Collar finish same as HST78TB(). Washer is passivated per Hi-Shear Spec. 258.
HST78VW() = Collar finish same as HST78V(). Washer is solid film lube per "Lubeco" 2123.
HST78W() = Collar finish same as HST78(). Washer is passivated per Hi-Shear Spec. 258.
HST78DUWK() = Collar finish same as HST78DU(). Washer is with HI-KOTE™ 1 (minimum .0002 thickness) and optional cetyl alcohol lubrication.
HST78DUWU() = Collar finish same as HST78DU(). Washer is passivated per Hi-Shear Spec. 258.

SPECIFICATION: HI-LITE™ Product Specification 381. Test bolt requirement exceptions per note 5 above. 15

CODE: Dash number indicates nominal thread size in 1/32nds.
See Finish note for explanation of other code letters.

EXAMPLES: HST78PB8 = 1/4-28 HI-LITE™ collar, finish is cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST78PBW8 = Assembly of HST78TB8 collar and HST78W8 washer.

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

DATE	BY	TITLE	DRAWING NO.
DRAWN	1986-11-04	D.P.S.	
APPROVED	1986-11-04	E.E.BEELES	
15 REVISION	2018-08-10	S.WILEY	

HI-LITE™ COLLAR
A-286 HIGH TEMPERATURE ALLOY
1/16 GRIP VARIATION, TENSION APPLICATION
FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS

HST78

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