



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	.292 .288	.337	.173 .169	.395 .375	.220	.250	.415	.344	.314 .302	.085	.115	1,400	15-25
6	3/16	.1900-32 UNJF-3B	.307 .303	.360	.200 .196	.405 .385	.230	.260	.425	.380	.346 .332	.085	.115	1,600	25-35
8	1/4	.2500-28 UNJF-3B	.412 .408	.462	.261 .257	.475 .455	.270	.300	.495	.484	.440 .425	.090	.120	3,000	60-80
10	5/16	.3125-24 UNJF-3B	.518 .512	.575	.325 .319	.555 .535	.315	.345	.575	.484	.440 .425	.095	.125	5,000	110-140
12	3/8	.3750-24 UNJF-3B	.628 .622	.690	.388 .382	.625 .605	.355	.385	.645	.557	.503 .488	.095	.125	7,000	160-200
14	7/16	.4375-20 UNJF-3B	.713 .707	.770	.450 .444	.705 .685	.405	.435	.725	.624	.565 .550	.100	.130	9,500	220-280
16	1/2	.5000-20 UNJF-3B	.815 .809	.872	.513 .507	.765 .745	.435	.465	.785	.763	.690 .675	.100	.130	12,500	340-410
18	9/16	.5625-18 UNJF-3B	.885 .875	.935	.579 .573	.875 .855	.520	.550	.895	.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:**
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.

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

Washer - "NW" = 300 series stainless steel, .010 thick.

"TW" = 2024 aluminum alloy per AMS-QQ-A-250/4 or AMS-QQ-A-250/5, .020 thick.

"WT" or "WY" = Commercially pure titanium per AMS4901 or ASTM B265 Grades 1 through 4

HEAT TREAT: Collar - Age to T73 condition per AMS2770.

Washer - "NW" = None.

"TW" = Age to T6 condition per AMS2770.

"WT" or "WY" = None.

FINISH: Collar - HST79CK() = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST79CY() = Anodize per MIL-A-8625, dye color orange, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST79CU() = Anodize per MIL-A-8625 and solid film lube per NG Spec. PR6-21-2-2.

Collar &
Washer

- HST79CKNW() = Collar finish same as HST79CK(). Washer is passivated.

HST79CKTW() = Collar finish same as HST79CK(). Washer finish is anodize per MIL-A-8625, dye color blue.

HST79CKWT() = Collar finish same as HST79CK(). Washer finish per Hi-Shear Spec. 306, Type I, color yellow to brown, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST79CYNW() = Collar finish same as HST79CY(). Washer is passivated.

HST79CYTW() = Collar finish same as HST79CY(). Washer finish is anodize per MIL-A-8625, dye color blue.

HST79CYWT() = Collar finish same as HST79CY(). Washer finish per Hi-Shear Spec. 306, Type I, color yellow to brown, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST79CYWY() = Collar finish same as HST79CY(). Washer finish is solid film lube per AS5272, Type I.

HST79CUNW() = Collar finish same as HST79CU(). Washer is passivated.

SPECIFICATION: HI-LITE™ Product Specification 381.

CODE: Dash number indicates nominal thread size in 1/32nds. "ALB" and "ALH" following dash number indicate collars on plastic rods, -5, -6 and -8 only. Rods for ALB have break point at base end of collars. Rods for ALH have break point at hex end of collars. See finish note for explanation of code letters.

EXAMPLES: HST79CY8 = .2500-28 HI-LITE™ collar with color dye orange and cetyl alcohol lube.

HST79CY6ALB = .1900-32 HI-LITE™ collar, packaged on rods with rod break point at base end of collar.

"HI-LITE" AND "HST" ARE INTERNATIONAL
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DATE	BY	TITLE	DRAWING NO.
1982-08-04	D.P.S.	HI-LITE™ COLLAR	HST79
1982-08-04	E.E. BEELES	7075-T73 ALUMINUM ALLOY	
2021-08-09	B. CHAN	1/16 GRIP VARIATION, SHEAR APPLICATION	1 of 1