



FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 REF	P REF	W HEX	X REF	UTS LBS. MIN	TORQUE-OFF IN-LBS
6	3/16	.1900-32 UNJF-3B	.355 .345	.227 .223	.435 .415	.245	.344	.314 .302	.095	4,000	40-50
8	1/4	.2500-28 UNJF-3B	.440 .430	.290 .286	.490 .470	.279	.380	.346 .332	.100	7,500	110-135
10	5/16	.3125-24 UNJF-3B	.535 .525	.356 .350	.575 .555	.333	.484	.440 .425	.105	11,750	200-250
12	3/8	.3750-24 UNJF-3B	.635 .625	.419 .413	.645 .625	.373	.557	.503 .488	.105	18,000	360-420
14	7/16	.4375-20 UNJF-3B	.735 .725	.481 .475	.725 .705	.425	.840	.753 .736	.110	23,750	525-675
16	1/2	.5000-20 UNJF-3B	.850 .840	.543 .537	.785 .765	.455	.970	.878 .861	.110	30,000	725-1000

**GENERAL NOTES:**

1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
- ① 2. Dimensions are in inches and to be met before application of solid film lubricant.
- ③ 3. Locking torque, breakaway and preload are tested on epoxy chromate plate using preload releasing fixture.

**MATERIAL:** 17-4PH stainless steel per AMS5643.

**HEAT TREAT:** Age to H-1025 condition per AMS-H-6875.

**FINISH:** HST925TP( ) - HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305, and orange identification on body of collar.  
 ① HST925HK( ) - HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

**SPECIFICATION:** HI-LITE™ Product Specification 381, except ③ and test bolt is TB64AP( )M.

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

**EXAMPLE:** HST925TP8 = .2500-28 HI-LITE™ Collar with HI-KOTE™ 2 and cetyl alcohol lube.

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

DATE	BY	TITLE	DRAWING NO.
DRAWN	2017-03-03	J.F.OBISPO	<b>HST925</b>
APPROVED	2017-03-07	E.E.BEELES	
① REVISION	2017-07-17	F.CARINGELLA	

**HI-LITE™ COLLAR**  
 17-4PH STAINLESS STEEL  
 TENSION APPLICATION, 1/16 GRIP VARIATION  
 FOR USE ON 1/32 OVERSIZE HI-LITE™ PINS