



FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	C DIA REF	D DIA REF	L REF	L1 REF	M	P REF	R SPHER. RAD	W HEX	X MAX	UTS LBS. MIN	TORQUE-OFF INCH-LB
5	5/32	.1640-32 UNJC-3B	.365 .355	.095 .085	.255	.171	.415	.220	.400 .380	.250	.205 .195	.220 .213	.095	2,300	15-30
6	3/16	.1900-32 UNJF-3B	.365 .355	.095 .085	.255	.198	.425	.230	.400 .380	.280	.205 .195	.251 .244	.095	2,750	25-40
8	1/4	.2500-28 UNJF-3B	.475 .465	.120 .110	.333	.259	.515	.270	.485 .465	.350	.265 .255	.314 .302	.100	5,000	60-90
10	5/16	.3125-24 UNJF-3B	.620 .610	.130 .120	.417	.322	.615	.315	.570 .550	.420	.345 .335	.377 .365	.105	8,300	110-160
12	3/8	.3750-24 UNJF-3B	.685 .675	.145 .135	.490	.385	.685	.355	.630 .610	.490	.385 .375	.439 .425	.105	12,700	160-220
14	7/16	.4375-20 UNJF-3B	.805 .795	.180 .170	.570	.447	.765	.405	.695 .675	.557	.455 .445	.503 .490	.110	19,000	220-300
16	1/2	.5000-20 UNJF-3B	.915 .905	.205 .195	.648	.510	.835	.435	.760 .740	.624	.515 .505	.565 .550	.110	25,500	340-430
18	9/16	.5625-18 UNJF-3B	1.125 1.115	.270 .260	.763	.575	.940	.520	.845 .825	.775	.715 .705	.690 .675	.115	29,000	525-625
20	5/8	.6250-18 UNJF-3B	1.305 1.290	.315 .305	.855	.644	1.025	.575	.930 .910	.850	.765 .755	.753 .736	.115	32,000	650-750

- GENERAL NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
  2. Dimensions are in inches and to be met after finish and before application of solid film lubricant.
  3. For used on sloped surfaces up to 7° maximum on HI-LITE™ pins.
  4. For -12, -14, and -16 washers, chamfer or radius .040-.050.
  5. Use TB64VF( ) L for HST1076TB( ) JA, and HST1076TF( ) JA.

**MATERIAL:** Collar S30430 (302 HQ) stainless steel per ASTM A193, Type XM-7, 303 stainless steel per AMS-QQ-S-763 and AMS5686; or 303 Se stainless steel per ASTM A582 and AMS5640.  
Washer "C" - A-286 high temperature alloy per AMS5731 or AMS5737.  
"W" - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

**HEAT TREAT:** Collar None.  
Washer "C" - 90,000 psi shear minimum.  
⑥ "W" - Age to H1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per AMS2759.

**FINISH:** Collar HST1076-( ) JA = Cadmium plate per AMS-QQ-P-416, Type I, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.  
HST1076DU( ) JA = Solid film lube per AS5272, Type I plus orange identification on body of collar per MIL-PRF-23377.  
HST1076PB( ) JA = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.  
HST1076TB( ) JA = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.  
HST1076TF( ) JA = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.  
HST1076HK( ) JA = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Washer ⑥ HST1076-( ) JU = Passivate per AMS2700, Method 1, Type 8, Class 1.  
HST1076-( ) DW = Solid film lube per AS5272, Type I.  
HST1076-( ) PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.  
HST1076-( ) JW = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.  
⑥ HST1076-( ) WU = Passivate per AMS2700, Method 1, Type 8, Class 1.

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

**CODE:** Dash number indicates nominal diameter in 1/32nds.  
Code letter "A" following dash number indicates HI-LITE™ collar.  
See Finish note for explanation of code letters.

**EXAMPLES:** HST1076TF8ACU = Assembly of HST1076TF8A collar and HST1076-8CU washer.  
HST1076-8AW = Assembly of HST1076-8A collar and HST1076-8W washer.  
HST1076TF8AWU = Assembly of HST1076TF8A collar and HST1076-8WU washer.

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	DATE	BY	TITLE  <b>HI-LITE™ COLLAR</b>  SELF-ALIGNING COLLAR ASSEMBLY (STAINLESS STEEL COLLAR-STAINLESS STEEL WASHER) SHEAR APPLICATION, 1/16 GRIP VARIATION	DRAWING NO.  <b>HST1076</b>
DRAWN	1986-02-19	D.P.S.		
APPROVED	1986-02-19	J.RAUSCH		
⑥ REVISION	2020-12-03	A.CHAE		