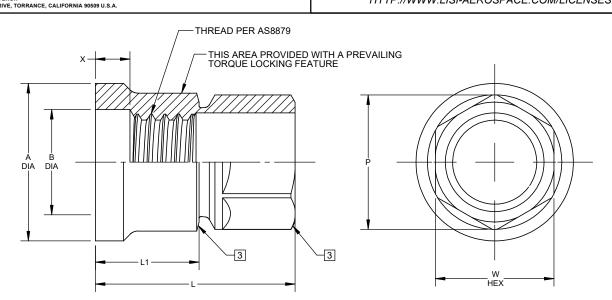
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FIRST DASH NO.	PIN NOM DIA	THREAD	<b>A</b> DIA	<b>B</b> DIA	L	L1 REF	<b>P</b> REF	<b>W</b> HEX	<b>X</b> REF	UTS LBS. MIN	TORQUE- OFF IN-LBS
5	5/32	.1640-32 UNJC-3B	.287 .283	.173 .169	.435 .405	.230	.248	.221 .213	.085	2,300	30-40
6	3/16	.1900-32 UNJF-3B	.307 .303	.212 .208	.445 .415	.240	.280	.255 .235	.085	2,750	40-50
8	1/4	.2500-28 UNJF-3B	.412 .408	.276 .272	.525 .505	.270	.344	.314 .302	.090	5,000	110-130
10	5/16	.3125-24 UNJF-3B	.518 .512	.340 .334	.625 .605	.323	.414	.378 .365	.095	8,300	200-250
12	3/8	.3750-24 UNJF-3B	.628 .622	.403 .397	.705 .675	.363	.484	.440 .425	.095	12,700	360-420
14	7/16	.4375-20 UNJF-3B	.733 .727	.468 .462	.790 .770	.420	.557	.503 .488	.100	19,000	525-600
16	1/2	.5000-20 UNJF-3B	.848 .842	.533 .527	.870 .850	.458	.624	.565 .550	.100	25,500	725-825
18	9/16	.5625-18 UNJF-3B	.915 .905	.603 .597	.950 .930	.520	.775	.690 .675	.105	29,000	1000-1150
20	5/8	.6250-18 UNJF-3B	.995 .985	.661 .655	1.035 1.015	.575	.850	.753 .736	.105	32,000	1350-1550

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- 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 lubricants.
  - Burrs from cutoff process and cutting torque-off groove allowed.
  - 4 Use TB64VF( )L for HST1078DK( ), HST1078DU( ), HST1078TB( ), HST1078TF( ), HST1078HK( ) and, HST1078UK( ) thread lock inspection.

MATERIAL: A-286 high temperature alloy per AMS5731.

FINISH: HST1078-()

(19) HST1078DK() HST1078DU()

HST1078PB()

 Silver plate per AMS2410 (.0002-.0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.
 Kalgard FA with special cure.
 Solid film lube per AS5272, Type I.
 Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HI-KOTE<sup>TM</sup> 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305. HST1078TB()

per Hi-Shear Spec. 305.

= Hi-KOTE™ 2 solid film lube per Hi-Shear Spec. 292. HST1078TF()

= HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397. HST1078HK()

HST1078UK() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, green identification. on body of collar 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 diameter in 1/32nds.

See Finish note for explanation of code letters.

**EXAMPLE:** HST1078-8 = .2500-28 HI-LITE™ collar with silver plate and cetyl alcohol lube.

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

	DATE	BY		
DRAWN	1983-03-21	D.P.S.		
APPROVED	1983-03-21	R.TING		
19 REVISION	2022-12-22	K. PHAM		

## TITLE **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

DRAWING NO.

**HST1078**