



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
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

- GENERAL NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 - 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.
 - Use TB64VF()L for HST1078DK(), HST1078DU(), HST1078TB(), HST1078TF(), HST1078HK() and, HST1078UK() thread lock inspection.

MATERIAL: A-286 high temperature alloy per AMS5731.

FINISH: HST1078-() = Silver plate per AMS2410 (.0002-.0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.
 ①9 HST1078DK() = Kalgard FA with special cure.
 HST1078DU() = Solid film lube per AS5272, Type I.
 HST1078PB() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST1078TB() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST1078TF() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
 HST1078HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
 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.

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DATE	BY	TITLE	DRAWING NO.
1983-03-21	D.P.S.	HI-LITE™ COLLAR	HST1078
1983-03-21	R.TING	A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, TENSION APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS	1 of 1
2022-12-22	K. PHAM		