



DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L MAX	P (REF)	W HEX	X (REF)	UTS LBS. MIN
4	1/2	.1380-32 UNJC-3B	.266 .262	.176 .172	.215	.215	.189 .181	.085	1,000
5	5/32	.1640-32 UNJC-3B	.292 .288	.202 .198	.225	.250	.220 .212	.085	1,400
6	3/16	.1900-32 UNJF-3B	.322 .318	.228 .224	.235	.285	.251 .243	.085	1,600
8	1/4	.2500-28 UNJF-3B	.422 .418	.288 .284	.275	.355	.313 .305	.090	3,000
10	5/16	.3125-24 UNJF-3B	.538 .532	.350 .346	.325	.430	.376 .367	.095	5,000
12	3/8	.3750-24 UNJF-3B	.649 .642	.413 .409	.365	.500	.439 .430	.095	7,000

- 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 plating or before solid film lube as applicable.
  3. Burrs from cutoff process allowed.

**MATERIAL:** 7075 aluminum alloy per QQ-A-430 or AMS-QQ-A-225/9.

**HEAT TREAT:** Age to T73 condition per AMS2770.

**FINISH:** HST1081-( ) = Anodize per MIL-A-8625, dye color green, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HST1081DU( ) = Solid film lube per AS5272, Type I.

**SPECIFICATION:** HI-LITE™ Product Specification 381, except torque-off and preload do not apply.

**CODE:** Dash number indicates nominal thread size in 1/32nds.

**EXAMPLE:** HST1081-8 = 1/4-28 HI-LITE™ collar with cetyl alcohol lube.

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

DATE	BY	TITLE	DRAWING NO.
DRAWN 1982-12-14	D.P.S.	<b>HI-LITE™ COLLAR</b>	<b>HST1081</b>
APPROVED 1982-12-14	JG WILCOX	7075-T73 ALUMINUM ALLOY	1 of 1
REVISION 2017-09-14	KEVIN TRAN	1/16 GRIP VARIATION, SPECIAL APPLICATION	