

FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	D DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER. RAD	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-LB
5	5/32	.1640-32 UNJC-3B													
NOTE: USE HST1076-6															
6	3/16	.1900-32 UNJF-3B	.395 .385	.088 .078	.285	.225	.435	.240	.410 .390	.280	.245 .235	.251 .244	.095	2,750	25-40
8	1/4	.2500-28 UNJF-3B	.515 .505	.123 .113	.365	.288	.525	.280	.495 .475	.350	.305 .295	.314 .302	.100	5,000	60-90
10	5/16	.3125-24 UNJF-3B	.660 .650	.160 .150	.450	.348	.625	.325	.580 .560	.420	.385 .375	.377 .365	.105	8,300	110-160
12	3/8	.3750-24 UNJF-3B	.790 .780	.180 .170	.525	.413	.695	.365	.640 .620	.490	.445 .435	.439 .425	.105	12,700	160-220
14	7/16	.4375-20 UNJF-3B	.893 .883	.237 .227	.605	.478	.775	.415	.705 .685	.557	.505 .495	.503 .490	.110	19,000	220-300
16	1/2	.5000-20 UNJF-3B	1.005 .995	.265 .255	.690	.540	.845	.445	.770 .750	.624	.565 .555	.565 .550	.110	25,500	340-430
18	9/16	.5625-18 UNJF-3B	1.185 1.175	.270 .260	.807	.605	.950	.530	.855 .835	.775	.715 .705	.690 .675	.115	29,000	525-625
20	5/8	.6250-18 UNJF-3B	1.375 1.360	.315 .305	.872	.668	1.125	.585	.940 .920	.850	.760 .750	.753 .736	.115	32,000	650-750

- GENERAL NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
  - For used on sloped surfaces up to 7° maximum on HI-LITE™ tension head pins.
  - Dimensions are in inches and apply after finish.
  - For -12, -14, and -16 washers, chamfer or radius .040-.050.
  - Hardness and UTS requirement in ASTM A582/A582M and/or AMS5640 are not applicable to the raw material. Raw material can be supplied in cold worked condition in order to meet the product UTS requirement.

**MATERIAL:** Collar - S30430 (302 HQ) stainless steel per Spec. 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 - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

**HEAT TREAT:** Collar - None.  
Washer - Age to H1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per AMS2759.

**FINISH:** Collar

- HST1176-( )JA = Cadmium plate per AMS-QQ-P-416, Type I, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST1176DU( )JA = Solid film lube per AS5272, Type I plus orange identification on body of collar per MIL-PRF-23377.
- HST1176PB( )JA = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST1176TF( )JA = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- HST1176HK( )JA = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Washer

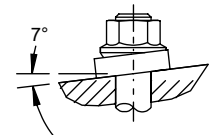
- HST1176-( )DW = Solid film lube per AS5272, Type I.
- HST1176-( )PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
- HST1176-( )W = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.
- HST1176-( )WU = Passivate per AMS2700, Method 1, Type 8, Class 1.

**SPECIFICATION:** HI-LITE™ Product Specification 381.

**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:** HST1176-8AW = Assembly of HST1176-8A collar and HST1176-8W washer.  
HST1176TF8AWU = Assembly of HST1176TF8A collar and HST1176-8WU washer.

"HI-LITE" and "HST" are international registered trademarks of Hi-Shear Corporation



DATE	BY	TITLE	DRAWING NO.
DRAWN 1986-02-19	D.P.S.	<b>HI-LITE™ COLLAR</b>	<b>HST1176</b>
APPROVED 1986-02-19	J.RAUSCH	SELF-ALIGNING COLLAR ASSEMBLY (STAINLESS STEEL COLLAR-STAINLESS STEEL WASHER) SHEAR APPLICATION, 1/16 GRIP VARIATION FOR USE ON STANDARD AND 1/32 OVERSIZE HI-LITE™ PINS	
REVISION 2021-01-27	A.CHAE		