

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-POUNDS
5	5/32	.1640-32 UNJC-3B	.365 .355	.095 .085	.255	.171	.415	.220	.400 .380	.250	.20	.220 .213	.095	1,400	15-30
6	3/16	.1900-32 UNJF-3B	.365 .355	.095 .085	.255	.210	.425	.230	.400 .380	.280	.20	.251 .244	.095	1,600	25-40
8	1/4	.2500-28 UNJF-3B	.475 .465	.120 .110	.333	.270	.515	.270	.485 .465	.350	.26	.314 .302	.100	3,000	60-90
10	5/16	.3125-24 UNJF-3B	.620 .610	.130 .120	.417	.334	.615	.315	.570 .550	.420	.34	.377 .365	.105	5,000	110-160
12	3/8	.3750-24 UNJF-3B	.685 .675	.145 .135	.490	.395	.685	.355	.630 .610	.490	.38	.439 .425	.105	7,000	160-220
14	7/16	.4375-20 UNJF-3B	.805 .795	.180 .170	.570	.460	.765	.405	.700 .680	.557	.45	.503 .490	.110	9,300	220-300
16	1/2	.5000-20 UNJF-3B	.915 .905	.205 .195	.648	.525	.835	.435	.760 .740	.624	.51	.565 .550	.110	12,500	340-430

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
 - Dimensions are in inches and apply after finish.
 - For use on sloped surfaces up to 7° maximum on HI-LITE™ pins.

MATERIAL:

Collar - 7075 aluminum alloy per AMS-QQ-A-225/9.
 Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

HEAT TREAT:

Collar - Age to T73 condition per AS2770.
 Washer - Age to H-1025 condition for 17-4 PH, age to TH1050 condition for 17-7PH and 15-7Mo per AMS2759.

FINISH:

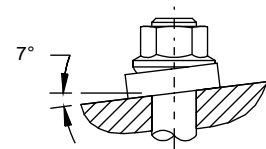
Collar - HST1183CY()A = Anodize per MIL-A-8625, dye color orange, and cetyl alcohol
 Washer - HST1183-()WU = Passivate per AMS2700, Method 1, Type 8, Class 1
 HST1183-()W = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.

SPECIFICATION: HI-LITE™ Product Specification 381.

CODE:

Dash number indicates nominal thread size in 1/32nds.
 Code letter "A" following dash number indicates HI-LITE™ collar.
 Code letter "W" following dash number indicates self-aligning collar.
 See "Finish" note for explanation of other code letters.

EXAMPLE: HST1183CY8AWU = Assembly of HST1183CY()A collar and HST1183-8WU washer.



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

DRAWN	DATE	BY	TITLE	DRAWING NO.
J.F.O.	1989-01-17	J.F.O.	HI-LITE™ COLLAR	HST1183
JG WILCOX	1994-05-09	JG WILCOX	SELF-ALIGNING COLLAR ASSEMBLY	
C. Artos	2023-06-01	C. Artos	(ALUMINUM COLLAR, STAINLESS STEEL WASHER)	
			1/16 GRIP VARIATION, SHEAR APPLICATION	
			FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS	