



FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	F DIA MAX	L	L1 REF	N MAX	P REF	T MIN	W HEX	X	UTS LBS. MIN	TORQUE-OFF IN-LBS
5	5/32	.1640-32 UNJC-3B	.294 .286	.173 .169	.253	.405 .385	.230	.070	.248	.090	.221 .211	.102 .092	1,400	15-25
6	3/16	.1900-32 UNJF-3B	.355 .345	.228 .223	.290	.415 .395	.240	.070	.285	.098	.252 .241	.102 .092	1,600	25-35
8	1/4	.2500-28 UNJF-3B	.440 .430	.288 .283	.360	.485 .465	.280	.080	.355	.098	.314 .302	.106 .096	3,000	60-80
10	5/16	.3125-24 UNJF-3B	.535 .525	.350 .345	.435	.565 .545	.325	.090	.430	.115	.378 .365	.108 .098	5,000	110-140
12	3/8	.3750-24 UNJF-3B	.635 .625	.413 .407	.505	.635 .615	.365	.090	.500	.130	.440 .428	.110 .100	7,000	160-200
14	7/16	.4375-20 UJF-3B	.735 .725	.476 .470	.578	.715 .695	.415	.100	.573	.142	.503 .490	.114 .104	9,500	220-280
16	1/2	.5000-20 UNJF-3B	.850 .840	.538 .532	.648	.775 .755	.445	.110	.643	.165	.565 .550	.116 .106	12,500	340-410
18	9/16	.5625-18 UNJF-3B	.925 .915	.610 .602	.793	.865 .845	.505	.110	.788	.185	.690 .675	.120 .110	14,500	450-535
20	5/8	.6250-18 UNJF-3B	1.000 .990	.672 .664	.865	.950 .930	.560	.115	.860	.200	.753 .736	.120 .110	18,000	575-650

- 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.
  3. Burrs from cutoff process and cutting torque-off groove allowed.
  4. Use the following test bolts for thread lock inspection:  
TB64CE( )L for HST1380-(5-12).  
TB64VF( )L for HST1380-(14-20).

**MATERIAL:** 7075 aluminum alloy per AMS-QQ-A-225/9 or 7050 aluminum alloy per QQ-A-430.

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

**FINISH:** HST1380-( ) = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.

**SPECIFICATION:** HI-LITE™ Product Specification 381. Test bolt requirement exceptions per note [4] above. [17]

**CODE:** Dash number indicates nominal diameter in 1/32nds.  
See Finish note for explanation of code letters.

**EXAMPLE:** HST1380-8 = .2500-28 HI-LITE™ collar with anodize and cetyl alcohol lube.

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DATE	BY	TITLE	DRAWING NO.
1983-02-04	D.P.S.	<b>HI-LITE™ COLLAR</b>	<b>HST1380</b>
1983-02-04	R.TING	<b>ALUMINUM ALLOY</b>	
1983-02-04	R.TING	<b>1/16 GRIP VARIATION, SHEAR APPLICATION</b>	
2018-02-15	M.BEARD/S.WILEY	<b>FOR USE ON STANDARD AND 1/32 OVERSIZE HI-LITE™ PINS</b>	