

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	T MIN	W HEX	X	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.345 .335	.071 .061	.255	.184	.395	.230	.375 .355	.248	.205 .195	.090	.223 .211	.108 .088	1,400	15-30
6	3/16	.1900-32 UNJF-3B	.395 .385	.088 .078	.285	.225	.405	.240	.380 .360	.285	.245 .235	.098	.252 .241	.112 .092	1,600	25-40
8	1/4	.2500-28 UNJF-3B	.515 .505	.123 .113	.365	.288	.475	.280	.445 .425	.355	.310 .300	.098	.314 .302	.116 .096	3,000	60-90
10	5/16	.3125-24 UNJF-3B	.660 .650	.160 .150	.450	.348	.555	.325	.510 .490	.430	.385 .375	.115	.378 .365	.118 .098	5,000	110-160
12	3/8	.3750-24 UNJF-3B	.790 .780	.180 .170	.525	.413	.625	.365	.590 .570	.500	.445 .435	.130	.440 .428	.120 .100	7,000	160-240
14	7/16	.4375-20 UNJF-3B	.893 .883	.237 .227	.605	.478	.705	.445	.640 .620	.573	.505 .495	.142	.503 .490	.124 .104	9,500	220-320
16	1/2	.5000-20 UNJF-3B	1.005 .995	.265 .255	.690	.540	.765	.485	.675 .655	.643	.565 .555	.165	.565 .550	.126 .106	12,500	340-440
18	9/16	.5625-18 UNJF-3B	1.185 .1175	.270 .260	.807	.605	.855	.515	.800 .780	.788	.715 .705	.185	.690 .675	.130 .110	14,500	450-550
20	5/8	.6250-18 UNJF-3B	1.375 .1360	.315 .305	.872	.668	.940	.560	.870 .850	.860	.760 .750	.200	.753 .736	.130 .110	18,000	575-675

- 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 finish and before application of lubricants.
 3. Burrs from cutoff process and cutting torque-off groove allowed.
 4. For use on sloped surfaces up to 7° maximum on HI-LITE™ Pins.
 5. Use the following test bolts for thread lock inspection:
 TB64CE()L for HST1382-(5-12)A
 TB64VF()L for HST1382-(14-20)A

MATERIAL: Collar - 7050 aluminum alloy per AMS4340 or 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.

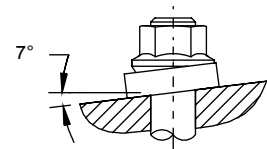
HEAT TREAT: Collar - Age to T73 condition per AMS2770.
 Washer - Age to H1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and PH15-7Mo per AMS-H-6875.

FINISH: Collar - HST1382-()A = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.
 Washer - HST1382-()W = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 HST1382-()WU = Passivate per AMS2700, Method 1, Type 8.

SPECIFICATION: HI-LITE™ Product Specification 381. Test bolt requirement exceptions per note 5 above.

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: HST1382-8AW = Assembly of HST1382-8A collar and HST1382-8W washer.



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

DATE	BY	TITLE	DRAWING NO.
1983-06-07	D.P.S.	HI-LITE™ COLLAR	HST1382
1983-06-08	R. TING	SELF-ALIGNING COLLAR ASSEMBLY	
2018-02-09	K.TRAN/S.WILEY	ALUMINUM COLLAR, STAINLESS STEEL WASHER	
		1/16 GRIP VARIATION, SHEAR APPLICATION	
		FOR USE ON STANDARD AND 1/32 OVERSIZE HI-LITE™ PINS	