



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 MIN	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.294 .286	.173 .169	.260	.405 .385	.230	.090	.250	.090	.220 .213	.100	1,400	15-25
6	3/16	.1900-32 UNJF-3B	.355 .345	.228 .223	.295	.415 .395	.240	.095	.285	.098	.252 .241	.100	1,600	22-32
7	7/32	.2160-28 UNJF-3B	.390 .380	.260 .255	.330	.465 .445	.260	.095	.320	.098	.283 .271	.100	2,250	37-52
8	1/4	.2500-28 UNJF-3B	.440 .430	.288 .283	.365	.485 .465	.280	.100	.355	.098	.314 .302	.104	3,000	52-68
10	5/16	.3125-24 UNJF-3B	.535 .525	.350 .345	.440	.565 .545	.325	.115	.430	.115	.378 .365	.106	5,000	110-140
12	3/8	.3750-24 UNJF-3B	.683 .673	.413 .407	.585	.635 .615	.365	.120	.573	.130	.503 .490	.108	7,000	160-200
14	7/16	.4375-20 UNJF-3B	.775 .765	.476 .470	.655	.715 .695	.415	.120	.643	.142	.565 .550	.112	9,500	220-280
16	1/2	.5000-20 UNJF-3B	.880 .870	.538 .532	.800	.775 .755	.445	.125	.788	.165	.690 .675	.114	12,500	340-410
18	9/16	.5625-18 UNJF-3B	.925 .915	.610 .602	.875	.865 .845	.505	.130	.860	.185	.753 .736	.118	14,500	450-535
20	5/8	.6250-18 UNJF-3B	1.000 .990	.672 .664	.875	.950 .930	.560	.130	.860	.200	.753 .736	.118	18,000	575-650

GENERAL NOTES:

1. Go thread gage or mid-pitch test pin penetration shall be 3/4 of one revolution minimum.
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. Use the following test bolts for thread lock inspection:
 TB64CE()L for HST1480-(5,6,8-12).
 TB64VF()L for HST1480-(7,14-20).

MATERIAL: 7050 aluminum alloy per AMS4341 or 7075 aluminum alloy per AMS-QQ-A-225/9.

HEAT TREAT: Age to T73 condition per AMS2770.

FINISH: HST1480-() = 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. 12

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

EXAMPLE: HST1480-8 = 1/4-28 HI-LITE™ collar with cetyl alcohol lube.

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

	DATE	BY	TITLE HI-LITE™ COLLAR ALUMINUM ALLOY 1/16 GRIP VARIATION, SHEAR APPLICATION FOR USE ON STANDARD AND 1/32 OVERSIZE HI-LITE™ PINS	DRAWING NO.
DRAWN	1983-03-21	J.F.O.		HST1480
APPROVED	1983-03-21	N.POTO		
12 REVISION	2018-01-26	M.BEARD/S.WILEY		
			1 of 1	