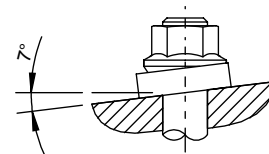


DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	D DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER. RAD	T MIN	W HEX	X MIN	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
6	3/16	.1900-32 UNJF-3B	.395 .385	.088 .078	.285	.225	.405	.240	.380 .360	.285	.245 .235	.098	.252 .241	.100	1,600	25-40
7	7/32	.2160-28 UNJF-3B	.470 .460	.095 .085	.320	.257	.455	.265	.430 .410	.320	.270 .260	.098	.283 .271	.100	2,250	45-60
8	1/4	.2500-28 UNJF-3B	.515 .505	.123 .113	.365	.288	.475	.280	.445 .425	.355	.310 .300	.098	.314 .302	.104	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	.106	5,000	110-160
12	3/8	.3750-24 UNJF-3B	.790 .780	.180 .170	.525	.413	.625	.365	.590 .570	.573	.445 .435	.130	.503 .490	.108	7,000	160-240
14	7/16	.4375-20 UNJF-3B	.893 .883	.237 .227	.605	.478	.705	.445	.640 .620	.643	.505 .495	.142	.565 .550	.112	9,500	220-320
16	1/2	.5000-20 UNJF-3B	1.005 .995	.265 .255	.690	.540	.765	.485	.675 .655	.788	.565 .555	.165	.690 .675	.114	12,500	340-440
18	9/16	.5625-18 UNJF-3B	1.185 .1175	.270 .260	.807	.605	.855	.515	.800 .780	.860	.715 .705	.185	.753 .736	.118	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	.118	18,000	575-675

**GENERAL NOTES:**

- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
- Dimensions are in inches and apply after finish and before application of lubricants.
- Burrs from cutoff process and cutting torque-off groove allowed.
- For use on sloped surfaces up to 7° maximum on HI-LITE™ Pins.
- For -7 size parts manufactured prior to Revision 4:  
L (Ref) = .445; and Torque-off = 32-48.
- Use the following test bolts for thread lock inspection:  
TB64CE (JL for HST1482-(6,8,10,12)A.  
TB64VF (JL for HST1482-(7,14,16,18,20)A.



**MATERIAL:** Collar - 7050 aluminum alloy per AMS4341 or 7075 aluminum alloy per AMS-QQ-A-225/9.  
 Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH13-7Mo 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 15-7Mo per AMS-H-6875.

**FINISH:** Collar - HST1482-( )A = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 Washer - HST1482-( )W = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

**SPECIFICATION:** HI-LITE™ Product Specification 381. Test bolt requirement exceptions per note [6] above. ⑦

**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:** HST1482-8AW = Assembly of HST1482-8A collar and HST1482-8W washer.

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

DATE	BY	TITLE	DRAWING NO.
1989-01-17	JFO	<b>HI-LITE™ COLLAR</b>	<b>HST1482</b>
1989-01-20	N. POTO	<b>SELF-ALIGNING COLLAR ASSEMBLY</b>	
2018-02-15	K.TRAN/S.WILEY	<b>ALUMINUM COLLAR, STAINLESS STEEL WASHER</b>	
		<b>1/16 GRIP VARIATION, SHEAR APPLICATION</b>	
		<b>FOR USE ON STANDARD AND 1/32 OVERSIZE HI-LITE™ PINS</b>	