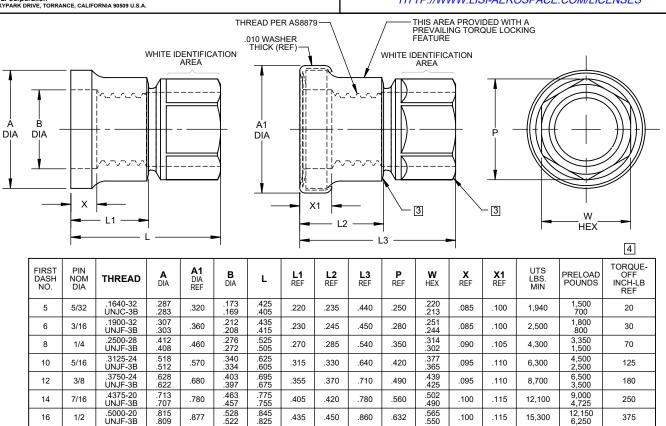
AEROSPACE

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GENERAL NOTES:

.598 .592

.655

.786 .780

911

1.041 1.035

.947

1.040

1.140

1.365

1.510

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 solid film lubricant.

.950 .930

1.035 1.015

1.255 1.235

1 455

1.725 1.705

3 Burrs from cutoff process and cutting torque-off groove allowed.

.755

.895

1.030

These are reference torque-off values only and shall not be used for acceptance or rejection of collars.

(6) 5. For use on titanium HI-LITE™ pins with HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating and cetyl alcohol lube per HS 305.

.590

.770

.910

1.045

1.050

1.270

1.480

.850

.994

1.140

[6] Locking torque, breakaway and preload are tested on epoxy chromate plate using preload releasing fixture.

3AI-2.5V titanium per AMS6940 (AMS-T-9047) for -5 through -10 sizes. 6AI-4V titanium per AMS4928 or AMS4967 for -12 and larger sizes. MATERIAL: Collar

Washer - WT - Commercially pure titanium per ASTM B 265, ASTM B 348. Minimum yield 25 KSI. DW - 300 Series stainless steel.

FINISH: Collar HST1571YN()

= Anodize per Hi-Shear Ti-Shield III and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color orange identification on body of collar plus cetyl alcohol lube per

.690 .675

.753 .736

.878

.861 1.003

985

1.128 1.110

105

105

.120

125

130

.120

.120

.135

.140

.145

19,000

23,000

30.700

45.000

60,900

Hi-Shear Spec. 305, and white identification.

HST1571HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Collar &

.5625-18

UNJF-3B

.6250-18 UNJF-3B

.7500-16 UNJF-3B

.8750-14

UNJF-3B

1.0000-12 UNJF-3B

18

20

24

28

9/16

3/4

7/8

.915 .905

.995 .985

1.120 1.110

1.345 1.335

1.490 1.480

Washer (16) HST1571()WT() = See HST1571() collar for applicable finish. Washer finish per Hi-Shear Spec. 306, Type I, color brown, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST1571()DW() = See HST1571() collar for applicable finish. Washer finish is solid film lube per

AS5272, Type I.

SPECIFICATION: HI-LITE™ Product Specification 381, except note [6], materials and preload as noted and test bolt is TB64AP()M.

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

EXAMPLES: HST1571YN8 = .2500-28 HI-LITE™ collar

HST1571YNWT8 = .2500-28 HI-LITE™ collar with washer. HST1571YNDW8 = .2500-28 HI-LITE™ collar with washer.

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

15,300 7,250

18,900 9,000

27,630 13,750

37.800

18,750

49,500 25,000

TBD

TBD

TBD

TBD

TBD

	DATE	BY
DRAWN	1994-01-06	J.F.OBISPO
APPROVED	1994-01-06	J.G.WILCOX
16 REVISION	2021-06-14	B. CHAN

TITLE HI-LITE™ COLLAR

TITANIUM ALLOY 1/16 GRIP VARIATION, SHEAR APPLICATION FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS

DRAWING NO.

HST1571