



FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 DIA REF	B DIA	L	L1 REF	L2 REF	L3 REF	P REF	W HEX	X REF	X1 REF	UTS LBS. MIN	PRELOAD POUNDS	TORQUE-OFF INCH-LB REF
5	5/32	.1640-32 UNJC-3B	.287 .283	.320	.173 .169	.425 .405	.220	.235	.440	.250	.220 .213	.085	.100	1,940	1,500 700	20
6	3/16	.1900-32 UNJF-3B	.307 .303	.360	.212 .208	.435 .415	.230	.245	.450	.280	.251 .244	.085	.100	2,500	1,800 800	30
8	1/4	.2500-28 UNJF-3B	.412 .408	.460	.276 .272	.525 .505	.270	.285	.540	.350	.314 .302	.090	.105	4,300	3,350 1,500	70
10	5/16	.3125-24 UNJF-3B	.518 .512	.570	.340 .334	.625 .605	.315	.330	.640	.420	.377 .365	.095	.110	6,300	4,500 2,500	125
12	3/8	.3750-24 UNJF-3B	.628 .622	.680	.403 .397	.695 .675	.355	.370	.710	.490	.439 .425	.095	.110	8,700	6,500 3,500	180
14	7/16	.4375-20 UNJF-3B	.713 .707	.780	.463 .457	.775 .755	.405	.420	.780	.560	.502 .490	.100	.115	12,100	9,000 4,725	250
16	1/2	.5000-20 UNJF-3B	.815 .809	.877	.528 .522	.845 .825	.435	.450	.860	.632	.565 .550	.100	.115	15,300	12,150 6,250	375
18	9/16	.5625-18 UNJF-3B	.915 .905	.947	.598 .592	.950 .930	.520	.535	.965	.775	.690 .675	.105	.120	19,000	15,300 7,250	TBD
20	5/8	.6250-18 UNJF-3B	.995 .985	1.040	.661 .655	1.035 1.015	.575	.590	1.050	.850	.753 .736	.105	.120	23,000	18,900 9,000	TBD
24	3/4	.7500-16 UNJF-3B	1.120 1.110	1.140	.786 .780	1.255 1.235	.755	.770	1.270	.994	.878 .861	.120	.135	30,700	27,630 13,750	TBD
28	7/8	.8750-14 UNJF-3B	1.345 1.335	1.365	.916 .911	1.475 1.455	.895	.910	1.480	1.140	1.003 .985	.125	.140	45,000	37,800 18,750	TBD
32	1	1.0000-12 UNJF-3B	1.490 1.480	1.510	1.041 1.035	1.725 1.705	1.030	1.045	1.740	1.280	1.128 1.110	.130	.145	60,900	49,500 25,000	TBD

- GENERAL NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 - Dimensions are in inches and to be met after finish and solid film lubricant.
 - Burrs from cutoff process and cutting torque-off groove allowed.
 - These are reference torque-off values only and shall not be used for acceptance or rejection of collars.
 - 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.
 - Locking torque, breakaway and preload are tested on epoxy chromate plate using preload releasing fixture.

MATERIAL: Collar - 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.

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 Hi-Shear Spec. 305, and white identification.
HST1571HK() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Collar & Washer 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

			TITLE	DRAWING NO.
			HI-LITE™ COLLAR	HST1571
			TITANIUM ALLOY	
			1/16 GRIP VARIATION, SHEAR APPLICATION	
			FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS	
DATE	BY			
DRAWN 1994-01-06	J.F.OBISPO			
APPROVED 1994-01-06	J.G.WILCOX			
(16) REVISION 2021-06-14	B. CHAN			