



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	2,300	1960 1150	30
6	3/16	.1900-32 UNJF-3B	.307 .303	.360	.212 .208	.435 .415	.230	.245	.450	.280	.251 .244	.085	.100	2,750	2575 1375	40
8	1/4	.2500-28 UNJF-3B	.412 .408	.440	.276 .272	.525 .505	.270	.285	.540	.350	.314 .302	.090	.105	5,000	4500 2500	90
10	5/16	.3125-24 UNJF-3B	.518 .512	.550	.340 .334	.625 .605	.315	.330	.640	.420	.377 .365	.095	.110	8,300	7500 4150	175
12	3/8	.3750-24 UNJF-3B	.628 .622	.660	.403 .397	.695 .675	.355	.370	.710	.490	.439 .425	.095	.110	12,700	11400 6350	300
14	7/16	.4375-20 UNJF-3B	.713 .707	.775	.463 .457	.775 .755	.405	.420	.780	.560	.502 .490	.100	.115	19,000	17000 9500	440
16	1/2	.5000-20 UNJF-3B	.815 .809	.895	.528 .522	.845 .825	.435	.450	.860	.632	.565 .550	.100	.115	25,500	23050 12750	720
18	9/16	.5625-18 UNJF-3B	.915 .905	.947	.598 .592	.950 .930	.520	.535	.965	.775	.690 .675	.105	.120	29,000	26100 14500	820
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	32,000	28800 16000	900
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	42,000	37800 21000	1425
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	62,000	55800 31000	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	84,000	75600 42000	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 lubricant.
  - Locking torque, breakaway and preload are tested on epoxy chromate plate using preload releasing fixture.
- MATERIAL:** Collar - 3Al-2.5V titanium per AMS6940 (AMS-T-9047) for -5 through -10 sizes.  
6Al-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.

**FINISH:** Collar HST1572ZA( ) = Anodize per Hi-Shear Ti-Shield III and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color blue identification band on barrel of collar plus cetyl alcohol lube per Hi-Shear Spec. 305, and white identification on hex portion of collar.  
HST1572HK( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Collar & Washer HST1572ZAWT( ) = Collar finish same as HST1572ZA( ). Washer finish per Hi-Shear Spec. 306, Type I, color brown, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HST1572HKWT( ) = Collar finish same as HST1572HK( ). Washer finish per Hi-Shear Spec. 306, Type I, color brown, and cetyl alcohol lube per Hi-Shear Spec. 305.

**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.

**EXAMPLE:** HST1572ZA8 = .2500-28 HI-LITE™ collar.  
HST1572ZAWT8 = .2500-28 HI-LITE™ collar with washer.

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	DATE	BY	TITLE	DRAWING NO.
DRAWN	1994-05-05	J.F.OBISPO	<b>HI-LITE™ COLLAR</b>	<b>HST1572</b>
APPROVED	1994-05-09	J.G.WILCOX	TITANIUM ALLOY	
			1/16 GRIP VARIATION, TENSION APPLICATION	
			FOR USE ON STANDARD AND 1/64 OVERSIZE	
			HI-LITE™ PINS	
(10) REVISION	2021-06-14	B. CHAN		1 OF 1