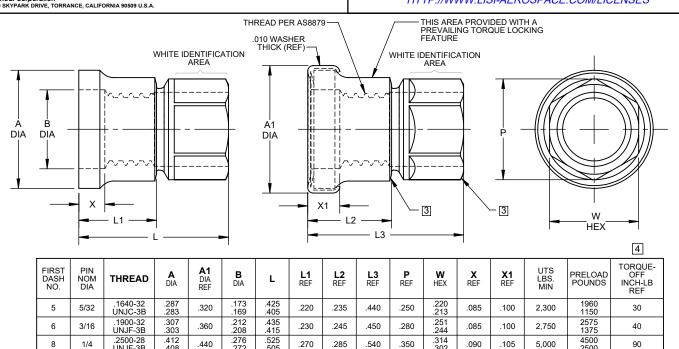
For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at: HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



		UNJF-3D	.400		.212	.505					.302				2500	
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	17
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	30
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	44
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	72
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	82
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	90
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	14
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	TE
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	TE

GENERAL NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.

(1) 2. Dimensions are in inches and to be met after finish and solid film lubricant.

3 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.

1 5. 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.
- 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. 6 Loc Collar MATERIAL:

10 Washer - WT - Commercially pure titanium per ASTM B 265, ASTM B 348. Minimum yield 25 KSI.

= 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 HST1572ZA() FINISH: Collar

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 &

AEROSPACE

Washer (1) 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.

(1) HST1572HKWT() = Collar finish same as HST1572HK(). Washer finish per Hi-Shear Spec. 306, Type I, color brown, and cetyl alcohol lube pre 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: = .2500-28 HI-LITE™ collar.

HST1572ZAWT8 = .2500-28 HI-LITE™ collar with washer.

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

	DATE	BY
DRAWN	1994-05-05	J.F.OBISPO
APPROVED	1994-05-09	J.G.WILCOX
10 REVISION	2021-06-14	B. CHAN

TITLE HI-LITE™ COLLAR

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

DRAWING NO.

HST1572