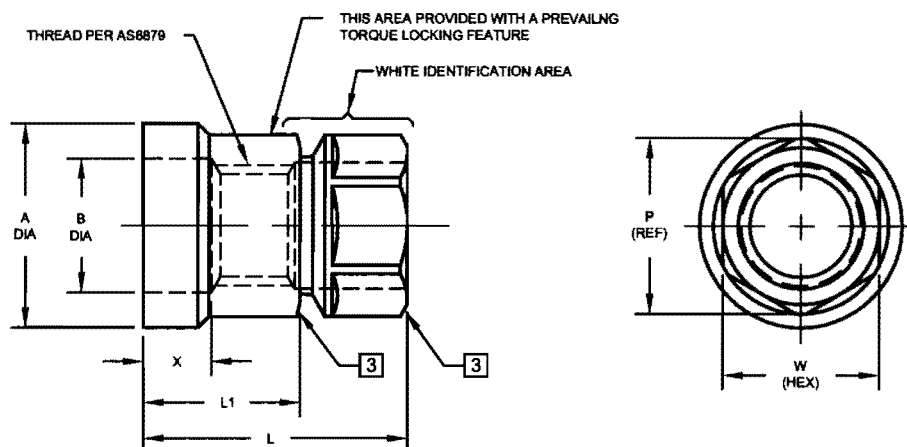




DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	PRELOAD POUNDS	TORQUE-OFF INCH-LB. (REF)
5			NOTE: USE HST1572-6									
6	7/32	10-32UNJF-3B	.355 .345	.227 .223	.435 .415	.240	.280	.251 .244	.095	2,750	2575 1375	40
8	9/32	1/4-28UNJF-3B	.440 .430	.290 .286	.525 .505	.280	.350	.314 .302	.100	5,000	4500 2500	90
10	11/32	5/16-24UNJF-3B	.580 .570	.353 .347	.625 .605	.325	.420	.377 .365	.105	8,300	7500 4150	175
12	13/32	3/8-24UNJF-3B	.685 .675	.416 .410	.695 .675	.365	.490	.439 .425	.105	12,700	11400 6350	300
14	15/32	7/16-20UNJF-3B	.775 .765	.481 .475	.775 .755	.415	.624	.565 .550	.110	19,000	17000 9500	440
16	17/32	1/2-20UNJF-3B	.880 .870	.543 .537	.845 .825	.445	.775	.690 .675	.110	25,500	23050 12750	720
18	19/32	9/16-18UNJF-3B	.925 .915	.613 .607	.950 .930	.530	.840	.753 .736	.115	29,000	26100 14500	820
20	21/32	5/8-18UNJF-3B	1.000 .990	.678 .672	1.035 1.015	.585	.970	.878 .861	.115	32,000	28800 16000	900
24	25/32	3/4-16UNJF-3B	1.185 1.175	.803 .797	1.255 1.235	.765	1.045	.941 .924	.130	42,000	37800 21000	1425

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 - Dimensions apply after finish.
 - 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 tension head titanium Hi-Lite ST pins with Hi-Kote1 and cetyl alcohol lubricant.
 - Locking torque, breakaway and preload are tested on epoxy chromate plate using preload releasing fixture.
 - Material: 3AL-2.5V titanium to be used on dash -5 through -10 and 6AL-4V titanium to be used on dash -12 and larger sizes.

MATERIAL: Collar - 3AL-2.5V titanium per AMS4943 (MIL-T-9047).
① - 6AL-4V titanium alloy per AMS4928 or AMS4967.

FINISH: Collar HST1772ZA() = Pretreat per Hi-Shear Ti-Shield III and Hi-Kote 2 solid film lube per Hi-Shear spec 292, plus cetyl alcohol lube per Hi-Shear Spec 305, with color blue identification on barrel, and white identification.

SPECIFICATION: Hi-Lite product specification No. 381, except note [6], material and preload as noted and test bolt is TB32VAP.

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

EXAMPLE: HST1772ZA8 = 1/4-28 Hi-Lite ST collar.

U.S. Patents 4,326,825; 4,485,510 and 4,957,401.
Other U.S. and foreign patents pending.
"Hi-Lite" and "HST" are registered trademarks and
"Hi-Lite ST" is a trademark of Hi-Shear Corporation.

DATE	BY	TITLE	DRAWING NO.
DRAWN 09-07-94	j.f.obispo	HI-LITE® ST™ COLLAR	HST1772
APPROVED 9-7-94	J.G. Wilcox	TITANIUM ALLOY 1/16 GRIP VARIATION, TENSION APPLICATION FOR USE ON 1/32" OVERSIZE HI-LITE ST PINS	
① REVISION 8-23-2011	jo		