

DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	D DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER. RAD	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.365 .355	.095 .085	.255	.171	.385	.220	.370 .350	.344	.20	.314 .302	.095	1,940	15-30
6	3/16	.1900-32 UNJF-3B	.365 .355	.095 .085	.255	.198	.395	.230	.370 .350	.380	.20	.346 .332	.095	2,500	25-40
8	1/4	.2500-28 UNJF-3B	.475 .465	.120 .110	.333	.259	.465	.270	.435 .415	.484	.26	.440 .425	.100	4,300	60-90
10	5/16	.3125-24 UNJF-3B	.620 .610	.130 .120	.417	.322	.545	.315	.500 .480	.484	.34	.440 .425	.105	6,300	110-160
12	3/8	.3750-24 UNJF-3B	.685 .675	.145 .135	.490	.385	.615	.355	.560 .540	.557	.38	.503 .488	.105	8,700	160-220

**GENERAL NOTES:**

1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. For use on sloped surfaces up to 7° maximum.
3. Dimensions are in inches and apply after finish and before application of lubricants.
4. Use TB64VF( )L for thread lock inspection.
5. Cetyl Alcohol lube per Hi-Shear Spec. 305 may be applied, at manufacturer's option to meet procurement specification requirements.

**MATERIAL:** Collar A-286 high temperature alloy per AMS5731 or AMS5734.  
 Washer A-286 high temperature alloy per AMS5731 or AMS5737.

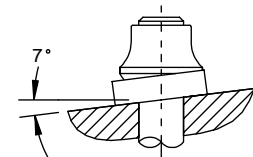
**HEAT TREAT:** Collar None.  
 Washer 90,000 psi shear minimum.

**FINISH:** [5] Collar HST185DU( )A = Collar with solid film lube per AS5272, Type I.  
 Collar HST185HKA( )A = Collar with HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 Washer HST185-( )CU = Washer with passivate per AMS2700, Method 1, Type 8.  
 Washer HST185-( )HKB = Washer with HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 294.

**SPECIFICATION:** HI-LITE™ Product Specification 381. Test bolt requirement exception per note [4] above.

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

**EXAMPLE:** HST185DU8ACU = Assembly of HST185DU-8A collar and HST185-8CU washer.  
 HST185HKA8AHKB = Assembly of HST185HKA-8A collar and HST185-8HKB washer.



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	DATE	BY	TITLE <b>HI-LITE™ COLLAR</b> SELF-ALIGNING COLLAR ASSEMBLY A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, SHEAR APPLICATION	DRAWING NO.
DRAWN	1989-06-10	D.P.S.		<b>HST185</b>
APPROVED	1989-06-10	J.G. WILCOX		
8 REVISION	2023-05-10	C. Artos		