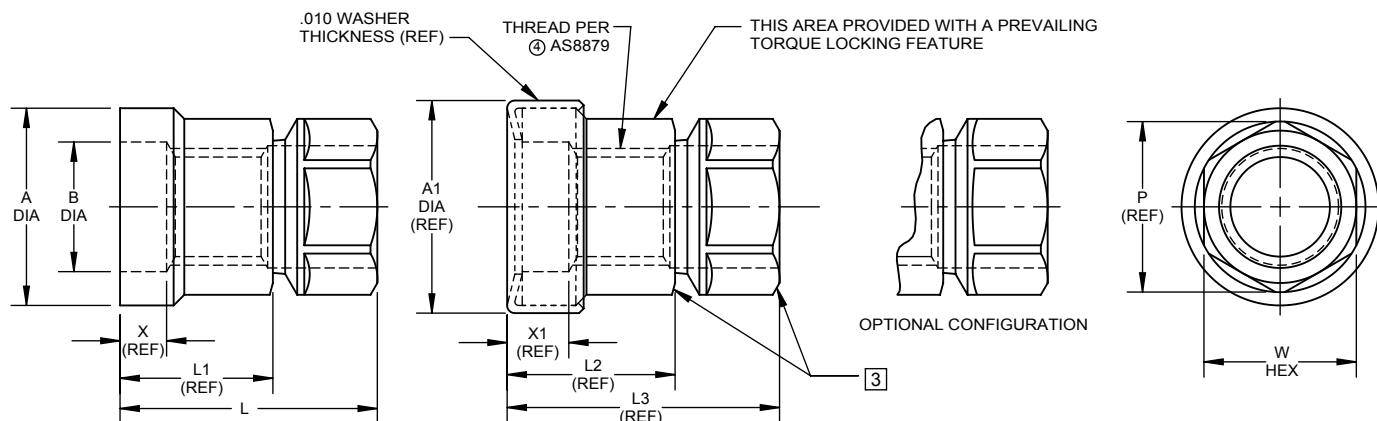


④



④

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 MIN	X1 MIN	UTS LBS. MIN	TORQUE-OFF IN. - LBS.
5	5/32	.1640-32 UNJC-3B	.287 .283	.320	.173 .169	.445 .425	.250	.265	.460	.250	.220 .213	.113	.128	1,400	15-25
6	3/16	.1900-32 UNJF-3B	.307 .303	.340	.212 .208	.465 .445	.260	.275	.480	.280	.251 .244	.113	.128	1,600	25-35
8	1/4	.2500-28 UNJF-3B	.412 .408	.440	.276 .272	.555 .535	.300	.315	.570	.350	.314 .302	.117	.132	3,000	60-80
10	5/16	.3125-24 UNJF-3B	.518 .512	.550	.340 .334	.655 .635	.350	.360	.670	.420	.377 .365	.119	.134	5,000	110-140
12	3/8	.3750-24 UNJF-3B	.628 .622	.660	.403 .397	.725 .705	.390	.400	.740	.490	.439 .425	.121	.136	7,000	160-200

NOTES:

1. Go thread gage penetration shall be 3/4 of one revolution minimum.
- ④ 2. Dimensions are in inches and apply after finish.
- ③ 3. Burrs from cutoff process and cutting torque-off groove allowed.

MATERIAL:

- ④ Collar - 7050 aluminum alloy per AMS4340 or 7075 aluminum alloy per AMS-QQ-A-225/9
- ④ Washer - Commercial pure titanium per AMS-T-9046, CP-4 composition.

HEAT TREAT:

- ④ Collar - Age to T73 condition per AMS2770.
- Washer - None.

FINISH:

- Collar - HST690CK-() = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST690CY-() = Anodize per MIL-A-8625, dye color orange, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ④ HST690LP-() = Anodize per MIL-A-8625, dye color natural, and solid film lube per AS5272, Type I.
- Collar & Washer - HST690LPWT-() = Collar finish same as HST690LP. Washer finish per Hi-Shear Spec. 306, Type 1, color brown, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

HI-LITE™ Product Specification 381.

CODE:

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

EXAMPLE:

HST690CY-8 = 1/4-28 HI-LITE™ collar with dye color orange and cetyl alcohol lube.
HST690LPWT-8 = 1/4-28 HI-LITE™ collar, anodize and solid film lube, with washer.

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

DATE	BY	TITLE	DRAWING NO.
1986-11-05	D.P.S.	HI-LITE™ COLLAR	HST690
1986-11-05	P.WONG	7075 ALUMINUM ALLOY	
1986-11-05	P.WONG	3/32 GRIP VARIATION - SHEAR APPLICATION	
1986-11-05	P.WONG	FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE™ PINS	
2017-12-18	F.CARINGELLA		1 of 1