lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company
Design Holder
CAGE No. 73197

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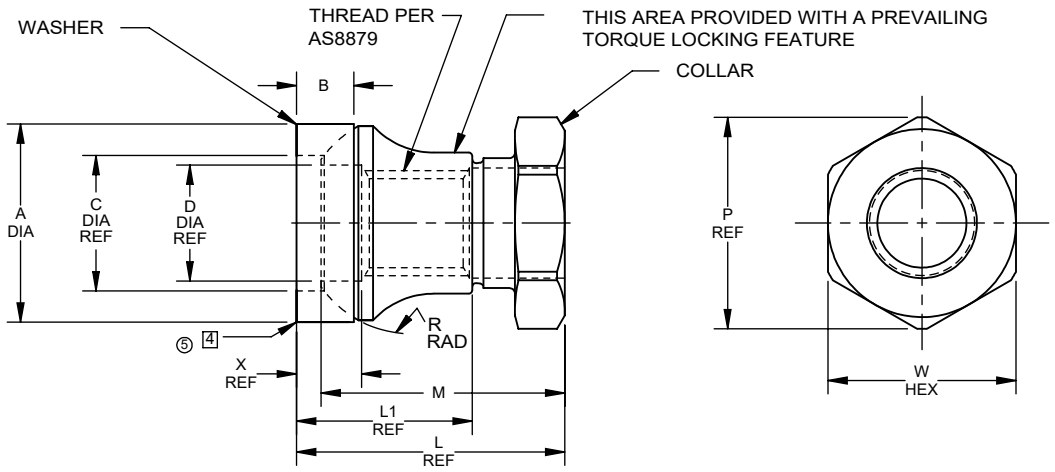


DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	D DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER. RAD (REF)	W HEX	X (MAX)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.365 .355	.095 .085	.255	.171	.385	.220	.370 .350	.380	.20	.346 .332	.095	2,300	30-40
6	3/16	.1900-32 UNJF-3B	.365 .355	.095 .085	.255	.198	.395	.230	.370 .350	.380	.20	.346 .332	.095	2,750	40-50
8	1/4	.2500-28 UNJF-3B	.475 .465	.120 .110	.333	.259	.465	.270	.435 .415	.484	.26	.440 .425	.100	5,000	115-130
10	5/16	.3125-24 UNJF-3B	.620 .610	.130 .120	.417	.322	.545	.315	.500 .480	.484	.34	.440 .425	.105	8,300	200-250
12	3/8	.3750-24 UNJF-3B	.790 .780	.145 .135	.490	.385	.615	.355	.560 .540	.557	.38	.503 .488	.105	12,700	360-440
14	7/16	.4375-20 UNJF-3B	.895 .885	.180 .170	.570	.447	.695	.405	.625 .605	.840	.45	.753 .736	.110	19,000	550-625
16	1/2	.5000-20 UNJF-3B	1.005 .995	.205 .195	.648	.510	.755	.435	.680 .660	.970	.51	.878 .861	.110	25,000	725-825

GENERAL NOTES:

1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. Dimensions are in inches and apply after finish and before application of lubricants.
3. For used on sloped surfaces up to 7° maximum on HI-LITE™ tension head pins.

4 For -12, -14, and -16 washers, chamfer or radius .040-.050.

5 Cetyl alcohol lube per Hi-Shear Spec. 305 may be applied, at manufacturer's option to meet procurement specification requirements.

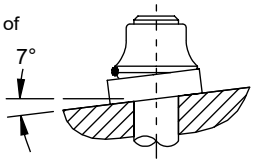
⑤ 6 Use the following test bolts for thread lock inspection:
TB64AP( )L for HST75TP( )A and HST75HK( )A
TB64VF( )L for HST75DU( )A.
TB8740PB( )L for HST75-( )A, HST75PB( )A, and HST75TF( )A

7. Hardness and UTS requirement in ASTM A582/A582M and/or AMS5640 are not applicable to the raw material. Raw material can be supplied in cold worked condition in order to meet the product UTS requirement

MATERIAL: Collar 303 Se stainless steel per ASTM A582/A582M and AMS5640.
Washer 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

HEAT TREAT: Collar None.
⑤ Washer Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per AMS2759

FINISH: Collar HST75-( )A = Cadmium plate per AMS-QQ-P-416, Type I, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
5 HST75DU( )A = Solid film lube per AS5272, Type I.
HST75PB( )A = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
5 HST75TF( )A = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
HST75TP( )A = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, color orange on body of collar, and cetyl alcohol lube per Hi-Shear Spec. 305.
⑤ 5 HST75HK( )A = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
Washer HST75-( )DW = Solid film lube per AS5272, Type I.
HST75-( )PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
HST75( )W = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.
HST75-( )WU = Passivate per AMS2700, Method 1, Type 8, Class 1



SPECIFICATION: HI-LITE™ Product Specification 381. Test bolt requirement exceptions per note 6 above.

CODE: Dash number indicates nominal thread size in 1/32nds.
Code letter "A" following dash number indicates HI-LITE™ collar.
See "Finish" note for explanation of other code letters.

EXAMPLE: HST75-8AW = Assembly of HST75-8A collar and HST75-8W washer.
HST75TF8AWU = Assembly of HST75TF8A collar and HST75-8WU washer.

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

	DATE	BY
DRAWN	1983-12-23	D.P.S.
APPROVED	1983-12-23	R.TING
5 REVISION	2026-05-12	C.ARTOS

TITLE
HI-LITE™ COLLAR
SELF-ALIGNING COLLAR ASSEMBLY
(303 SE STAINLESS STEEL COLLAR, STAINLESS STEEL WASHER)
1/16 GRIP VARIATION, TENSION APPLICATION

DRAWING NO.
HST75

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