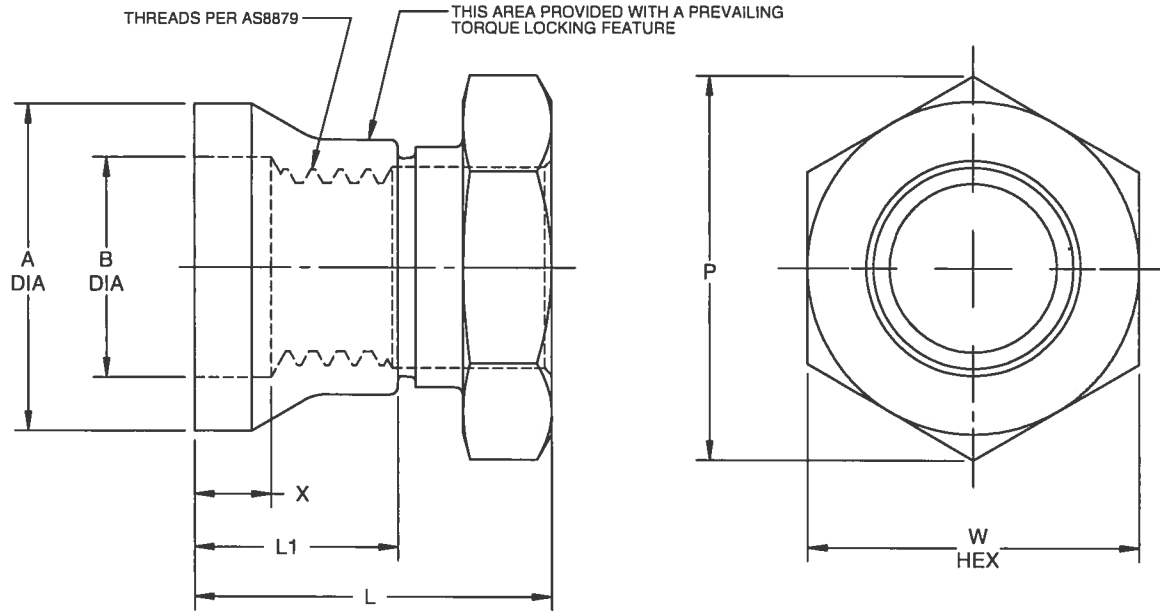


Hi-Shear Corporation, U.S.A. a LISI AEROSPACE Company	Design Holder	CAGE No. 73197	Air Industries CO. USA	Licensee (USA, Canada)	CAGE No. 08725
BLANC AERO INDUSTRIES SA, France a LISI AEROSPACE Company	Licensee	CAGE No. F0188-C	SPS TECHNOLOGIES USA	Licensee	CAGE No. 56878
LISI AEROSPACE CANADA, Canada a LISI AEROSPACE Company	Licensee	CAGE No. L4528	MINEBEA, Japan	Licensee (Japan)	CAGE No. SB952
ANKIT FASTENERS Ltd. India	Licensee (India)	CAGE No. SEM10	AFS St-Cosmes France	Licensee	CAGE No. F0224



FIRST DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 REF	P REF	W HEX	X REF	UTS LBS. MIN	TORQUE-OFF IN-LBS
5											
NOTE: USE HST79()6											
6	13/64 7/32	.1900-32 UNJF-3B	.355 .345	.227 .223	.415 .395	.240	.380	.346 .332	.095	1,600	25-35
8	17/64 9/32	.2500-28 UNJF-3B	.440 .430	.290 .286	.485 .465	.280	.484	.440 .425	.100	3,000	60-80
10	21/64 11/32	.3125-24 UNJF-3B	.535 .525	.353 .347	.565 .545	.325	.484	.440 .425	.105	5,000	110-140
12	25/64 13/32	.3750-24 UNJF-3B	.635 .625	.416 .410	.635 .615	.365	.557	.503 .488	.105	7,000	160-200
14	29/64 15/32	.4375-20 UNJF-3B	.735 .725	.481 .475	.715 .695	.415	.624	.565 .550	.110	9,500	220-280
16	33/64 17/32	.5000-20 UNJF-3B	.850 .840	.543 .537	.775 .755	.445	.763	.690 .675	.110	12,500	340-410

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

③ **MATERIAL:** 7075 aluminum alloy per AMS-QQ-A-225/9.

③ **HEAT TREAT:** Age to T73 condition per AMS2770.

③ **FINISH:** HST84CK() = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST84CY() = Anodize per MIL-A-8625, dye color orange, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 381.

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

EXAMPLE: HST84CK8 = .2500-28 HI-LITE™ collar, anodized color black and cetyl alcohol lube.

*HI-LITE™ and *HST™ are international registered trademarks of Hi-Shear Corporation

	DATE	BY	TITLE	DRAWING NO.
	12-2-83	D.P.S.	HI-LITE™ COLLAR	HST84
DRAWN	12-2-83	D.P.S.	7075-T73 ALUMINUM ALLOY	
APPROVED	12-9-83	E.E.B.	SHEAR APPLICATION, 1/16 GRIP VARIATION	
③ REVISION	6-27-2016	J.F.Obispo	FOR USE ON 1/64 AND 1/32 OVERSIZE HI-LITE™ PINS	