



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	A <sub>1</sub> DIA. (REF.)	B DIA.	L	L <sub>1</sub> (REF.)	L <sub>2</sub> (REF.)	L <sub>3</sub> (REF.)	P (REF.)	W HEX.	X (REF.)	X <sub>1</sub> (REF.)	UTS LBS. MIN.	TORQUE OFF IN.-LBS.
5	5/32	8-32UNJC-3B	.287 .283	.320	.173 .169	.425 .405	.220	.235	.440	.250	.220 .213	.085	.100	2,300	35 25
6	3/16	10-32UNJF-3B	.307 .303	.340	.212 .208	.435 .415	.230	.245	.450	.280	.251 .244	.085	.100	2,750	45 35
8	1/4	1/4-28UNJF-3B	.412 .408	.440	.276 .272	.525 .505	.270	.285	.540	.350	.314 .302	.090	.105	5,000	95 80
10	5/16	5/16-24UNJF-3B	.518 .512	.550	.340 .334	.625 .605	.315	.330	.640	.420	.377 .365	.095	.110	8,300	200 150
12	3/8	3/8-24UNJF-3B	.628 .622	.660	.403 .397	.695 .675	.355	.370	.710	.490	.439 .425	.095	.110	12,700	330 270

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

**MATERIAL:** Collar - 6Al-4V titanium alloy per AMS4928, AMS4930 or AMS4967, or 3Al-2.5V titanium alloy per AMS4943 (MIL-T-9047).  
 Washer - Commercial pure titanium per MIL-T-9046, CP-4 composition.

**FINISH:** Collar - HST1072TA-( ) = 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.  
 Collar & Washer - HST1072TAWT-( ) = Collar finish same as HST1072TA.  
 Washer finish per Hi-Shear Spec. 306, Type I, 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.

**EXAMPLES:** HST1072TA-8 = 1/4-28 Hi-Lite ST collar.  
 HST1072TAWT-8 = 1/4-28 Hi-Lite ST collar with washer.

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

			TITLE	DRAWING NUMBER
DRAWN	DATE	BY	<b>HI-LITE® ST™ COLLAR</b> © 6AL-4V OR 3AL-2.5V TITANIUM ALLOY 1/16 GRIP VARIATION, TENSION APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LITE ST PINS	<b>HST1072</b>
	4-7-87	D.P.S.		
APPROVED	4-7-87	N. Poto		
② REVISION	12-15-94	J.F.Obispo		