

DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B	C DIA. (REF.)	D DIA. (REF.)	L (REF.)	L ₁ (REF.)	M	P (REF.)	R SPHER. RAD.	W HEX.	X (MAX.)	UTS LBS. MIN.	TORQUE-OFF IN.-LBS.
-5	5/32	8-32UNJC-3B	.365 .355	.095 .085	.255	.171	.415	.220	.400 .380	.250	.20	.220 .213	.095	2,300	15-30
-6	3/16	10-32UNJF-3B	.365 .355	.095 .085	.255	.198	.425	.230	.400 .380	.280	.20	.251 .244	.095	2,750	25-40
-8	1/4	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.259	.515	.270	.485 .465	.350	.26	.314 .302	.100	5,000	60-90
-10	5/16	5/16-24UNJF-3B	.620 .610	.130 .120	.417	.322	.615	.315	.570 .550	.420	.34	.377 .365	.105	8,300	110-160
-12	3/8	3/8-24UNJF-3B	.685 .675	.145 .135	.490	.395	.685	.355	.630 .610	.490	.38	.439 .425	.105	12,700	160-220
-14	7/16	7/16-20UNJF-3B	.905 .795	.180 .170	.570	.447	.765	.405	.695 .675	.557	.45	.503 .490	.110	19,000	220-300
-16	1/2	1/2-20UNJF-3B	.915 .905	.205 .195	.648	.510	.835	.435	.760 .740	.624	.51	.565 .550	.110	25,500	340-430
-18	9/16	9/16-18UNJF-3B	1.125 1.115	.270 .260	.763	.575	.940	.520	.845 .825	.775	.71	.690 .675	.115	29,000	525-625
-20	5/8	5/8-18UNJF-3B	1.125 1.115	.315 .305	.820	.644	1.025	.575	.930 .910	.850	.76	.753 .736	.115	32,000	650-750

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. For use on sloped surfaces up to 7° maximum on Hi-Lite ST tension head pins.
3. Dimensions apply after finish.
4. For -12, -14, and -16 washers, chamfer or radius .040-.050.

① MATERIAL: Collar - S30430 (302 HQ) stainless steel per Spec. ASTM A193, Type XM-7, 305 stainless steel per QQ-S-763 and AMS5686; or 303 Se stainless steel per ASTM A582 and AMS5640.
Washer - "C" = A-286 high temperature alloy per AMS5731 or AMS5737.
"W" = 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

① HEAT TREAT: Collar - None.
Washer - "C" = 90,000 psi shear minimum.
"W" = Age to H1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and 15-7Mo per MIL-H-6875.

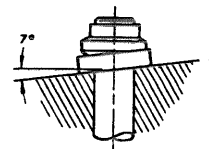
① FINISH: Collar - HST1076-()A = Cadmium plate per QQ-P-416, Type I, Class 2, with cetyl alcohol lube per Hi-Shear Spec. 305.
HST1076DU-()A = Solid film lube per MIL-L-8937 plus orange identification on body of collar per MIL-P-23377.
HST1076PB-()A = Cadmium plate per QQ-P-416, Type II, Class 2, with cetyl alcohol lube per Hi-Shear Spec. 305.
HST1076TF-()A = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
Washer - HST1076-()CU = Passivate per Hi-Shear Spec. 258.
HST1076-()DW = Solid film lube per MIL-L-8937.
HST1076-()PBW = Cadmium plate per QQ-P-416, Type II, Class 2.
HST1076-()JW = Cadmium plate per QQ-P-416, Type I, Class 2.
HST1076-()WU = Passivate per Hi-Shear Spec. 258.

SPECIFICATION: Hi-Lite Product Specification 381.

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

① EXAMPLES: HST1076TF-8ACU = Assembly of HST1076TF-8A collar and HST1076-8CU washer.
HST1076-8AW = Assembly of HST1076-8A collar and HST1076-8W washer.
HST1076TF-8AWU = Assembly of HST1076TF-8A collar and HST1076-8WU washer.

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



DATE	BY	TITLE	DRAWING NUMBER
DRAWN 2-19-86	D. P. S.	HI-LITE®ST™ COLLAR SELF-ALIGNING COLLAR ASSEMBLY (STAINLESS STEEL COLLAR - STAINLESS STEEL WASHER) 1/16" GRIP VARIATION - SHEAR APPLICATION	HST1076
APPROVED 2-19-86	J. [Signature]		
① REVISION 5-4-88	D. P. S.		