



DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.287 .283	.173 .169	.435 .405	.230	.248	.221 .213	.085	2,300	30-40
6	3/16	10-32UNJF-3B	.307 .303	.212 .208	.445 .415	.240	.280	.255 .235	.085	2,750	40-50
8	1/4	1/4-28UNJF-3B	.412 .408	.276 .272	.525 .505	.270	.344	.314 .302	.090	5,000	110-130
10	5/16	5/16-24UNJF-3B	.518 .512	.340 .334	.625 .605	.323	.414	.378 .365	.095	8,300	200-250
12	3/8	3/8-24UNJF-3B	.628 .622	.403 .397	.705 .675	.363	.484	.440 .425	.095	12,700	360-420
14	7/16	7/16-20UNJF-3B	.733 .727	.468 .462	.790 .770	.420	.557	.503 .488	.100	19,000	525-600
16	1/2	1/2-20UNJF-3B	.848 .842	.533 .527	.870 .850	.458	.624	.565 .550	.100	25,500	725-825
18	9/16	9/16-18UNJF-3B	.915 .905	.603 .597	.950 .930	.520	.775	.690 .675	.105	29,000	1000-1150
20	5/8	5/8-18UNJF-3B	.995 .985	.661 .655	1.035 1.015	.575	.850	.753 .736	.105	32,000	1350-1550

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

**MATERIAL:** A-286 high temperature alloy per AMS5731.

- FINISH:**
- Collar HST1078(-) = Silver plate per AMS2410 (.0002-.0004 thick) and cetyl alcohol lube per Hi-Shear Spec 305.
  - HST1078DK(-) = Kalgard FA solid film lube with special cure for vacuum compatibility.
  - HST1078DU(-) = Solid film lube per AS5272, Type I.
  - HST1078TB(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST1078PB(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST1078TF(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
  - HST1078UK(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, green identification on body of collar 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:** HST1078-8 = 1/4-28 Hi-Lite ST collar with silver plate and cetyl alcohol.

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

			TITLE	DRAWING NO.
			<b>HI-LITE® ST™ COLLAR</b>	<b>HST1078</b>
			A-286 HIGH TEMPERATURE ALLOY	
			1/16" GRIP VARIATION	
			TENSION APPLICATION	
			FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LITE PINS	
DATE	BY			
DRAWN 3-21-83	D.P.S.			
APPROVED 3-21-83	R. Ting			
14 REVISION 11-26-08	A.B.			