

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.		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 .390	.250	.20		.220 .213	.095	1,400	15-30
-6	3/16	10-32UNJF-3B	.365 .355	.095 .085	.255	.198	.425	.230	.400 .390	.290	.20		.251 .244	.095	1,600	25-40
-8	1/4	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.259	.515	.270	.485 .465	.350	.26		.314 .302	.100	3,000	60-90
-10	5/16	5/16-24UNJF-3B	.620 .610	.130 .120	.417	.322	.615	.315	.570 .550	.420	.34		.377 .365	.105	5,000	110-160
-12	3/8	3/8-24UNJF-3B	.685 .675	.145 .135	.490	.385	.685	.355	.630 .610	.490	.38		.439 .425	.105	7,000	160-220
-14	7/16	7/16-20UNJF-3B	.805 .795	.180 .170	.570	.447	.765	.405	.695 .675	.567	.45		.502 .490	.110	9,300	220-300
-16	1/2	1/2-20UNJF-3B	.915 .905	.205 .195	.648	.510	.835	.435	.760 .740	.624	.51		.585 .550	.110	12,500	340-430

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. Dimensions apply after finish.
3. For use on sloped surfaces up to 7° maximum on Hi-Lite ST pins.

MATERIAL: Collar — 7075 aluminum alloy per QQ-A-225/9.
Washer — 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

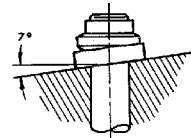
HEAT TREAT: Collar — Age to T73 condition per MIL-H-6088.
Washer — Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and 15-7Mo per MIL-H-6875.

FINISH: Collar — HST1082CK-()A = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST1082CY-()A = Anodize per MIL-A-8625, dye color orange, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST1082D-()A = Anodize per MIL-A-8625, color natural, and solid film lube per MIL-L-8937.
Washer — HST1082-()DW = Solid film lube per MIL-L-8937.
HST1082-()W = Cadmium plate per QQ-P-416, Type I, Class 2.
HST1082-()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.
Code letter "W" following dash number indicates self-aligning washer.
See "Finish" note for explanation of code letters.

EXAMPLE: HST1082CY-8AW = Assembly of HST1082CY-8A collar and HST1082-8W washer.
HST1082D-8AWU = Assembly of HST1082D-8A collar and HST1082-8WU washer.
HST1082D-8ADW = Assembly of HST1082D-8A collar and HST1082-8DW washer.



U.S. Patents 4,326, 825 and 4,495, 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.

			TITLE	DRAWING NUMBER
DRAWN	12-18-85	D. P. S.	HI-LITE[®] ST[™] COLLAR SELF-ALIGNING COLLAR ASSEMBLY (ALUMINUM COLLAR — STAINLESS STEEL WASHER) 1/16" GRIP VARIATION — SHEAR APPLICATION	HST1082
APPROVED	1-8-86	J. Rowell		
REVISION	1-23-86	D. P. S.		
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