

DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B DIA.	C DIA. (REF.)	D DIA. (REF.)	L (REF.)	L <sub>1</sub> (REF.)	M	P (REF.)	R SPHER. RAD.	W HEX.	X (MAX.)	UTS LBS. MIN.	TORQUE-OFF INCH-LB.
5	5/32	8-32UNJC-3B	.365 .355	.095 .085	.255	.171	.415	.220	.400 .380	.250	.20	.220 .213	.095	2,300	30 15
6	3/16	10-32UNJF-3B	.365 .355	.095 .085	.255	.198	.425	.230	.400 .380	.280	.20	.251 .244	.095	2,750	40 25
8	1/4	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.259	.515	.270	.485 .465	.350	.26	.314 .302	.100	5,000	90 60
10	5/16	5/16-24UNJF-3B	.620 .610	.130 .120	.417	.322	.615	.315	.570 .550	.420	.34	.377 .365	.105	8,300	160 110
12	3/8	3/8-24UNJF-3B	.790 .780	.145 .135	.490	.385	.685	.355	.630 .610	.490	.38	.439 .425	.105	12,700	220 160
14	7/16	7/16-20UNJF-3B	.895 .885	.180 .170	.570	.447	.765	.405	.695 .675	.557	.45	.503 .490	.110	19,000	300 220
16	1/2	1/2-20UNJF-3B	1.005 .995	.205 .195	.648	.510	.835	.435	.760 .740	.624	.51	.565 .550	.110	25,500	430 340

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
  - For use on sloped surfaces up to 7° maximum on Hi-Lite ST shear head pins.
  - Dimensions apply after finish.
  - For -12, -14, and -16 washers, chamfer or radius .040-.060.

**MATERIAL:** Collar - 6Al-4V titanium alloy per AMS4928, AMS4930 or AMS4967, or 3Al-2.5V titanium alloy per AMS4943 (MIL-T-9047).  
Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

**HEAT TREAT:** Collar - None.  
Washer - Age to H1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and PH15-7Mo per MIL-H-6875.

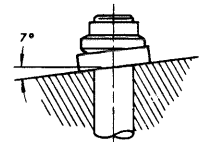
**FINISH:** Collar - HST1096TA-( )A = Pretreat per Hi-Shear Ti-Shield III, and Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, with color orange identification on barrel, plus cetyl alcohol lube per Hi-Shear Spec. 305.  
Washer - HST1096-( )DW = Solid film lube per MIL-L-46010, Type I.  
HST1096-( )TFW = Passivate per Hi-Shear Spec. 258, and Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.  
⑤ HST1096-( )WU = Passivated 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.

**EXAMPLE:** HST1096TA-8ATFW = Assembly of HST1096TA-8A collar and HST1096-8TFW 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.



	DATE	BY	TITLE	DRAWING NUMBER
DRAWN	10-10-85	D.P.S.	<b>HI-LITE® ST™ COLLAR</b> SELF-ALIGNING COLLAR ASSEMBLY 6AL-4V OR 3AL-2.5V TITANIUM ALLOY COLLAR, STAINLESS STEEL WASHER 1/16" GRIP VARIATION, SHEAR APPLICATION	<b>HST1096</b>
APPROVED	10-10-85	J.Rausch		
⑤ REVISION	08-28-95	J.F.Obispo		