

DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B	C DIA. (REF.)	D DIA. (REF.)	L (REF.)	L <sub>1</sub> (REF.)	M	P (REF.)	R SPHER. RAD.	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE-OFF IN.-LBS.
-5	5/32	8-32UNJC-3B	NOTE: USE HST1076-6												
-6	3/16	10-32UNJF-3B	.395 .385	.088 .078	.285	.225	.435	.240	.410 .390	.280	.24	.251 .244	.095	2,750	25-40
-8	1/4	1/4-28UNJF-3B	.515 .505	.123 .113	.365	.288	.525	.280	.495 .475	.350	.30	.314 .302	.100	5,000	60-90
-10	5/16	5/16-24UNJF-3B	.660 .650	.160 .150	.450	.348	.625	.325	.580 .560	.420	.38	.377 .365	.105	8,300	110-160
-12	3/8	3/8-24UNJF-3B	.790 .780	.180 .170	.525	.413	.695	.365	.640 .620	.490	.44	.439 .425	.105	12,700	160-220
-14	7/16	7/16-20UNJF-3B	.893 .883	.237 .227	.605	.478	.775	.415	.705 .685	.557	.50	.503 .490	.110	19,000	220-300
-16	1/2	1/2-20UNJF-3B	1.005 .995	.265 .255	.690	.540	.945	.445	.770 .750	.624	.56	.565 .550	.110	25,500	340-430

- 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.

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 - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

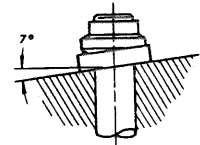
HEAT TREAT: Collar - None.  
Washer - Age to H1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and 15-7Mo per MIL-H-6875.

FINISH: Collar - HST1176-( )A = Cadmium plate per QQ-P-416, Type I, Class 2, with cetyl alcohol lube per Hi-Shear Spec. 305.  
HST1176DU-( )A = Solid film lube per MIL-L-8937 plus orange identification on body of collar per MIL-P-23377.  
HST1176PB-( )A = Cadmium plate per QQ-P-416, Type II, Class 2, with cetyl alcohol lube per Hi-Shear Spec. 305.  
HST1176TF-( )A = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.  
Washer - HST1176-( )DW = Solid film lube per MIL-L-8937.  
HST1176-( )PBW = Cadmium plate per QQ-P-416, Type II, Class 2.  
HST1176-( )W = Cadmium plate per QQ-P-416, Type I, Class 2.  
HST1176-( )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.

EXAMPLE: HST1176-8AW = Assembly of HST1176-8A collar and HST1176-8W washer.  
HST1176TF-8AWU = Assembly of HST1176TF-8A collar and HST1176-8WU 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	5-19-86	D.P.S.				<b>HI-LITE®ST™ COLLAR</b> SELF-ALIGNING COLLAR ASSEMBLY (STAINLESS STEEL COLLAR - STAINLESS STEEL WASHER) 1/16" GRIP VARIATION - SHEAR APPLICATION FOR USE ON STANDARD AND 1/32" OVERSIZE HI-LITE ST PINS	<b>HST1176</b>
APPROVED	5-20-86	<i>D. P. S.</i>					
REVISION							