



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	UTS LBS. MIN
⑩ 5	5/32	8-32UNJC-3B	.345 .335	.071 .061	.225	.184	.395	.230	.375 .355	.248	.205 .195	.223 .211	.108 .088	2,300
6	3/16	10-32UNJF-3B	.395 .385	.088 .078	.285	.225	.405	.240	.380 .360	.285	.245 .235	.252 .241	.112 .092	2,750
8	1/4	1/4-28UNJF-3B	.515 .505	.123 .113	.365	.288	.475	.280	.445 .425	.355	.310 .300	.314 .302	.116 .096	5,000
10	5/16	5/16-24UNJF-3B	.660 .650	.160 .150	.450	.348	.555	.325	.510 .490	.430	.385 .375	.378 .365	.118 .098	8,300
12	3/8	3/8-24UNJF-3B	.790 .780	.180 .170	.525	.413	.625	.365	.590 .570	.500	.445 .435	.440 .428	.120 .100	12,700
14	7/16	7/16-20UNJF-3B	.893 .883	.237 .227	.605	.478	.705	.445	.640 .620	.573	.505 .495	.503 .490	.124 .104	19,000
16	1/2	1/2-20UNJF-3B	1.005 .995	.265 .255	.690	.540	.765	.485	.675 .655	.643	.565 .555	.565 .550	.126 .106	25,500
18	9/16	9/16-18UNJF-3B	1.185 1.175	.270 .260	.807	.605	.855	.515	.800 .780	.788	.715 .705	.690 .675	.130 .110	29,000
20	5/8	5/8-18UNJF-3B	1.375 1.360	.315 .305	.872	.668	.940	.560	.870 .850	.860	.760 .750	.753 .736	.130 .110	32,000

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
  - Dimensions apply after finish.
  - Burrs from cutoff process and cutting torque-off groove allowed.
  - For use on sloped surfaces up to 7° maximum on Hi-Lite ST tension head pins.

**MATERIAL:** Collar - S30430 (302 HQ) stainless steel per ASTM A 493, Type XM-7; 305 stainless steel per AMS-QQ-S-763 and AMS5686; or 303 stainless steel per ASTM A 582 (AMS5640); or 302 stainless steel per AMS-QQ-S-763.  
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 AMS-H-6875.

**FINISH:** Collar - HST1375-( )A = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HST1375DU( )A = Solid film lube per AS5272, Type I.  
Washer - HST1375-( )WU = Passivate per Hi-Shear Spec. 258.  
HST1375-( )W = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.  
HST1375-( )PW = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.

**SPECIFICATION:** Hi-Lite Product Specification 382.

**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 collar.  
See "Finish" note for explanation of other code letters.

**EXAMPLE:** HST1375DU8AWU = Assembly of HST1375DU8A collar and HST1375-8WU washer.

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

	DATE	BY
DRAWN	6-7-83	D.P.S.
APPROVED	6-8-83	R.Ting
⑪ REVISION	1-18-06	A.B.

TITLE  
**HI-LITE® ST™ COLLAR**  
SELF-ALIGNING COLLAR ASSEMBLY  
STAINLESS STEEL  
1/16 GRIP VARIATION, SPECIAL APPLICATION  
FOR USE ON STANDARD AND 1/32" OVERSIZE HI-LITE ST PINS

DRAWING NO.  
**HST1375**