



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B DIA.	F MAX.	L	L1 (REF.)	N MAX.	P (REF.)	T MIN.	W HEX.	X	UTS LBS. MIN.	TORQUE-OFF IN.-LBS.
-5	5/32	8-32UNJF-3B	.294 .286	.173 .169	.253	.405 .385	.230	.070	.248	.090	.221 .211	.102 .092	1,400	15-25
-6	3/16	10-32UNJF-3B	.355 .345	.228 .223	.290	.415 .395	.240	.070	.285	.098	.252 .241	.102 .092	1,600	25-35
-8	1/4	1/4-28UNJF-3B	.440 .430	.288 .283	.380	.485 .465	.280	.080	.355	.098	.314 .302	.106 .096	3,000	60-80
-10	5/16	5/16-24UNJF-3B	.535 .525	.350 .345	.435	.565 .545	.325	.090	.430	.115	.378 .365	.108 .098	5,000	110-140
-12	3/8	3/8-24UNJF-3B	.635 .625	.413 .407	.505	.635 .615	.365	.090	.500	.130	.440 .428	.110 .100	7,000	160-200
-14	7/16	7/16-20UNJF-3B	.735 .725	.476 .470	.578	.715 .685	.415	.100	.573	.142	.503 .490	.114 .104	9,500	220-280
-16	1/2	1/2-20UNJF-3B	.850 .840	.538 .532	.648	.775 .755	.445	.110	.643	.165	.565 .550	.116 .106	12,500	340-410
-18	9/16	9/16-18UNJF-3B	.925 .915	.610 .602	.793	.865 .845	.505	.110	.788	.195	.690 .675	.120 .110	14,500	450-535
-20	5/8	5/8-18UNJF-3B	1.000 .990	.672 .664	.865	.950 .930	.560	.115	.860	.200	.753 .736	.120 .110	18,000	575-650

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.  
2. Dimensions apply after finish.  
3. Burrs from cutoff process and cutting torque-off groove allowed.

Ⓞ MATERIAL: 7050 aluminum alloy per QQ-A-430 or 7075 aluminum alloy per QQ-A-225/9.

HEAT TREAT: Age to T73 condition per MIL-H-6088.

FINISH: HST1380-( ) = Anodize per MIL-A-8825, dye color black, 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.

EXAMPLE: HST1380-3 = 1/4-28 Hi-Lite ST collar with cetyl alcohol lube.

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.

			TITLE	DRAWING NUMBER
DRAWN	2-4-83	D. P. S.	<b>HI-LITE<sup>®</sup> ST<sup>™</sup> COLLAR</b> ALUMINUM ALLOY 1/16" GRIP VARIATION - SHEAR APPLICATION FOR USE ON STANDARD AND 1/32" OVERSIZE HI-LITE ST PINS	<b>HST1380</b>
APPROVED	2-4-83	<i>[Signature]</i>		
REVISION	7-19-89	D. P. S.		
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