



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	A ₁ DIA. (REF.)	B DIA.	L	L ₁ (REF.)	L ₂ (REF.)	L ₃ (REF.)	P (REF.)	W HEX.	X (REF.)	X ₁ (REF.)	UTS LBS. MIN.	TORQUE-OFF IN.-LBS.
5	5/32	8-32UNJC-3B	.287 .283	.320	.173 .169	.445 .425	.235	.255	.460	.250	.220 .213	.085	.100	2,300	15-25
6	3/16	10-32UNJF-3B	.307 .303	.340	.212 .208	.455 .435	.245	.265	.470	.280	.251 .244	.085	.100	2,750	25-35
8	1/4	1/4-28UNJF-3B	.412 .408	.440	.276 .272	.525 .505	.270	.285	.540	.350	.314 .302	.090	.105	5,000	60-80
10	5/16	5/16-24UNJF-3B	.518 .512	.550	.340 .334	.633 .613	.323	.338	.650	.420	.377 .365	.095	.110	8,300	130-160
12	3/8	3/8-24UNJF-3B	.628 .622	.660	.403 .397	.703 .683	.363	.378	.720	.490	.439 .425	.095	.100	12,700	200-240

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

MATERIAL: Collar - A-286 high temperature alloy per AMS5731.
 Washer - 300 series stainless steel.

⊙ FINISH: Collar - HST1397DU() = Solid film lube per AS5272 plus orange identification on body of collar.
 HST1397PB() = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST1397TF() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
 Collar & Washer - HST1397TFW() = Collar with Hi-Kote 2 solid film lube. Washer with passivate per Hi-Shear Spec. 258.

SPECIFICATION: Hi-Lite Product Specification No. 381.

CODE: Dash number indicates nominal thread size in 1/32nds.
 See Finish note for explanation of code letters.

⊙ EXAMPLE: HST1397PB8 = 1/4-28 Hi-Lite ST collar with Type II cadmium plate.

U.S. Patents 4,326,825; 4,485,510 and 4,957,401.
 Other U.S. and international patents pending.
 "Hi-Lite" and "HST" are registered trademarks and
 "Hi-Lite ST" is a trademark of Hi-Shear Corporation

DRAWN			DATE			BY			TITLE			DRAWING NUMBER		
DRAWN			9-19-85			D.P.S.			HI-LITE® ST™ COLLAR			HST1397		
APPROVED			9-30-85			J.RAUSCH			A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION SHEAR APPLICATION					
① REVISION			1-18-99			J.Henderson			FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LITE PINS					