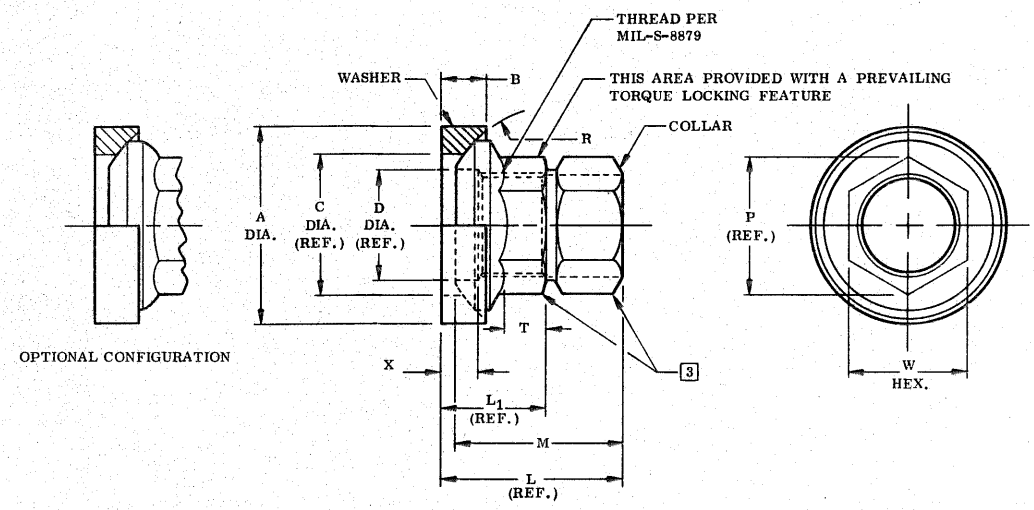
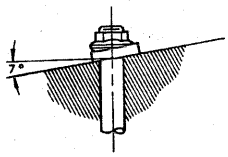
hi-shear CORPORATION
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B	C DIA. (REF.)	D DIA. (REF.)	L (REF.)	L_1 (REF.)	M	P (REF.)	R SPHER. RAD.	T MIN.	W HEX.	X	UTS LBS. MIN.	TORQUE-OFF IN.-LBS.
-5	5/32	8-32UNJC-3B	.345 .335	.071 .061	.225	.170	.470	.300	.447 .427	.288	.215 .205	.090	.252 .241	.112 .092	1,750	20-30
-6	3/16	10-32UNJF-3B	.395 .385	.088 .078	.285	.210	.485	.310	.457 .437	.320	.245 .235	.090	.283 .271	.112 .092	2,210	30-40
-8	1/4	1/4-28UNJF-3B	.515 .505	.123 .113	.365	.270	.585	.370	.552 .532	.385	.310 .300	.105	.346 .332	.116 .096	4,080	60-90
-10	5/16	5/16-24UNJF-3B	.660 .650	.160 .150	.450	.335	.720	.470	.672 .652	.490	.385 .375	.170	.400 .425	.118 .098	6,500	110-160
-12	3/8	3/8-24UNJF-3B	.790 .780	.180 .170	.525	.395	.785	.525	.744 .724	.565	.445 .435	.170	.503 .488	.120 .100	10,100	160-240

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.
4. For use on sloped surfaces up to 7° maximum on Hi-Lite ST pins.



MATERIAL: Collar – 7050 aluminum alloy per AMS4340 or 7075 aluminum alloy per QQ-A-225/9.
Washer – 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH13-7Mo per AMS5520.

HEAT TREAT: Collar – Age to T73 condition per MIL-H-6088.
Washer – Age to H1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and 15-7Mo per MIL-H-6875.

FINISH: Collar – HST1486-( )A = Anodize per MIL-A-8625, color black, and cetyl alcohol lube per Hi-Shear Spec. 305.
Washer – HST1486-( )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.
Code letter "W" following dash number indicates self-aligning washer.
See finish note for explanation of code letters.

EXAMPLE: HST1486-8AWU = Assembly of HST1486-8A collar and HST1486-8WU 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
DRAWN	4-24-89	D.P.S.
APPROVED	5-22-89	
REVISION		

TITLE

HI-LITE ST™ COLLAR

SELF-ALIGNING COLLAR ASSEMBLY
ALUMINUM COLLAR – STAINLESS STEEL WASHER
1/16" GRIP VARIATION – SHEAR APPLICATION
FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LITE ST PINS

DRAWING NUMBER

HST1486

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