

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 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-LB.
6	7/32	10-32UNJF-3B	.395 .385	.088 .078	.285	.225	.435	.240	.410 .390	.280	.240	.251 .244	.095	2,750	40-50
8	9/32	1/4-28UNJF-3B	.515 .505	.123 .113	.365	.288	.525	.280	.490 .470	.350	.305	.314 .302	.100	5,000	105-130
10	11/32	5/16-24UNJF-3B	.660 .650	.160 .150	.450	.348	.625	.325	.590 .570	.420	.380	.377 .365	.105	8,300	200-250
12	13/32	3/8-24UNJF-3B	.790 .780	.180 .170	.525	.413	.695	.365	.660 .640	.490	.440	.439 .425	.105	12,700	360-440
14	15/32	7/16-20UNJF-3B	.893 .883	.237 .227	.605	.478	.775	.415	.710 .690	.557	.500	.503 .490	.110	19,000	550-625
16	17/32	1/2-20UNJF-3B	1.005 .995	.265 .255	.690	.540	.845	.445	.770 .750	.624	.560	.565 .550	.110	25,500	725-825

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

**MATERIAL:** Collar - S30430 (302 HQ) stainless steel per ASTM A493, Type XM-7; 305 stainless steel per AMS-QQ-S-763 and AMS5686; or 303 stainless steel per ASTM A582 (AMS5640); or 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 PH15-7Mo per AMS-H-6875.

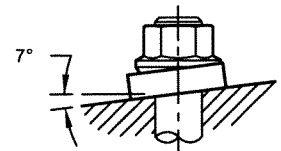
**FINISH:** Collar - HST1675JV( )A = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305, and color orange identification on body of collar.  
HST1675TP( )A = Hi-Kote 2 solid fillm lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305, and color orange identification on body of collar.

Washer - HST1675-( )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 other code letters.

**EXAMPLE:** HST1675TP8AWU = Assembly of HST1675TP8A Hi-Lite ST collar and HST1675-8WU 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

			TITLE	DRAWING NO.
			<b>HI-LITE® ST™ COLLAR</b>	<b>HST1675</b>
			SELF-ALIGNING COLLAR ASSEMBLY	
			STAINLESS STEEL	
			1/16" GRIP VARIATION, TENSION APPLICATION FOR USE ON 1/32" OVERSIZE HI-LITE PINS	
DATE	BY			
DRAWN	12-21-00	J.F.Obispo		
APPROVED	12-21-00	D.Hocking		
1 REVISION	8-21-01	J.F.Obispo		