

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.	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE-OFF IN. -LBS.
-5	5/32	8-32UNJC-3B	NOTE: Use HST1576-6												
-6	3/16	10-32UNJF-3B	.395 .385	.088 .078	.285	.225	.435	.240	.410 .390	.280	.24	.251 .244	.095	2,750	25-40
-8	1/4	1/4-28UNJF-3B	.515 .505	.123 .113	.365	.288	.525	.280	.495 .475	.350	.30	.314 .302	.100	5,000	60-90
-10	5/16	5/16-24UNJF-3B	.660 .650	.160 .150	.450	.348	.625	.325	.580 .560	.420	.38	.377 .365	.105	8,300	110-160
-12	3/8	3/8-24UNJF-3B	.790 .780	.180 .170	.525	.413	.695	.365	.640 .620	.490	.44	.439 .425	.105	12,700	160-220
-14	7/16	7/16-20UNJF-3B	.893 .883	.237 .227	.605	.478	.775	.415	.705 .685	.557	.50	.503 .490	.110	19,000	220-300
-16	1/2	1/2-20UNJF-3B	1.005 .995	.265 .255	.690	.540	.845	.445	.770 .750	.624	.56	.565 .550	.110	25,500	340-430

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. For use on sloped surfaces up to 7° maximum on Hi-Lite ST tension head pins.
3. Dimensions apply after finish.
4. For -12, -14, and -16 washers, chamfer or radius .040-.050.

MATERIAL: Collar - S30430 (302 HQ) stainless steel per Spec. ASTM A193, Type XM-7; 305 stainless steel per QQ-S-763 and AMS5686; or 303 Se stainless steel per ASTM A582 and AMS5640.
Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

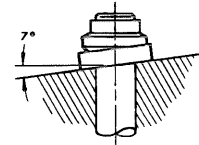
HEAT TREAT: Collar - None.
Washer - Age to H1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and 15-7Mo per MIL-H-6875.

FINISH: Collar - HST1676YM-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305, plus color orange identification on barrel and color white identification on hex and adjacent portion of barrel.
Washer - HST1676-()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.
See finish note for explanation of other code letters.

EXAMPLE: HST1676YM-8AWU = Assembly of HST1676YM-8A collar and HST1676-8WU 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.

			TITLE	DRAWING NUMBER
DATE	BY		HI-LITE® ST™ COLLAR SELF-ALIGNING COLLAR ASSEMBLY (STAINLESS STEEL COLLAR - STAINLESS STEEL WASHER) 1/16" GRIP VARIATION - SHEAR APPLICATION FOR USE ON STANDARD AND 1/32" OVERSIZE HI-LITE ST PINS	HST1676
DRAWN	11-21-89	D.P.S.		
APPROVED	11-21-89	JCW/lt		
REVISION				