



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	A1 DIA. (REF.)	B DIA.	L	L1 (REF.)	L2 (REF.)	L3 (REF.)	P (REF.)	W HEX.	X (REF.)	X1 (REF.)	UTS LBS. MIN.	PRELOAD	
															MAX.	MIN.
-5	5/32	5-32UNJC-3B	.287 .283	.320	.173 .169	.395 .375	.220	.235	.400	.344	.314 .302	.085	.100	2,300	1,300	650
-6	3/16	10-32UNJF-3B	.307 .303	.340	.212 .208	.405 .395	.230	.245	.410	.344	.314 .302	.085	.100	2,750	1,900	950
-8	1/4	1/4-28UNJF-3B	.412 .408	.442	.272 .268	.475 .455	.270	.295	.480	.484	.440 .425	.090	.105	5,000	3,500	1,750
-10	5/16	5/16-24UNJF-3B	.518 .512	.552	.336 .330	.555 .535	.315	.330	.545	.624	.565 .550	.095	.110	8,300	5,500	2,760
-12	3/8	3/8-24UNJF-3B	.620 .614	.665	.398 .392	.625 .605	.355	.370	.630	.715	.628 .613	.095	.110	12,700	8,400	4,200
-14	7/16	7/16-20UNJF-3B	.733 .727	.765	.463 .457	.705 .685	.405	.420	.710	.840	.753 .736	.100	.115	19,000	11,300	5,670
-16	1/2	1/2-20UNJF-3B	.848 .842	.880	.528 .522	.765 .745	.425	.450	.770	.970	.878 .861	.100	.115	25,500	15,360	7,690
-18	9/16	9/16-18UNJF-3B	.915 .905	.910	.599 .592	.875 .855	.520	.535	.890	.970	.878 .861	.105	.120	29,000	19,440	9,720
-20	5/8	5/8-18UNJF-3B	.995 .985	1.040	.661 .655	.960 .940	.575	.590	.975	1.120	1.003 .986	.105	.120	32,000	24,600	12,300
-24	3/4	3/4-16UNJF-3B	1.120 1.110	1.140	.786 .780	1.185 1.165	.755	.770	1.205	1.240	1.128 1.110	.120	.135	42,000	35,700	17,850
-28	7/8	7/8-16UNJF-3B	1.345 1.335	1.365	.911 .905	1.400 1.380	.895	.910	1.420	1.520	1.380 1.366	.125	.140	62,000	46,500	23,250
-32	1	1-12UNJF-3B	1.490 1.480	1.510	1.036 1.030	1.635 1.615	1.030	1.045	1.655	1.650	1.504 1.480	.130	.145	84,000	60,000	30,000

NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. Dimensions apply after finish.

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

FINISH: HST178GU-() = Collar with silver plate per AMS2410.
HST178GUW-() = Collar with silver plate per AMS2410. Washer with passivate per Hi-Shear Spec. 258.

SPECIFICATION: Hi-Lite Product Specification 381 except preload as tabulated.

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

EXAMPLE: HST178GUW-8 = 1/4-28 Hi-Lite ST collar assembly. Collar finish is silver plate per AMS2410. Washer is passivated.

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	7-27-89	D.P.S.	HI-LITE[®] ST[™] COLLAR A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION SPECIAL APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LITE ST PINS	HST178
APPROVED	7-31-89	JG Wilcox		
REVISION				