



| 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 | TORQUE-OFF INCH-POUNDS |
|----------|-------------|----------------|--------------|--------------|--------------|--------------|----------|----------|----------|---------|--------------|---------|----------|--------------|------------------------|
| 5 | 5/32 | 8-32UNJC-3B | .287 .283 | .320 | .179 .169 | .415 .395 | .235 | .250 | .420 | .344 | .314 .302 | .085 | .100 | 3,050 | 30-40 |
| 6 | 3/16 | 10-32UNJF-3B | .307 .303 | .340 | .212 .208 | .435 .415 | .245 | .260 | .440 | .344 | .314 .302 | .085 | .100 | 4,000 | 40-50 |
| 8 | 1/4 | 1/4-28UNJF-3B | .413 .407 | .445 | .272 .268 | .490 .470 | .279 | .295 | .495 | .380 | .346 .332 | .090 | .105 | 7,500 | 110-135 |
| 10 | 5/16 | 5/16-24UNJF-3B | .518 .512 | .550 | .336 .330 | .575 .555 | .333 | .343 | .580 | .484 | .440 .425 | .095 | .110 | 11,750 | 200-250 |
| 12 | 3/8 | 3/8-24UNJF-3B | .620 .614 | .660 | .398 .392 | .645 .625 | .373 | .388 | .650 | .557 | .503 .488 | .095 | .110 | 18,000 | 360-420 |
| 14 | 7/16 | 7/16-20UNJF-3B | .733 .727 | .765 | .463 .457 | .725 .705 | .425 | .440 | .730 | .840 | .753 .736 | .100 | .115 | 23,250 | 525-600 |
| 16 | 1/2 | 1/2-20UNJF-3B | .848 .842 | .880 | .528 .522 | .785 .765 | .455 | .470 | .790 | .970 | .878 .861 | .100 | .115 | 32,000 | 725-825 |

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
 - Dimensions apply after finish.
 - For use on tension head Inconel 718 Hi-Lite pins heat treated to 125,000 psi shear minimum. Do not use on titanium pins.

MATERIAL: Collar - 17-4PH stainless steel per AMS5643.
Washer - 300 series stainless steel.

HEAT TREAT: Collar - To condition H1025 per AMS-H-6875.
Washer - None.

FINISH: Collar - HST73-() = Silver plate per AMS2410 (.0002-.0004 thick), dye color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST73DU() = Solid film lube per AS5272, Type I.
HST73DY() = Solid film lube per AS5272, Type I plus yellow identification on body of collar.
HST73KB() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and optional cetyl alcohol lube per Hi-Shear Spec. 305, and green identification on body of collar.
HST73LP() = Solid film lubricant per AS5272, Type II.
HST73PB() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST73TP() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305, and orange identification on body of collar.
HST73V() = Solid film lubricant per Lubeco 2123, Type II.
Collar & Washer - HST73DUW() = Both with solid film lube per AS5272, Type I.
HST73KBWU() = Collar finish same as HST73KB(), and washer is passivated per Hi-Shear Spec. 258.
HST73VW() = Both with Lubeco 2123 solid film lubricant.
HST73W() = Collar finish same as HST73-(), and washer is passivated per Hi-Shear Spec. 258.
HST73WV() = Collar finish same as HST73-(), and washer is solid film lube per Lubeco 2123.

SPECIFICATION: Hi-Lite Product Specification 381.

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

EXAMPLES: HST73-8 = 1/4-28 Hi-Lite ST collar.
HST73W8 = 1/4-28 Hi-Lite ST collar with 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. |
|----------|----------|------------|---|--------------|
| | DATE | BY | HI-LITE® ST™ COLLAR 17-4PH STAINLESS STEEL 1/16" GRIP VARIATION, TENSION APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LITE ST PINS | HST73 |
| DRAWN | 12-20-83 | D.P.S. | | |
| APPROVED | 12-20-83 | E.E.Beeles | | |
| REVISION | 2-18-02 | S. KIM | | |