

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 (MAX)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.365 .355	.095 .085	.255	.171	.385	.220	.370 .350	.380	.20	.346 .332	.095	2,300	30-40
6	3/16	10-32UNJF-3B	.365 .355	.095 .085	.255	.198	.395	.230	.370 .350	.380	.20	.346 .332	.095	2,750	40-50
8	1/4	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.259	.465	.270	.435 .415	.484	.26	.440 .425	.100	5,000	115-130
10	5/16	5/16-24UNJF-3B	.620 .610	.130 .120	.417	.322	.545	.315	.500 .480	.484	.34	.440 .425	.105	8,300	200-250
12	3/8	3/8-24UNJF-3B	.790 .780	.145 .135	.490	.385	.615	.355	.560 .540	.557	.38	.503 .488	.105	12,700	360-440
14	7/16	7/16-20UNJF-3B	.895 .885	.180 .170	.570	.447	.695	.405	.625 .605	.840	.45	.753 .736	.110	19,000	550-625
16	1/2	1/2-20UNJF-3B	1.005 .995	.205 .195	.648	.510	.755	.435	.680 .660	.970	.51	.878 .861	.110	25,000	725-825

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
 - Dimensions apply after finish.
 - For used on sloped surfaces up to 7° maximum on Hi-Lite ST tension head pins.
 - For -12, -14, and -16 washers, chamfer or radius .040-.050.
- ② 5 Cetyl alcohol lube per Hi-Shear Spec. 305 may be applied, at manufacturer's option to meet procurement specification requirements.

MATERIAL: Collar - 303 Se stainless steel per ASTM A 582 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 H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH, and 15-7Mo per AMS-H-6875.

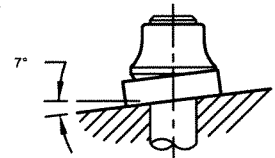
FINISH: Collar - HST75-()A = Cadmium plate per AMS-QQ-P-416, Type I, Class 2 and cetyl alcohol lube per Hi-Shear Spec. 305.
5 HST75DU()A = Solid film lube per AS5272, Type I.
HST75PB()A = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
5 HST75TF()A = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
HST75TP()A = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, color orange on body of collar, and cetyl alcohol lube per Hi-Shear Spec. 305.

Washer - HST75-()DW = Solid film lube per AS5272, Type I.
HST75-()PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
HST75()JW = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.
HST75-()JUW = 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: HST75-8AW = Assembly of HST75-8A collar and HST75-8W washer.
HST75TF8AWU = Assembly of HST75TF8A collar and HST75-8WU 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.
	DATE	BY	HI-LITE® ST™ COLLAR SELF-ALIGNING COLLAR ASSEMBLY (303 STAINLESS STEEL COLLAR, STAINLESS STEEL WASHER) 1/16 GRIP VARIATION, TENSION APPLICATION	HST75
DRAWN	12-23-83	D.P.S.		
APPROVED	12-23-83	R. Ting		
2 REVISION	07-30-01	J.F.Obispo		