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(12)

HI-SHEAR CORPORATION, U.S.A.——(Patent Holder)——CAGE No. 73197
a LISI AEROSPACE Company
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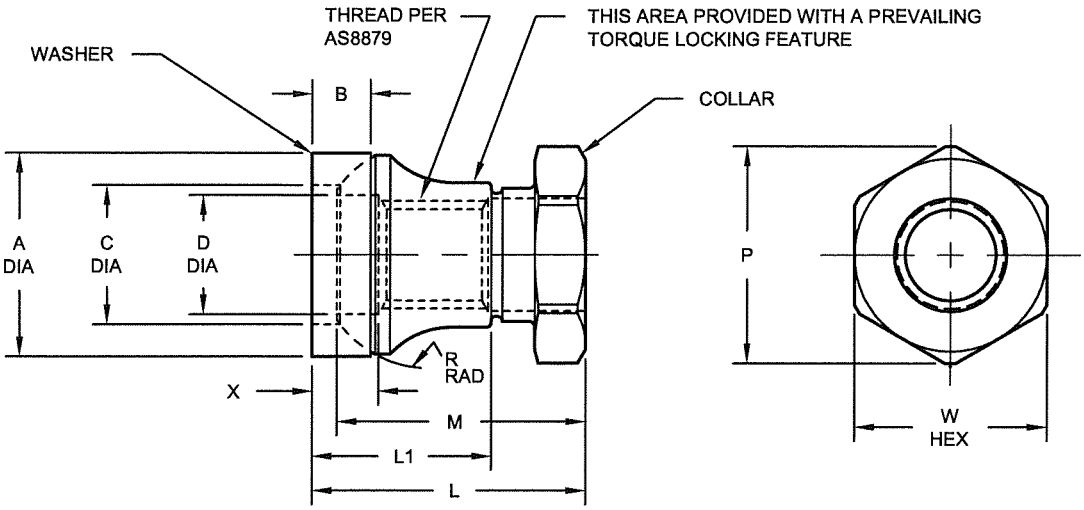


DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	D DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER. RAD	W HEX	X (MAX)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.365 .355	.095 .085	.255	.171	.385	.220	.370 .350	.344	.20	.314 .302	.095	1,400	15-30
6	3/16	10-32UNJF-3B	.365 .355	.095 .085	.255	.198	.395	.230	.370 .350	.380	.20	.346 .332	.095	1,600	25-40
8	1/4	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.259	.465	.270	.435 .415	.484	.26	.440 .425	.100	3,000	60-90
10	5/16	5/16-24UNJF-3B	.620 .610	.130 .120	.417	.322	.545	.315	.500 .480	.484	.34	.440 .425	.105	5,000	110-160
12	3/8	3/8-24UNJF-3B	.685 .675	.145 .135	.490	.385	.615	.355	.560 .540	.557	.38	.503 .488	.105	7,000	160-220
14	7/16	7/16-20UNJF-3B	.805 .795	.180 .170	.570	.447	.695	.405	.625 .605	.624	.45	.565 .550	.110	9,300	220-300
16	1/2	1/2-20UNJF-3B	.915 .905	.205 .195	.648	.510	.755	.435	.680 .660	.763	.51	.690 .675	.110	12,500	340-430
18	9/16	9/16-18UNJF-3B	1.125 1.115	.270 .260	.763	.575	.940	.520	.845 .825	.970	.71	.878 .861	.115	14,500	525-625
20	5/8	5/8-18UNJF-3B	1.305 1.290	.315 .305	.855	.644	1.025	.575	.930 .910	1.120	.76	1.003 .986	.115	18,000	650-750

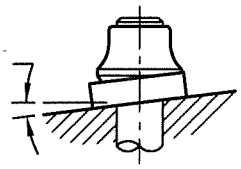
NOTES:
1. Dimensions apply after finish.
2. For use on sloped surfaces up to 7° maximum on Hi-Lite ST pins.

MATERIAL:
Collar - 7075 aluminum alloy per AMS-QQ-A-225/9.
Washer - "C" - A-286 high temperature alloy per AMS5731 or AMS5737.
"W" - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

HEAT TREAT:
Collar - Age to T73 condition per AMS2770.
Washer - "C" - 90,000 psi shear minimum.
"W" - Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and 15-7Mo per AMS-H-6875.

FINISH:
Collar - HST82CK( )A = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST82CY( )A = Anodize per MIL-A-8625, dye color orange, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST82D( )A = Anodize per MIL-A-8625, color natural, and solid film lube per AS5272, Type I.

Washer - HST82-( )CPB = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
HST82-( )CU = Passivate per Hi-Shear Spec. 258.
HST82-( )DW = Solid film lube per AS5272, Type I.
HST82-( )PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
HST82-( )W = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.
HST82-( )WU = Passivate per Hi-Shear Spec. 258.
HST82-( )EW = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cety alcohol lube per Hi-Shear Spec. 305.



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.

EXAMPLES:
HST82CY8ACPB = Assembly of HST82CY8A collar and HST82-8CPB washer.
HST82CY8AW = Assembly of HST82CY8A collar and HST82-8W washer.
HST82D8AWU = Assembly of HST82D8A collar and HST82-8WU washer.
HST82D8ADW = Assembly of HST82D8A collar and HST82-8DW 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

	DATE	BY
DRAWN	6-1-83	D.P.S.
APPROVED	6-1-83	R. Ting
(12) REVISION	10-27-10	J.F.Obispo

TITLE

HI-LITE® ST™ COLLAR

SELF-ALIGNING COLLAR ASSEMBLY
(ALUMINUM COLLAR, STAINLESS STEEL WASHER)
1/16 GRIP VARIATION, SHEAR APPLICATION

DRAWING NO.

HST82

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