



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	.324	.173 .169	.395 .375	.220	.235	.400	.344	.314 .302	.085	.100	1,940	15-25
6	3/16 13/64	10-32UNJF-3B	.307 .303	.357	.212 .208	.405 .385	.230	.245	.410	.344	.314 .302	.085	.100	2,500	25-35
8	1/4 17/64	1/4-28UNJF-3B	.412 .408	.457	.272 .268	.475 .455	.270	.285	.480	.484	.440 .425	.090	.105	4,300	60-80
10	5/16 21/64	5/16-24UNJF-3B	.518 .512	.573	.336 .330	.555 .535	.315	.330	.545	.624	.565 .550	.095	.110	6,300	130-160
12	3/8 25/64	3/8-24UNJF-3B	.620 .614	.683	.398 .392	.625 .605	.355	.370	.630	.715	.628 .613	.095	.110	8,700	200-240
14	7/16 29/64	7/16-20UNJF-3B	.733 .727	.777	.463 .457	.705 .685	.405	.420	.710	.840	.753 .736	.100	.115	12,100	270-330
16	1/2 33/64	1/2-20UNJF-3B	.848 .842	.897	.528 .522	.765 .745	.435	.450	.770	.970	.878 .861	.100	.115	15,300	370-430
18	9/16 37/64	9/16-18UNJF-3B	.915 .905	.910	.598 .592	.875 .855	.520	.535	.890	1.045	.941 .924	.105	.120	20,500	500-575
20	5/8 41/64	5/8-18UNJF-3B	.995 .985	1.040	.661 .655	.960 .940	.575	.590	.975	1.120	1.003 .986	.105	.120	25,700	625-700
24	3/4 49/64	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	37,300	900-1000
28	7/8 57/64	7/8-14UNJF-3B	1.345 1.335	1.365	.911 .905	1.400 1.380	.895	.910	1.420	1.520	1.380 1.356	.125	.140	50,900	1200-1325
32	1 65/64	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	67,000	1450-1600

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions apply after finish.
 3. Use HST197 for oversize replacement.

MATERIAL: Collar - A-286 high temperature alloy per AMS5731, AMS5734, or AMS5736.
 Washer - 300 series stainless steel.

- FINISH:**
- Collar - HST97-() = Collar only with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST97DJ() = Collar only with solid film lube per AS5272, Type I, plus green identification on body of collar.
 - HST97DU() = Collar only with solid film lube per AS5272, Type I, plus orange identification on body of collar.
 - HST97DUW() = Collar with solid film lube per AS5272, Type I, plus orange identification on body of collar. Washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 - HST97DUWK() = Collar with solid film lube per AS5272, Type I, plus orange identification on body of collar. Washer with Hi-Kote 1 (minimum .0002 thickness) and optional cetyl alcohol lubrication.
 - HST97DUWU() = Collar with solid film lube per AS5272, Type I, plus orange identification on body of collar. Washer with passivate per Hi-Shear Spec. 258.
 - HST97MA() = Collar only with Kalgard RA solid film lube.
 - HST97PB() = Collar only with cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST97TF() = Collar only with Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
 - HST97V() = Collar only with Lubeco 2123 solid film lube.
 - HST97W() = Collar with silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305. Washer with passivate per Hi-Shear Spec. 258.

SPECIFICATION: Hi-Lite Product Specification 381.

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

EXAMPLE: HST97DU8 = 1/4-28 Hi-Lite ST collar with solid film lube per AS5272, Type I, plus orange identification on body of collar.

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	TITLE	DRAWING NO.
	2-27-84	D.P.S.	HI-LITE® ST™ COLLAR	HST97
	2-8-84	E.E.B.	A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION, SHEAR APPLICATION	
	04-14-09	P. L	FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LITE ST PINS	
12	REVISION			