



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	.173 .169	.425 .405	.220	.235	.440	.250	.220 .213	.085	.100	1,940	15-25
6	3/16	10-32UNJF-3B	.307 .303	.340	.212 .208	.435 .415	.230	.245	.450	.280	.251 .244	.085	.100	2,500	25-35
8	1/4	1/4-28UNJF-3B	.412 .408	.440	.276 .272	.525 .505	.270	.285	.540	.350	.314 .302	.090	.105	4,300	60-80
10	5/16	5/16-24UNJF-3B	.518 .512	.550	.340 .334	.625 .605	.315	.330	.640	.420	.377 .365	.095	.110	6,300	130-160
12	3/8	3/8-24UNJF-3B	.628 .622	.660	.403 .397	.695 .675	.355	.370	.710	.490	.439 .425	.095	.110	8,700	200-240

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 - Dimensions apply after finish.
 - Burrs from cutoff process and cutting torque-off groove allowed.

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

FINISH: Collar - HST1097(-) = Silver plate per AMS2410 (.0002-.0004 thick) and cetyl alcohol lube per Hi-Shear Spec. 305.
HST1097DU() = Solid film lube per MIL-L-46010, Type I, plus orange identification on body of collar per MIL-P-23377.
HST1097TF() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.

Collar & Washer - HST1094DUWU() = Collar finish same as HST1094DU. Washer with passivate per Hi-Shear Spec. 258.
HST1097DUWU() = Collar finish same as HST1097DU. Washer with cadmium plate per AMS-QQ-P-416, Type II, Class 2.

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: HST1097-8 = 1/4-28 Hi-Lite ST collar with silver plate and cetyl alcohol lube.
HST1097DUWU-8 = 1/4-28 Hi-Lite ST collar with solid film lube and 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 A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, SHEAR APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LITE ST PINS	HST1097
DRAWN	D.P.S.			
APPROVED	R. Ting			
REVISION	S. KIM			