

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 (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	.365 .355	.095 .085	.255	.171	.415	.220	.400 .380	.250	.20	.220 .213	.095	1,400	15-30
6	3/16	10-32UNJF-3B	.365 .355	.095 .085	.255	.210	.425	.230	.400 .380	.280	.20	.251 .244	.095	1,600	25-40
8	1/4	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.270	.515	.270	.485 .465	.350	.26	.314 .302	.100	3,000	60-90
10	5/16	5/16-24UNJF-3B	.620 .610	.130 .120	.417	.334	.615	.315	.570 .550	.420	.34	.377 .365	.105	5,000	110-160
12	3/8	3/8-24UNJF-3B	.685 .675	.145 .135	.490	.395	.685	.355	.630 .610	.490	.38	.439 .425	.105	7,000	160-220
14	7/16	7/16-20UNJF-3B	.805 .795	.180 .170	.570	.460	.765	.405	.700 .680	.557	.45	.503 .490	.110	9,300	220-300
16	1/2	1/2-20UNJF-3B	.915 .905	.205 .195	.648	.525	.835	.435	.760 .740	.624	.51	.565 .550	.110	12,500	340-430

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
  - Dimensions apply after finish.
  - 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 - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS-H-6875.

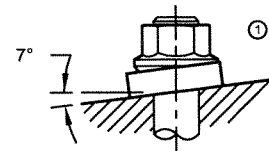
**HEAT TREAT:** Collar - Age to T73 condition per AS2770.  
Washer - Age to H-1025 condition for 17-4 PH, age to TH1050 condition for 17-7PH and 15-7Mo per AMS-H-6875.

① **FINISH:** Collar - HST1183CY( )A = Anodize per MIL-A-8625, dye color orange, and cetyl alcohol  
Washer - HST1183-( )WU = 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.  
Code letter "W" following dash number indicates self-aligning collar.  
See "Finish" note for explanation of other code letters.

① **EXAMPLE:** HST1183CY8AWU = Assembly of HST1183CY( )A collar and HST1183-8WU 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.
			<b>HI-LITE® ST™ COLLAR</b>	<b>HST1183</b>
			SELF-ALIGNING COLLAR ASSEMBLY	
			(ALUMINUM COLLAR, STAINLESS STEEL WASHER)	
			1/16 GRIP VARIATION, SHEAR APPLICATION	
① REVISION	DATE	BY	FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LITE PINS	
	1-17-89	J.F.O.		
	5-9-94	JGWilcox		
	8-13-02	J.F.O.		