



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-LBS.
5	5/32	8-32UNJC-3B	.292 .288	.335	.173 .166	.415 .395	.230	.245	.420	.248	.221 .211	.085	.100	2,300	25-35
6	3/16	10-32UNJF-3B	.307 .303	.360	.212 .208	.425 .405	.240	.255	.430	.285	.252 .241	.085	.100	2,750	40-50
8	1/4	1/4-28UNJF-3B	.412 .408	.460	.272 .268	.495 .475	.280	.295	.500	.355	.314 .302	.090	.105	5,000	105-130
10	5/16	5/16-24UNJF-3B	.518 .512	.575	.340 .334	.565 .545	.325	.340	.570	.430	.378 .365	.095	.110	8,300	200-250
12	3/8	3/8-24UNJF-3B	.628 .622	.690	.403 .397	.635 .615	.365	.380	.640	.573	.503 .490	.095	.110	12,700	340-420
14	7/16	7/16-20UNJF-3B	.733 .727	.780	.468 .462	.790 .770	.415	.430	.795	.643	.565 .550	.110	.115	19,000	525-600
16	1/2	1/2-20UNJF-3B	.848 .842	.890	.528 .522	.830 .810	.445	.460	.835	.788	.690 .675	.110	.115	25,500	725-825

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

**MATERIAL:** Collar - S30430 (302HQ) stainless steel per ASTM A493, Type XM-7; 305 stainless steel per AMS-QQ-S-763 and AMS5686; 303 Se stainless steel per ASTM A582 (AMS5640); or 302 stainless steel per AMS-QQ-S-763.

5 Washer - "NW" - 300 series stainless steel.  
"C" - A-286 high temperature alloy per AMS5525.

**FINISH:** Collar - HST1488TP ( ) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305, and orange identification on body of collar.  
HST1488G ( ) = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.

5 Collar & Washer - HST1488TP ( ) CD = Collar finish same as HST1488TP ( ) and washer is passivated and solid film lube per AS5272, Type I.  
HST1488G ( ) NWG = Collar finish same as HST1488G ( ) and washer is silver plate finish only.

**SPECIFICATION:** Hi-Lite Product Specification 381.

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

**EXAMPLES:** HST1488TP8 = 1/4-28 Hi-Lite ST collar only with Hi-Kote 2, color orange, and cetyl alcohol lube.  
5 HST1488TP8CD = 1/4-28 Hi-Lite ST collar with Hi-Kote 2, color orange, and cetyl alcohol with A-286 washer, passivate and solid film lube finish.  
HST1488G8NWG = 1/4-28 Hi-Lite ST collar with silver plate and cetyl alcohol with silver plate stainless steel 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		<b>HI-LITE® ST™ COLLAR</b> STAINLESS STEEL 1/16 GRIP VARIATION, TENSION APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LITE ST PINS	<b>HST1488</b>
DRAWN	4-19-94	T.Craine		
APPROVED	5-9-94	JGWilcox		
5 REVISION	7-21-05	J.F.Obispo		