



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	PRELOAD POUNDS	TORQUE-OFF INCH-LB. (REF)
5	5/32	8-32UNJC-3B	.287 .283	.320	.173 .169	.425 .405	.220	.235	.440	.250	.220 .213	.085	.100	2,300	1960 1150	30
6	3/16	10-32UNJF-3B	.307 .303	.340	.212 .208	.435 .415	.230	.245	.450	.280	.251 .244	.085	.100	2,750	2575 1375	40
8	1/4	1/4-28UNJF-3B	.412 .408	.440	.276 .272	.525 .505	.270	.285	.540	.350	.314 .302	.090	.105	5,000	4500 2500	90
10	5/16	5/16-24UNJF-3B	.518 .512	.550	.340 .334	.625 .605	.315	.330	.640	.420	.377 .365	.095	.110	8,300	7500 4150	175
12	3/8	3/8-24UNJF-3B	.628 .622	.660	.403 .397	.695 .675	.355	.370	.710	.490	.439 .425	.095	.110	12,700	11400 6350	300
14	7/16	7/16-20UNJF-3B	.713 .707	.775	.463 .457	.775 .755	.405	.420	.790	.560	.502 .490	.100	.115	19,000	17000 9500	440
16	1/2	1/2-20UNJF-3B	.815 .809	.895	.528 .522	.845 .825	.435	.450	.860	.632	.565 .550	.100	.115	25,500	23050 12750	720
18	9/16	9/16-18UNJF-3B	.915 .905	.947	.598 .592	.950 .930	.520	.535	.965	.775	.690 .675	.105	.120	29,000	26100 14500	820
20	5/8	5/8-18UNJF-3B	.995 .985	1.040	.661 .655	1.035 1.015	.575	.590	1.050	.850	.753 .736	.105	.120	32,000	28800 16000	900
24	3/4	3/4-16UNJF-3B	1.120 1.110	1.140	.786 .780	1.255 1.235	.755	.770	1.270	.994	.878 .861	.120	.135	42,000	37800 21000	1425
28	7/8	7/8-14UNJF-3B	1.345 1.335	1.365	.916 .911	1.475 1.455	.895	.910	1.480	1.140	1.003 .985	.125	.140	62,000	55800 31000	TBD
32	1	1-12UNJF-3B	1.490 1.480	1.510	1.041 1.035	1.725 1.705	1.030	1.045	1.740	1.280	1.128 1.110	.130	.145	84,000	75600 42000	TBD

- 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.
 - These are reference torque-off values only and shall not be used for acceptance or rejection of collars.
 - For use on tension head titanium Hi-Lite ST pins with Hi-Kote1 and cetyl alcohol lubricant.
 - Locking torque, breakaway and preload are tested on epoxy chromate plate using prelaod releasing fixture
 - Material 3AL-2.5V titanium to be used on dash -5 through -10 and 6AL-4V titanium to be used on dash -12 through -32.

MATERIAL: Collar - 3AL-2.5V titanium per AMS4943 (MIL-T-9047). [7]
- 6AL-4V titanium alloy per AMS4928 or AMS4967. [7]
Washer - Commercial pure titanium per ASTM B 265, ASTM B 348. Minimum yield 25 KSI.

FINISH: Collar HST1572ZA() = Pretreat per Hi-Shear Ti-Shield III and Hi-Kote 2 solid film lube per Hi-Shear spec 292, plus cetyl alcohol lube per Hi-Shear Spec 305, with color blue identification on barrel, and white identification.

Collar & washer-
HST1572ZAWT() = Collar finish same as HST1572ZA
Washer finish per Hi-Shear spec 306, Ty I, color brown, and cetyl alcohol lube per Hi-Shear spec 305.

SPECIFICATION: Hi-Lite product specification No. 381, except note [6], material and preload as noted and test bolt is TB32VAP.

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

EXAMPLE: HST1572ZA8 = 1/4-28 Hi-Lite ST collar.
HST1572ZAWT8 = 1/4-28 Hi-Lite ST collar 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

	DATE	BY	TITLE	DRAWING NO.
	5-5-94	j.f.obispo	HI-LITE® ST™ COLLAR	HST1572
	5-9-94	J.G. Wilcox	TITANIUM ALLOY 1/16 GRIP VARIATION, TENSION APPLICATION	
	3-8-10	jo	FOR USE ON STANDARD AND 1/64 OVERSIZE HI-LITE ST PINS	
(8)	REVISION			