



DASH NO.	PIN DIA.	THREAD	A DIA.	B DIA.	L	L ₁ (REF.)	P (REF.)	W HEX.	X (REF.)	UTS LBS. MIN.	PRELOAD POUNDS	TORQUE-OFF INCH - LB. (REF.)
5												
NOTE: USE HST1572-6												
6	7/32	10-32UNJF-3B	.355 .345	.227 .223	.435 .415	.240	.280	.251 .244	.095	2,750	2575 1375	40
8	9/32	1/4-28UNJF-3B	.440 .430	.290 .286	.525 .505	.280	.350	.314 .302	.100	5,000	4500 2500	90
10	11/32	5/16-24UNJF-3B	.580 .570	.353 .347	.625 .605	.325	.420	.377 .365	.105	8,300	7500 4150	175
12	13/32	3/8-24UNJF-3B	.685 .675	.416 .410	.695 .675	.365	.490	.439 .425	.105	12,700	11400 6350	300
14	15/32	7/16-20UNJF-3B	.775 .765	.481 .475	.775 .765	.415	.624	.565 .550	.110	19,000	17000 9500	440
16	17/32	1/2-20UNJF-3B	.880 .870	.543 .537	.845 .825	.445	.775	.690 .675	.110	25,500	23050 12750	720
18	19/32	9/16-UNJF-3B	.925 .915	.613 .607	.950 .930	.530	.840	.753 .736	.115	29,000	26100 14500	820
20	21/32	5/8-UNJF-3B	1.000 .990	.678 .672	1.035 1.015	.585	.970	.878 .861	.115	32,000	28800 16000	900
24	25/32	3/4-UNJF-3B	1.185 1.175	.803 .797	1.255 1.235	.765	1.045	.941 .924	.130	42,000	37800 21000	1425

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions apply after finish.
 3. Burrs from cutoff process and cutting torque-off groove allowed.
 4. These are reference torque-off values only and shall not be used for acceptance or rejection of collars.
 5. For use on 1/32 ovs titanium Hi-Lite ST pins with Hi-Kote 1 and cetyl alcohol lubricant.

MATERIAL: 3AI-2.5V titanium alloy per AMS4943 (MIL-T-9047).

FINISH: HST1772ZA-() = 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.

SPECIFICATION: Hi-Lite Product Specification No. 381, except material and preload as noted.

CODE: Dash number indicates nominal thread size in 1/32nds.

EXAMPLE: HST1772ZA-8 = 1/4-28 Hi-Lite ST collar.

U.S. Patents 4,326,825; 4,485,510 and 4,957,401.
Other U.S. and foreign patents pending.
"Hi-Lite" is a registered trademark and
"Hi-Lite ST" is a trademark of Hi-Shear Corporation.

	DATE	BY	TITLE	DRAWING NUMBER
DRAWN	09-07-94	J.F.Obispo	HI-LITE® ST™ COLLAR	
APPROVED	9-7-94	<i>JG Wilcox</i>	3AL-2.5V TITANIUM ALLOY 1/16" GRIP VARIATION - TENSION APPLICATION FOR USE ON 1/32 OVERSIZE HI-LITE ST PINS	HST1772
REVISION				