



DASH NO.	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 (REF)	P (REF)	W HEX	X (REF)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	8-32UNJC-3B	NOTE: USE HST78-6								
6	13/64	10-32UNJF-3B	.332	.228	.405	.230	.344	.314	.095	2,750	40-50
			.328	.223	.385	.302					
8	17/64	1/4-28UNJF-3B	.427	.288	.475	.270	.484	.440	.100	5,000	110-130
			.423	.283	.455	.425					
10	21/64	5/16-24UNJF-3B	.560	.350	.555	.315	.624	.565	.105	8,300	200-250
			.554	.345	.535	.550					
12	25/64	3/8-24UNJF-3B	.683	.413	.625	.355	.715	.628	.105	12,700	360-420
			.675	.407	.605	.613					
14	29/64	7/16-20UNJF-3B	.748	.476	.705	.405	.840	.753	.110	19,000	525-675
			.740	.470	.685	.736					
16	33/64	1/2-20UNJF-3B	.870	.538	.765	.435	.970	.878	.110	25,500	725-1000
			.860	.532	.745	.861					

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
  - Dimensions apply after finish.
  - Non-lubed collars must be used with lubed pins.

**MATERIAL:** Collar - A-286 high temperature alloy per AMS5731.

**FINISH:** Collar - HST378(-) = Silver plate per AMS2410 (to .0002" minimum thick on surfaces which can be touched by a .75 inch ball; threads shall show evidence of plate but thickness requirements are waived), and cetyl alcohol lube per Hi-Shear Spec. 305.

② HST378DU( ) = Solid film lube per AS5272, Type I.

HST378PB( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

③ HST378GU( ) = Silver plate per AMS2410 (to .0002" minimum thick on surfaces which can be touched by a .75 inch ball; threads shall show evidence of plate but thickness requirements are waived).

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

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

**EXAMPLE:** HST378PB8 = 1/4-28 Hi-Lite ST oversize collar, finish is Type II cadmium plate plus cetyl alcohol lube per Hi-Shear Spec. 305.

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>HST378</b>
			A-286 HIGH TEMPERATURE ALLOY	
			1/16 GRIP VARIATION, TENSION APPLICATION	
			FOR USE ON 1/64" AND 1/32" OVERSIZE HI-LITE PINS	
DATE	BY			
DRAWN	12-20-83	D.P.S.		
APPROVED	12-20-83	E.E.Beeles		
② REVISION	3-22-01	J.F.Obispo		