

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 IN. -LBS.
-5	5/32	8-32UNJC-3B	.365 .355	.095 .085	.255	.171	.370	.220	.355 .335	.280	.20	.254 .244	.085	1,400	15-30
-6	3/16	10-32UNJF-3B	.385 .355	.095 .085	.255	.198	.380	.230	.355 .335	.320	.20	.285 .274	.085	1,600	25-40
-8	1/4	1/4-28UNJF-3B	.475 .465	.120 .110	.333	.269	.450	.270	.420 .400	.380	.26	.346 .332	.090	3,000	60-90
-10	5/16	5/16-24UNJF-3B	.620 .610	.130 .120	.417	.322	.525	.315	.480 .460	.484	.34	.440 .425	.095	5,000	120-170
-12	3/8	3/8-24UNJF-3B	.685 .675	.145 .135	.490	.386	.585	.355	.530 .510	.557	.38	.503 .488	.095	7,000	180-240
-14	7/16	7/16-20UNJF-3B	.805 .795	.180 .170	.570	.447	.695	.405	.625 .605	.715	.45	.627 .615	.100	9,500	260-340
-16	1/2	1/2-20UNJF-3B	.915 .905	.205 .195	.648	.510	.755	.435	.680 .660	.763	.51	.690 .675	.100	12,500	360-460

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
2. Dimensions apply after finish.
3. For use on sloped surfaces up to 8° maximum on Hi-Lite ST pins.

MATERIAL: Collar — 7075 aluminum alloy per QQ-A-225/9.
Washer — 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

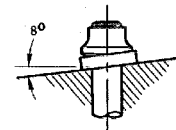
HEAT TREAT: Collar — Age to T73 condition per MIL-H-8088.
Washer — Age to H1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and PH15-7Mo per MIL-H-6875.

Collar — HST582-()A = Anodize per MIL-A-8625, dye color orange, and cetyl alcohol lube per Hi-Shear Spec. 305.
Washer — HST582-()W = Cadmium plate per QQ-P-416, Type I, Class 2 (no lube).

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 washer.
See "Finish" note for explanation of code letters.

EXAMPLE: HST582-8AW = Assembly of HST582-8A collar and HST582-8W washer.



U.S. Patents 4,326,325 and 4,485,510. Other U.S. and foreign patents pending. "Hi-Lite" is a registered trademark and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.

			TITLE	DRAWING NUMBER
DRAWN	6-9-83	D. P. S.	HI-LITE ST™ COLLAR SELF-ALIGNING COLLAR ASSEMBLY (ALUMINUM COLLAR — STAINLESS STEEL WASHER) 1/16" GRIP VARIATION — SHEAR APPLICATION (SPECIAL FOR McDONNELL)	HST582
APPROVED	6-9-83	<i>R. [Signature]</i>		
REVISION	12-19-89	D. P. S.		