



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-POUNDS
5	5/32	8-32UNJC-3B	.287 .283	.320	.173 .166	.395 .375	.220	.235	.400	.344	.314 .302	.085	.100	1,940	15-25
6	3/16	10-32UNJF-3B	.307 .303	.340	.212 .208	.405 .385	.230	.245	.410	.344	.314 .302	.085	.100	2,500	22-32
8	1/4	1/4-28UNJF-3B	.412 .408	.440	.272 .268	.475 .455	.270	.285	.480	.484	.440 .425	.090	.105	4,300	50-70
10	5/16	5/16-24UNJF-3B	.518 .512	.550	.336 .330	.555 .535	.315	.330	.590	.624	.565 .550	.095	.110	6,300	80-110
12	3/8	3/8-24UNJF-3B	.628 .622	.660	.398 .392	.625 .605	.355	.370	.630	.700	.628 .613	.095	.110	8,700	140-180
④ 14	7/16	7/16-20UNJF-3B	.733 .727	.777	.463 .457	.705 .685	.405	.420	.710	.840	.753 .736	.100	.115	12,100	190-250
④ 16	1/2	1/2-20UNJF-3B	.848 .842	.897	.528 .522	.765 .745	.435	.420	.770	.970	.878 .861	.100	.115	15,400	290-350

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 2. Dimensions apply after finish.
 3. Use HST171 for oversize replacement.

MATERIAL: Collar - 6Al-4V titanium alloy per AMS4928, AMS4930 or AMS4967, or
 - 3Al-2.5V titanium alloy per AMS4943 (MIL-T-9047).
 Washer - 300 series stainless steel.

FINISH: Collar - HST71TA() = Pretreat per Hi-Shear Ti-Shield III and Hi-Kote 2 solid film lube per Hi-Shear Spec. 292,
 and cetyl alcohol lube per Hi-Shear Spec. 305.
 Collar & Washer - HST71TAW() = Collar finish same as HST71TA() and washer is passivate.

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: HST71TA8 = 1/4-28 Hi-Lite ST collar.
 HST71TAW8 = 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.
DRAWN 9-30-85	J.F.O.	HI-LITE® ST™ COLLAR TITANIUM ALLOY 1/16 GRIP VARIATION, SHEAR APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LITE ST PINS	HST71
APPROVED 9-30-85	J. Rausch		
④ REVISION 6-24-08	P. Luu		