



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	.179 .169	.415 .395	.235	.250	.420	.344	.314 .302	.085	.100	3,050	22-32
6	3/16	10-32UNJF-3B	.307 .303	.340	.212 .208	.430 .410	.245	.260	.430	.344	.314 .302	.085	.100	4,000	30-40
8	1/4	1/4-28UNJF-3B	.413 .407	.445	.272 .268	.490 .470	.279	.295	.495	.380	.346 .332	.090	.105	7,500	75-95
10	5/16	5/16-24UNJF-3B	.518 .512	.550	.336 .330	.575 .555	.333	.343	.610	.484	.440 .425	.095	.110	11,750	170-200
12	3/8	3/8-24UNJF-3B	.628 .622	.660	.398 .392	.645 .625	.373	.388	.650	.557	.503 .488	.095	.110	18,000	260-300
14	7/16	7/16-20UNJF-3B	.733 .727	.765	.463 .457	.725 .705	.425	.440	.730	.840	.753 .736	.100	.115	23,250	400-450
16	1/2	1/2-20UNJF-3B	.848 .842	.880	.528 .522	.785 .765	.455	.470	.790	.970	.878 .861	.100	.115	32,000	500-575

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum.
 - Dimensions apply after finish.
 - Use HST374 for oversize replacement.
 - For use on Inconel 718 Hi-Lite pins heat treated to 125,000 psi shear minimum. Do not use on titanium pins.

MATERIAL: Collar - 17-4PH stainless steel per AMS5643.
Washer - 300 series stainless steel.

HEAT TREAT: Collar - To condition H1025 per AMS-H-6875.
Washer - None.

FINISH: Collar - HST74-() = Silver plate per AMS2410 (.0002-.0004 thick), dye color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST74DU() = Solid film lube per AS5272, Type I.
HST74DY() = Solid film lube per AS5272, Type I plus yellow identification on body of collar.
HST74LP() = Solid film lube per AS5272, Type II.
HST74PB() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST74TS() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305, plus white identification on body of collar.
HST74V() = Solid film lube per Lubeco 2123, Type II.
Collar & Washer - HST74DUW() = Both with solid film lube per AS5272, Type I.
HST74VW() = Both with Lubeco 2123 solid film lubricant.
HST74W() = Collar finish same as HST74-(), and washer is passivated per Hi-Shear Spec. 258.
HST74WV() = Collar finish same as HST74-(), and washer is solid film lube per Lubeco 2123.

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: HST74-8 = 1/4-28 Hi-Lite ST collar with silver plate.
HST74W8 = 1/4-28 Hi-Lite ST collar with silver plate and washer with passivate.

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.
			HI-LITE® ST™ COLLAR	HST74
			17-4PH STAINLESS STEEL	
			1/16" GRIP VARIATION, SHEAR APPLICATION	
			FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LITE ST PINS	
DRAWN	DATE	BY		
APPROVED	DATE	BY		
REVISION	DATE	BY		