



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B DIA.	L	L <sub>1</sub> (REF.)	P (REF.)	W HEX.	X (REF.)	UTS LBS. MIN.	TORQUE-OFF IN.-LBS.
-5	3										
-6	13/64 7/32	10-32UNJF-3B	.355 .345	.227 .223	.415 .395	.240	.380	.346 .332	.095	1,600	25-35
-8	17/64 9/32	1/4-28UNJF-3B	.440 .430	.290 .286	.485 .465	.280	.484	.440 .425	.100	3,000	60-80
-10	21/64 11/32	5/16-24UNJF-3B	.535 .525	.353 .347	.565 .545	.325	.484	.440 .425	.105	5,000	110-140
-12	25/64 13/32	3/8-24UNJF-3B	.635 .625	.416 .410	.635 .615	.365	.557	.503 .488	.105	7,000	160-200
-14	29/64 15/32	7/16-20UNJF-3B	.735 .725	.481 .475	.715 .695	.415	.624	.565 .550	.110	9,500	220-280
-16	33/64 17/32	1/2-20UNJF-3B	.850 .840	.543 .537	.775 .755	.445	.763	.690 .675	.110	12,500	340-410

- ① NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum.  
2. Dimensions apply after finish.  
3. Use 3/16 standard diameter pin and HST79-6 collar as oversize for 5/32 diameter.

MATERIAL: 7075 aluminum alloy per QQ-A-225/9.

HEAT TREAT: Age to T73 condition per MIL-H-6088.

FINISH: HST84CK-( ) = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HST84CY-( ) = Anodize per MIL-A-8625, dye color orange, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 381.

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

② EXAMPLE: HST84CK-8 = 1/4-28 Hi-Lite ST collar, anodized color black and cetyl alcohol lube.

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.

			TITLE	DRAWING NUMBER
DRAWN	12-2-83	D. P. S.	<b>HI-LITE<sup>®</sup> ST<sup>™</sup> COLLAR</b> 7075-T73 ALUMINUM ALLOY 1/16" GRIP VARIATION - SHEAR APPLICATION FOR USE ON 1/64" AND 1/32" OVERSIZE HI-LITE ST PINS	<b>HST84</b>
APPROVED	12-9-83	D. P. S.		
② REVISION	2-18-91	D. P. S.		