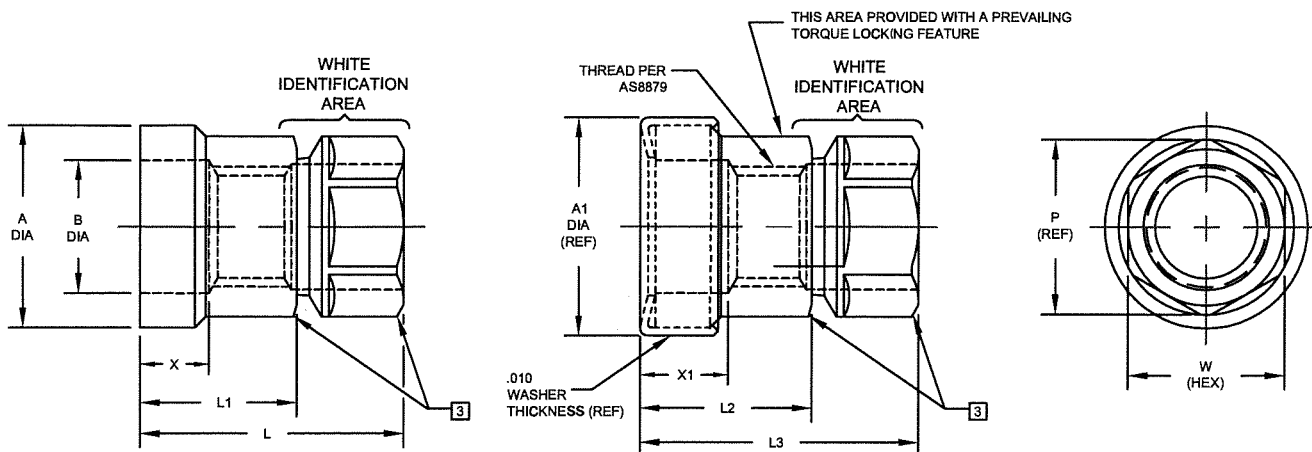




DASH NO.	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	UTS LBS. MIN	PRELOAD POUNDS	TORQUE-OFF INCH-LB. (REF)
5	5/32	8-32UNJC-3B	.287 .283	.320	.173 .169	.425 .405	.220	.235	.440	.250	.220 .213	.085	.100	1,940	1500 700	20
6	3/16	10-32UNJF-3B	.307 .303	.360	.212 .208	.435 .415	.230	.245	.450	.280	.251 .244	.085	.100	2,500	1800 800	30
8	1/4	1/4-28UNJF-3B	.412 .408	.460	.276 .272	.525 .505	.270	.285	.540	.350	.314 .302	.090	.105	4,300	3350 1500	70
10	5/16	5/16-24UNJF-3B	.518 .512	.570	.340 .334	.625 .605	.315	.330	.640	.420	.377 .365	.095	.110	6,300	4500 2500	125
12	3/8	3/8-24UNJF-3B	.628 .622	.680	.403 .397	.695 .675	.355	.370	.710	.490	.439 .425	.095	.110	8,700	6500 3500	180
14	7/16	7/16-20UNJF-3B	.713 .707	.780	.463 .457	.775 .755	.405	.420	.780	.560	.502 .490	.100	.115	12,100	9000 4725	250
16	1/2	1/2-20UNJF-3B	.815 .809	.877	.528 .522	.845 .825	.435	.450	.860	.632	.565 .550	.100	.120	15,300	12150 6250	375
18	9/16	9/16-18UNJF-3B	.915 .905	--	.598 .592	.950 .930	.520	--	--	.775	.690 .675	.105	--	19,000	15300 7250	TBD
20	5/8	5/8-18UNJF-3B	.995 .985	--	.661 .655	1.035 1.015	.575	--	--	.850	.753 .736	.105	--	23,000	18900 9000	TBD
24	3/4	3/4-16UNJF-3B	1.120 1.110	--	.786 .780	1.255 1.235	.755	--	--	.994	.878 .861	.120	--	30,700	27630 13750	TBD
28	7/8	7/8-14UNJF-3B	1.345 1.335	--	.916 .911	1.475 1.455	.895	--	--	1.140	1.003 .985	.125	--	45,000	37800 18750	TBD
32	1	1-12UNJF-3B	1.490 1.480	--	1.041 1.035	1.725 1.705	1.030	--	--	1.280	1.128 1.110	.130	--	60,900	49500 25000	TBD

NOTES:

- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
- Dimensions apply after finish.
- Burrs from cutoff process and cutting torque-off groove allowed.
- These are reference torque-off values only and shall not be used for acceptance or rejection of collars.
- For use on titanium Hi-Lite ST pins with Hi-Kote1 and cetyl alcohol lubricant.
- Locking torque, breakaway and preload are tested on epoxy chromate plate using prelaod releasing fixture
- Material 3AL-2.5V titanium to be used on dash -5 through -10 and 6AL-4V titanium to be used on dash -12 through -32.

MATERIAL:

Collar - 3AL-2.5V titanium per AMS4943 (MIL-T-9047).
 - 6AL-4V titanium alloy per AMS4928 or AMS4967.
 WT Washer - Commercial pure titanium per ASTM B 265, ASTM B 348. Minimum yield 25 KSI.
 DW Washer - 300 Series stainless steel.

FINISH:

Collar - HST1571YN() = Anodize per Hi-Shear Ti-Shield III and Hi-Kote 2 solid film lube per Hi-Shear spec 292, with color orange identification on barrel plus cetyl alcohol lube per Hi-Shear spec 305, and white identification.
 Collar & Washer -
 HST1571YNWT() = Collar finish same as HST1571YN.
 Washer finish per Hi-Shear spec 306, Type I, color brown, and cetyl alcohol lube per Hi-Shear spec 305.
 HST1571YNDW() = Collar finish same as HST1571YN.
 Washer finish is solid film lube per AS5272, Type I.

SPECIFICATION:

Hi-Lite product specification No. 381, except note 6, materials and preload as noted and test bolt is TB32VAP.

CODE:

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

EXAMPLE:

HST1571YN8 = 1/4-28 Hi-Lite ST collar.

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 1-6-94	J.F.Obispo	HI-LITE® ST™ COLLAR	HST1571
APPROVED 1-6-94	J.G. Wilcox	TITANIUM ALLOY	
REVISION 10-6-09	P. L	1/16 GRIP VARIATION, SHEAR APPLICATION FOR USE ON STANDARD AND 1/64" OVERSIZE HI-LITE PINS	