

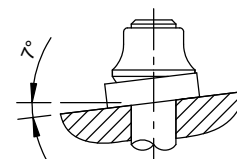
DASH NO.	PIN NOM DIA	THREAD	A DIA	B	C DIA (REF)	D DIA (REF)	L (REF)	L1 (REF)	M	P (REF)	R SPHER. RAD	W HEX	X (MAX)	UTS LBS. MIN	TORQUE-OFF INCH-POUNDS
5	5/32	.1640-32 UNJC-3B	.365 .355	.095 .085	.255	.171	.385	.220	.370 .350	.344	.20	.314 .302	.095	1,400	15-30
6	3/16	.1900-32 UNJF-3B	.365 .355	.095 .085	.255	.198	.395	.230	.370 .350	.380	.20	.346 .332	.095	1,600	25-40
8	1/4	.2500-28 UNJF-3B	.475 .465	.120 .110	.333	.259	.465	.270	.435 .415	.484	.26	.440 .425	.100	3,000	60-90
10	5/16	.3125-24 UNJF-3B	.620 .610	.130 .120	.417	.322	.545	.315	.500 .480	.484	.34	.440 .425	.105	5,000	110-160
12	3/8	.375-24 UNJF-3B	.685 .675	.145 .135	.490	.385	.615	.355	.560 .540	.557	.38	.503 .488	.105	7,000	160-220
14	7/16	.4375-20 UNJF-3B	.805 .795	.180 .170	.570	.447	.695	.405	.625 .605	.624	.45	.565 .550	.110	9,300	220-300
16	1/2	.5000-20 UNJF-3B	.915 .905	.205 .195	.648	.510	.755	.435	.680 .660	.763	.51	.690 .675	.110	12,500	340-430
18	9/16	.5625-18 UNJF-3B	1.125 1.115	.270 .260	.763	.575	.940	.520	.845 .825	.970	.71	.878 .861	.115	14,500	525-625
20	5/8	.6250-18 UNJF-3B	1.305 1.290	.315 .305	.855	.644	1.025	.575	.930 .910	1.120	.76	1.003 .986	.115	18,000	650-750

- NOTES:** ⑬ 1. Dimensions are in inches and apply after finish.
 2. For use on sloped surfaces up to 7° maximum on HI-LITE™ pins.
 ⑬ 3. After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: Collar - 7075 aluminum alloy per AMS-QQ-A-225/9.
 Washer - "C" - A-286 high temperature alloy per AMS5731 or AMS5737.
 "W" - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

HEAT TREAT: Collar - Age to T73 condition per AMS2770.
 Washer - "C" - 90,000 psi shear minimum.
 "W" - Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and 15-7Mo per AMS-H-6875.

FINISH: Collar - HST82CK()A = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST82CY()A = Anodize per MIL-A-8625, dye color orange, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST82D()A = Anodize per MIL-A-8625, color natural, and solid film lube per AS5272, Type I.
 Washer - HST82-()CPB = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 HST82-()CU = Passivate per Hi-Shear Spec. 258.
 HST82-()DW = Solid film lube per AS5272, Type I.
 HST82-()PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 HST82-()W = Cadmium plate per AMS-QQ-P-416, Type I, Class 2.
 HST82-()WU = Passivate per Hi-Shear Spec. 258.
 ⑬ ⑬ HST82-()EW = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 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.
 Code letter "A" following dash number indicates HI-LITE™ collar.
 See "Finish" note for explanation of other code letters.

EXAMPLES: HST82CY8ACPW = Assembly of HST82CY8A collar and HST82-8CPW washer.
 HST82CY8AW = Assembly of HST82CY8A collar and HST82-8W washer.
 HST82D8AWU = Assembly of HST82D8A collar and HST82-8WU washer.
 HST82D8ADW = Assembly of HST82D8A collar and HST82-8DW washer.

"HI-LITE" AND "HST" ARE INTERNATIONAL REGISTERED TRADEMARKS OF HI-SHEAR CORPORATION

			TITLE	DRAWING NO.
	DATE	BY	HI-LITE™ COLLAR SELF-ALIGNING COLLAR ASSEMBLY (ALUMINUM COLLAR, STAINLESS STEEL WASHER) 1/16 GRIP VARIATION, SHEAR APPLICATION	HST82 1 of 1
DRAWN	1983-06-01	D.P.S.		
APPROVED	1983-06-01	R.TING		
⑬ REVISION	2017-09-19	M.BEARD		