



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	.292 .288	.337	.173 .169	.395 .375	.220	.250	.415	.344	.314 .302	.085	.115	1,400	15-25
6	3/16	10-32UNJF-3B	.307 .303	.360	.200 .196	.405 .385	.230	.260	.425	.380	.346 .332	.085	.115	1,600	25-35
8	1/4	1/4-28UNJF-3B	.412 .408	.462	.261 .257	.475 .455	.270	.300	.495	.484	.440 .425	.090	.120	3,000	60-80
10	5/16	5/16-24UNJF-3B	.518 .512	.575	.325 .319	.555 .535	.315	.345	.575	.484	.440 .425	.095	.125	5,000	110-140
12	3/8	3/8-24UNJF-3B	.628 .622	.690	.388 .382	.625 .605	.355	.385	.645	.557	.503 .488	.095	.125	7,000	160-200
14	7/16	7/16-20UNJF-3B	.713 .707	.770	.450 .444	.705 .685	.405	.435	.725	.624	.565 .550	.100	.130	9,500	220-280
16	1/2	1/2-20UNJF-3B	.815 .809	.872	.513 .507	.765 .745	.435	.465	.785	.763	.690 .675	.100	.130	12,500	340-410
18	9/16	9/16-18UNJF-3B	.885 .875	.935	.579 .573	.875 .855	.520	.550	.895	.970	.878 .861	.105	---	14,500	500-575
20	5/8	5/8-18UNJF-3B	1.015 1.002	---	.647 .641	.960 .940	.575	---	---	1.120	1.003 .986	.105	---	18,000	625-700

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
  - Dimensions apply after finish.
  - Effective Aug. 1, 1999 HST79CY is inactive for design and procurement to BACC30BL.

**MATERIAL:** Collar - 7075 aluminum alloy per AMS-QQ-A-225/9. ⑩  
 Washer - "NW" = 300 series stainless steel, .010 thick.  
 "TW" = 2024 aluminum alloy per AMS-QQ-A-250/4 or AMS-QQ-A-250/5, .020 thick. ⑩  
 "WT" = Commercial pure titanium per MIL-T-9046, CP-4 composition, .010 thick.

**HEAT TREAT:** Collar - Age to T73 condition per AMS2770.  
 Washer - "NW" = None.  
 "TW" = Age to T6 condition per AMS2770.  
 "WT" = None.

**FINISH:** Collar - HST79CK( ) = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 ⑩ HST79CY( ) = Anodize per MIL-A-8625, dye color orange, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 Collar & Washer - HST79CKNW( ) = Collar finish same as HST79CK( ). Washer is passivated.  
 HST79CKTW( ) = Collar finish same as HST79CK( ). Washer finish is anodize per MIL-A-8625, dye color blue.  
 HST79CKWT( ) = Collar finish same as HST79CK( ). Washer finish per Hi-Shear Spec. 306, Type I, color yellow to brown, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HST79CYNW( ) = Collar finish same as HST79CY( ). Washer is passivated.  
 HST79CYTW( ) = Collar finish same as HST79CY( ). Washer finish is anodize per MIL-A-8625, dye color blue.  
 HST79CYWT( ) = Collar finish same as HST79CY( ). Washer finish per Hi-Shear Spec. 306, Type I, color yellow to brown, and cetyl alcohol lube per Hi-Shear Spec. 305.  
 HST79CYWY( ) = Collar finish same as HST79CY( ). Washer finish is solid film lube per AS5272, Type I.

**SPECIFICATION:** Hi-Lite Product Specification 381.

**CODE:** Dash number indicates nominal thread size in 1/32nds. "ALB" and "ALH" following dash number indicate collars on plastic rods, -5, -6 and -8 only. Rods for ALB have break point at base end of collars. Rods for ALH have break point at hex end of collars. See finish note for explanation of code letters.

**EXAMPLES:** HST79CY8 = .2500-28 Hi-Lite ST collar with color dye orange and cetyl alcohol lube.  
 HST79CY6ALB = .1640-32 Hi-Lite ST collar, packaged on rods with rod break point at base end of 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.
8-4-82	D.P.S.	<b>HI-LITE® ST™ COLLAR</b> 7075-T73 ALUMINUM ALLOY 1/16" GRIP VARIATION, SHEAR APPLICATION	<b>HST79</b>
8-4-82	E.E.Beeles		
10-27-10	JFO		
⑩ REVISION			