lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

Design Holder

CAGE No. 73197

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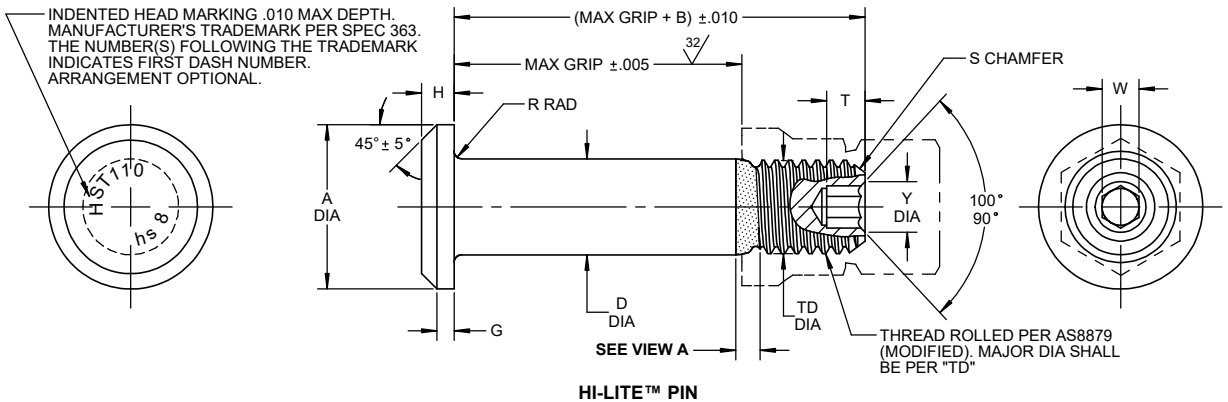
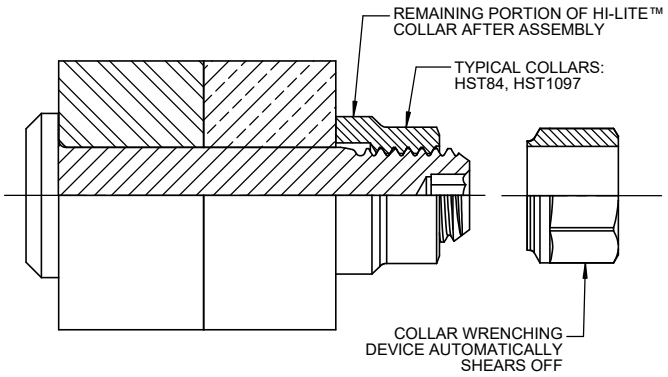


HI-LITE™ PIN

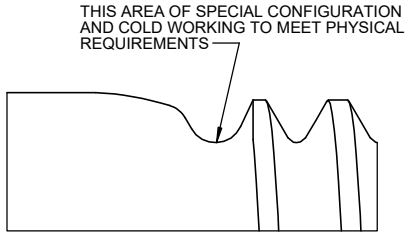


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

[5]

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA WITHOUT COATING OR SOLID FILM	D DIA AFTER COATING OR SOLID FILM	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	3/16						NOTE: USE HST10( )6-( )									
6	13/64	.315 .295	.300	.2026 .2021	.2026 .2016	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,130	2,500
8	17/64	.412 .387	.330	.2651 .2646	.2651 .2641	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	10,490	4,300
10	21/64	.505 .475	.390	.3276 .3271	.3276 .3266	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	16,000	6,300
12	25/64	.600 .565	.430	.3901 .3896	.3901 .3891	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	22,700	8,700
14	29/64	.676 .641	.495	.4526 .4521	.4526 .4516	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	30,600	12,100
16	33/64	.770 .735	.535	.5151 .5146	.5151 .5141	.4930 .4880	.050	.116 .103	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	39,600	15,300
18	37/64	.864 .829	.610	.5771 .5766	.5771 .5761	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	49,700	19,000
20	41/64	.953 .918	.670	.6396 .6391	.6396 .6386	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	61,000	23,000
24	49/64	1.108 1.066	.905	.7646 .7641	.7646 .7636	.7430 .7370	.070	.151 .136	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	87,200	30,700
28	57/64	1.285 1.241	1.010	.8896 .8891	.8896 .8886	.8680 .8610	.090	.187 .172	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.455 .425	.471 .451	118,000	45,000
32	1-1/64	1.468 1.424	1.170	1.0146 1.0141	1.0146 1.0136	.9930 .9860	.110	.218 .203	.060 .045	5/64 x 37°	1.0000-12 UNJF-3A	.5100 .5040	.580 .550	.618 .598	154,000	60,900

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.



VIEW A

HI-LITE™ THREAD TRANSITION AREA
SEE SPECIFICATION FOR INSPECTION

"HI-LITE", "HST", AND "HI-KOTE",
ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY	DATE
D.P.S.	1983-11-04
APPROVED	DATE
E.E.BEELES	1983-11-07
REVISION	DATE
20	K. PHAM 2022-06-20

TITLE
HI-LITE™ PIN
PROTRUDING SHEAR HEAD
TITANIUM
1/16 GRIP VARIATION, 1/64 OVERSIZE

DRAWING NUMBER
HST110

HST110

lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

GENERAL NOTES:
1. Concentricity: "A" diameter to "D" diameter within .010 FIM.
2. Dimensions are in inches and to be met after finish.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.

[5] Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.

[6] Broach petals removed.

7. Use HST410 for oversize replacement.

(20) [8] After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in the UK and European Union.

[9] After September 30th of 2015, HI-KOTE™ 4 coating per HS397 will be replaced by HI-KOTE™ 4 NC coating per HS397.

MATERIAL: 6AL-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum for sizes up to 3/4; 90,000 psi shear minimum for 7/8 and larger).

FINISH:
HST110-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.

(20) [8] HST110AG( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

(20) [8] HST110AP( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

(20) [8] HST110AZ( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST110BJ( )-( ) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST110BL( )-( ) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

[6] HST110CT( )-( ) = Color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST110CZ( )-( ) = Color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

[9] HST110HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

[6] HST110K( )-( ) = Solid film lube per "Lubeco™" 905. "LUBECO" is a trademark of Lubeco Incorporated.

[6] HST110MA( )-( ) = Solid film lube per "KalGard™" RA. "KALGARD" is a trademark of Metal Improvement Company.

HST110RP( )-( ) = Phosphate fluoride treat with color orange on thread end, and cetyl alcohol lube lube per Hi-Shear Spec. 305.

HST110RS( )-( ) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color orange on thread end.

HST110RV( )-( ) = Phosphate fluoride treat, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

(20) [8] HST110SU( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color light blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST110TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST110TF( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.

HST110UT( )-( ) = Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.

(20) HST110UV( )-( ) = Anodize per Hi-Shear Spec 306, Type II, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

(20) HST110VF( )-( ) = Anodize per Hi-Shear Spec 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.

(20) HST110WF( )-( ) = Anodize per Hi-Shear Spec 306, Type I, color blue, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

(20) [8] HST110GD( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST110YV( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 on threads only, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST110NKJ( )-( ) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST110NKK( )-( ) = Sulfuric acid anodizing per ISO8080 and HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST110NKL( )-( ) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST110NAP( )-( ) = HI-KOTE™ 1 NC Aluminum coating per Hi-Shear Spec. 294, Cetyl alcohol per Hi-Shear Spec. 305

SPECIFICATION: HI-LITE™ Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST110 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE: Pin Part Number
HST110AP8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

HST110

DRAWING NUMBER
HST110