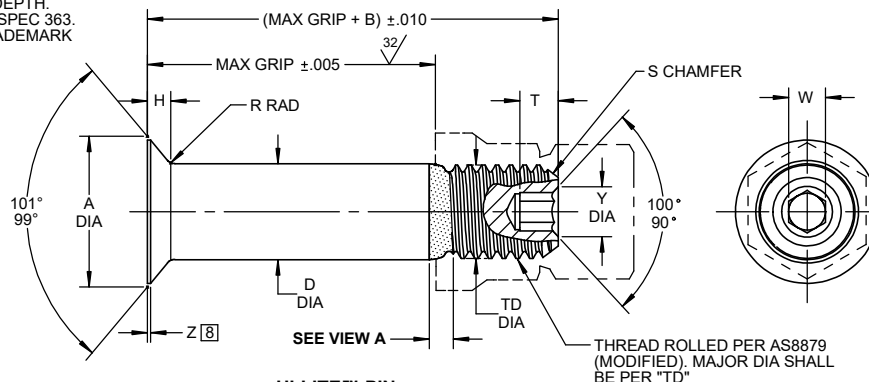
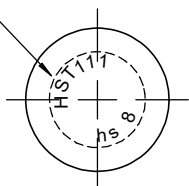
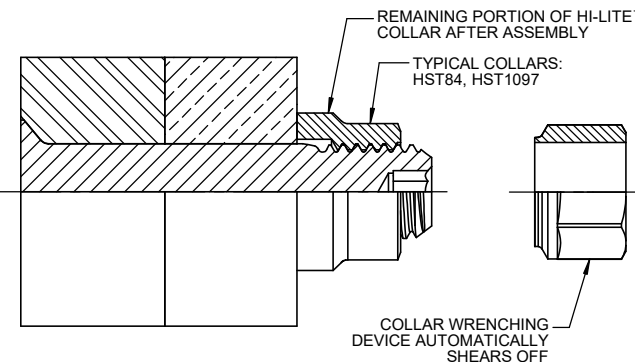


INDENTED HEAD MARKING .010 MAX DEPTH.  
MANUFACTURER'S TRADEMARK PER SPEC 363.  
THE NUMBER(S) FOLLOWING THE TRADEMARK  
INDICATES FIRST DASH NUMBER.  
ARRANGEMENT OPTIONAL.



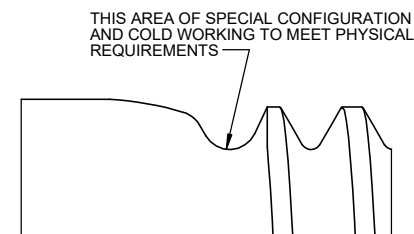
HI-LITE™ PIN



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

71																	
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM								W HEX	T DEPTH	Y DIA		
5	3/16						NOTE: USE HST11( )6(-)										
6	13/64	.3016 .2966	.300	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0415 .0394	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,130	2,000
8	17/64	.3948 .3898	.330	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0544 .0523	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	10,490	3,700
10	21/64	.4739 .4689	.390	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0614 .0593	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	16,000	5,000
12	25/64	.5604 .5554	.430	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0714 .0693	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	22,700	7,200
14	29/64	.6680 .6620	.495	.4526 .4521	.4526 .4516	.4310 .4260	.009	.0904 .0879	.050 .040	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	30,600	10,000
16	33/64	.7540 .7480	.535	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1002 .0977	.050 .040	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	39,600	13,500
18	37/64	.8380 .8310	.610	.5771 .5766	.5771 .5761	.5550 .5500	.010	.1094 .1065	.050 .040	.022	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	49,700	17,000
20	41/64	.9250 .9180	.670	.6396 .6391	.6396 .6386	.6180 .6120	.010	.1197 .1168	.050 .040	.022	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	61,000	21,000
24	49/64	1.0970 1.0850	.905	.7646 .7641	.7646 .7636	.7430 .7370	.012	.1394 .1344	.050 .040	.022	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	87,200	30,700
28	57/64	1.3197 1.3030	1.010	.8896 .8891	.8896 .8886	.8680 .8610	.014	.1804 .1734	.050 .040	.022	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.455 .425	.471 .451	118,000	42,000
32	1-1/64	1.5186 1.4995	1.170	1.0146 1.0141	1.0146 1.0136	.9930 .9860	.014	.2114 .2034	.050 .040	.022	5/64 x 37°	1.0000-12 UNJF-3A	.5100 .5040	.580 .550	.618 .598	154,000	55,000



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 J.OBISPO	DATE 1983-11-04	TITLE HI-LITE™ PIN 100° FLUSH SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED E.E.BEELES	DATE 1983-11-07	
REVISION 19	DATE K. PHAM 2022-06-20	DRAWING NUMBER <b>HST111</b>

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
  2. Concentricity: Conical surface of head to "D" diameter within .003 FIM.
  3. "H" is dimensioned from maximum "D" diameter.
  4. Dimensions are in inches and to be met after finish.
  5. Surface texture per ASME B46.1.
  6. Hole preparation per NAS618.
  - 7 Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
  - 8 Curved or flat edge manufacturer's option.
  - 9 Broach petals removed.
  10. Use HST411 for oversize replacement.
  - 11 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.
  - 12 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:** HST111-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.
- 11 HST111AG( )-( ) = 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.
- 11 HST111AP( )-( ) = 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.
- 11 HST111AZ( )-( ) = 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.
- HST111BJ( )-( ) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST111BL( )-( ) = 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.
- 9 HST111CT( )-( ) = Color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 12 HST111HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397
- 9 HST111K( )-( ) = Solid film lube per "Lubeco™ 905". "LUBECO" is a trademark of Lubeco Incorporated.
- 11 HST111KM( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 9 HST111MA( )-( ) = Solid film lube per "KalGard™ RA". "KALGARD" is a trademark of Metal Improvement Company.
- HST111RP( )-( ) = Phosphate fluoride treat with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST111RS( )-( ) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color orange on thread end.
- HST111SY( )-( ) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color red on thread end.
- HST111TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST111TF( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- 11 HST111WF( )-( ) = 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.
- HST111YV( )-( ) = 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.
- HST111NKJ( )-( ) = 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.
- HST111NKK( )-( ) = 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.
- HST111NKL( )-( ) = 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.
- HST111NAP( )-( ) = HI-KOTE™ 1 NC Aluminum Coating per Hi-Shear Spec. 294, cetyl alcohol lube 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 HST111 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  
 HST111AP8-8

8/16 or 1/2 Maximum Grip Length  
 8/32 or 1/4 Nominal Diameter Pin  
 Finish Code  
 Pin Basic Part Number

HST111

DRAWING NUMBER

**HST111**

2 OF 2