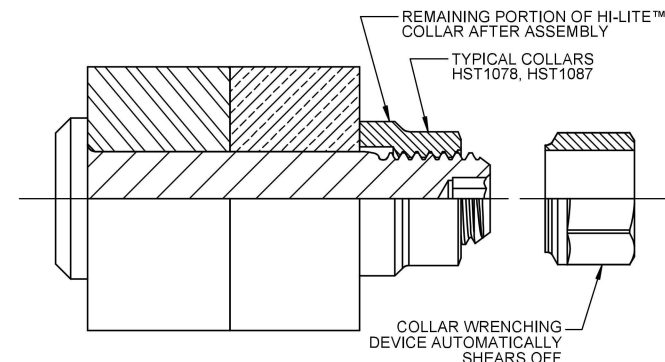
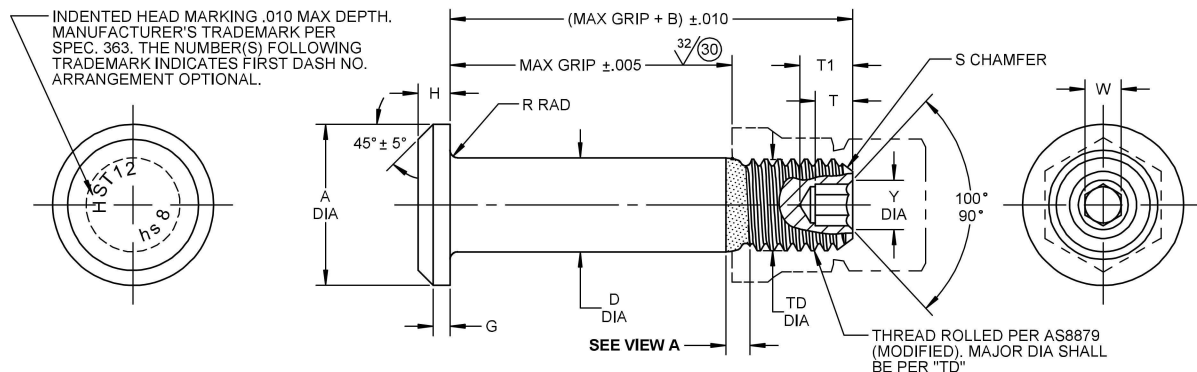
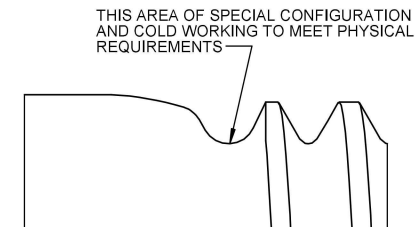


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FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM							W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA		
5	5/32	.322 .306	.280	.1635 .1630	.1635 .1625	.1595 .1570	.030	.065 .055	.025 .015	1/32 x 37°	.1640-32 UNJC-3A	.0801 .0791	.080	.135	.104 .094	4,010	2,180
6	3/16	.377 .357	.290	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.080	.135	.119 .104	5,380	3,180
8	1/4	.440 .415	.320	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.090	.160	.142 .122	9,300	5,820
10	5/16	.505 .475	.380	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.110	.200	.180 .160	14,600	9,200
12	3/8	.600 .565	.420	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.140	.235	.217 .197	21,000	14,000
14	7/16	.676 .641	.500	.4370 .4365	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.150	.246	.253 .233	28,600	18,900
16	1/2	.770 .735	.600	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.170	.275	.289 .269	37,300	25,600
18	9/16	.877 .842	.700	.5615 .5610	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.200	.329	.326 .306	47,200	32,400
20	5/8	.953 .918	.780	.6240 .6235	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.210	.339	.326 .306	58,300	41,000
24	3/4	1.150 1.110	1.020	.7490 .7485	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.290	.452	.398 .378	83,900	59,500
28	7/8	1.330 1.290	1.160	.8740 .8735	.8740 .8730	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.340	.525	.471 .451	107,000	77,500
32	1	1.510 1.470	1.305	.9990 .9985	.9990 .9980	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 37°	1.0000-12 UNJF-3A	.5100 .5040	.460	.682	.618 .598	140,000	100,900

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
 J.F. OBISPO

DATE
 2014-08-18

D.P.S.

1983-03-18

APPROVED
 R. TING

DATE
 1983-03-18

REVISION
 30

DATE
 K. PHAM
 2022-03-14

TITLE
HI-LITE™ PIN
PROTRUDING TENSION HEAD
TITANIUM
1/16 GRIP VARIATION

DRAWING NUMBER
HST12

- 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 HST112 for oversize replacement.
 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 UK & 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:**
- HST12(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST12AB(-)(-) = I.V.D. aluminum coating per BAC5315 with conversion coating (.0003-.0005 thick) per MIL-DTL-5541, Class 1A and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 30 8 HST12AG(-)(-) = 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.
 - 30 8 HST12AP(-)(-) = 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.
 - 30 8 HST12AZ(-)(-) = 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.
 - HST12BJ(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 6 HST12CT(-)(-) = Color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST12CZ(-)(-) = Color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 30 8 HST12GD(-)(-) = 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.
 - 9 HST12HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
 - 6 HST12K(-)(-) = Solid film lube per "Lubeco" 905.
 - 6 HST12MA(-)(-) = Solid film lube per KalGard RA.
 - HST12NAP(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 30 HST12NGD(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST12RP(-)(-) = Phosphate fluoride treat with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST12RS(-)(-) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color orange on thread end.
 - HST12RV(-)(-) = Phosphate fluoride treat, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 30 8 HST12SU(-)(-) = 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.
 - HST12TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST12UV(-)(-) = 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.
 - HST12WF(-)(-) = 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.
 - HST12YW(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 on threads only, with color white on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 30 8 HST12GM(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC Aluminum Coating per HS294 on threads only and top of head only, Cetyl Alcohol Lube per HS305, white on thread end.

SPECIFICATION: HI-LITE™ Product Specification 380.

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

**HOW TO ORDER
EXAMPLE:**

Pin Part Number
 HST12AP8-8

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