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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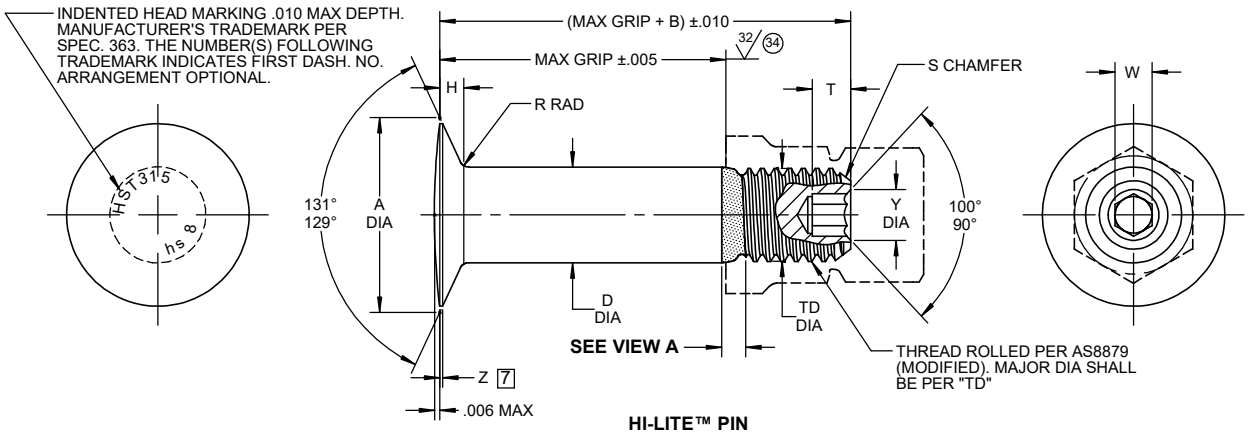
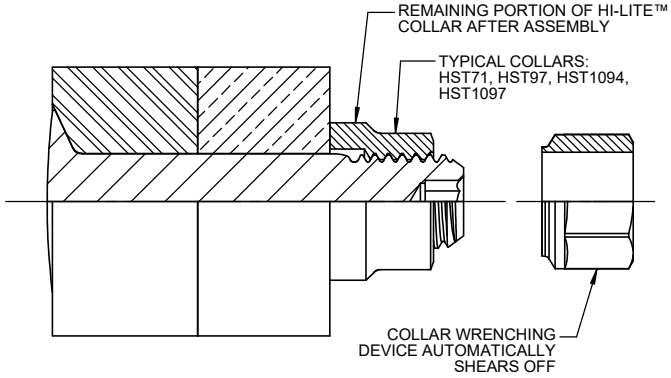


HI-LITE™ PIN

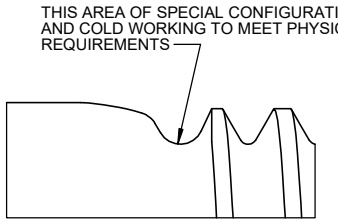


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

1

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	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	5/32	.3393 .3308	.280	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.012	1/32 x 37°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	.104 .094	4,010	1,650
6	3/16	.3911 .3825	.290	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,380	2,000
7	7/32	.4468 .4382	.305	.2182 .2177	.2182 .2172	.2100 .2070	.006	.0535 .0516	.030 .020	.015	1/32 x 37°	.2160-28 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,100	2,600
8	1/4	.5111 .5026	.320	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,300	3,700
10	5/16	.6037 .5951	.380	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,600	5,000
12	3/8	.7090 .7005	.420	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,000	7,200
14	7/16	.8526 .8419	.485	.4370 .4365	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 040	.020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	28,600	10,000

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	TITLE
J.OBISPO	1985-11-18	HI-LITE™ PIN 130° FLUSH CROWN SHEAR HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED E.E.Beeles	DATE 1985-11-18	
REVISION 34	DATE K. PHAM 2022-06-20	DRAWING NUMBER **HST315**

1 OF 2

HST315

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GENERAL NOTES:
1. [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. [7] Curved or flat edge manufacturer's option.
8. [8] Non-lubed pins must be used with lubed collars.
9. [9] Complete solid film lube coverage of threads and HI-LITE™ transition area required. Overspray on "D" diameter permissible.
10. Use HST415 for oversize replacement.
11. (34) [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.

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

HEAT TREAT: 95,000 psi shear minimum.

FINISH:
HST315-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.
(34) [11] HST315AG( )-( ) = 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.
(34) [11] HST315AP( )-( ) = 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.
HST315BJ( )-( ) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
(34) [9] HST315BS( )-( ) = Anodize per Hi-Shear Spec 306, Type I, color blue, with HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, except no solid film lube allowed on the head or "R" radius, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST315CE( )-( ) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, (.00015-.00045 thick). with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST315CF( )-( ) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, (.00015-.00045 thick). with color black on thread end.
HST315CZ( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305, with color black on thread end.
(34) [11] HST315GD( )-( ) = 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.
(34) [11] HST315GM( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads (no overspray on the shank allowed) and top of head only (.005 max overspray on the head bearing surface permissible) with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
(34) [11] HST315HF( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads (no overspray on the shank allowed) and top of head only (.005 max overspray on the head bearing surface permissible) and cetyl alcohol lube per Hi-Shear Spec. 305.
(34) [11] HST315KM( )-( ) = 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.
(34) [11] HST315KV( )-( ) = Sulfuric acid anodizing per ISO8080 and 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.
[8] HST315RN( )-( ) = Phosphate fluoride treat, no lube.
HST315RP( )-( ) = Phosphate fluoride treat with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST315SY( )-( ) = Phosphate fluoride treat, solid film lube per AS5272, Type I with color red on thread end.
HST315TA( )-( ) = Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST315TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST315UT( )-( ) = Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
(34) HST315UV( )-( ) = 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.
(34) HST315WF( )-( ) = 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.
HST315YV( )-( ) = 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.
HST315NAP( )-( ) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST315NKJ( )-( ) = 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.
HST315NKK( )-( ) = 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.
HST315NKL( )-( ) = 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.
HST315HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

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
HST315AP8-8
- HST315 — Pin Basic Part Number
- AP — Finish Code
- 8 — 8/32 or 1/4 Nominal Diameter Pin
- 8 — 8/16 or 1/2 Maximum Grip Length

HST315

DRAWING NUMBER
HST315 2 of 2