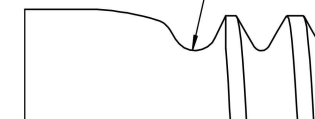


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

THIS AREA OF SPECIAL CONFIGURATION
 AND COLD WORKING TO MEET PHYSICAL
 REQUIREMENTS



VIEW A

HI-LITE™ THREAD TRANSITION AREA
 SEE SPECIFICATION FOR INSPECTION

[9]																	[1]	
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						NOTE: USE HST315()6-()												
6	13/64	.3911 .3825	.300	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0440 .0420	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,130	2,000	
8	17/64	.5111 .5026	.330	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0580 .0560	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	10,490	3,700	
10	21/64	.6037 .5951	.390	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0650 .0630	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	16,000	5,000	
12	25/64	.7090 .7005	.430	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0750 .0730	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	22,700	7,200	
14	29/64	.8526 .8419	.495	.4526 .4521	.4526 .4516	.4310 .4260	.009	.0930 .0910	.050 .040	.020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	30,600	10,000	

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

DRAWN BY J. OBISPO	DATE 1986-08-01	TITLE HI-LITE™ PIN 130° FLUSH CROWN SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED E.E. BEELES	DATE 1986-09-09		
REVISION 12	DATE K. PHAM 2022-03-15	DRAWING NUMBER HST415	

- 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 Curved or flat edge manufacturer's option.
 - 8 Non-lubed pins must be used with lubed collars.
 - 9 Complete solid film lube coverage of threads and Hi-Lite transition area required. Overspray on "D" diameter permissible.
 10. Use HST515 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 UK and European Union.

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

HEAT TREAT: 95,000 psi shear minimum.

- FINISH:**
- HST415(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
- 12 11 HST415AG(-)(-) = 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.
- 12 11 HST415AP(-)(-) = 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.
- HST415BJ(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 12 9 HST415BS(-)(-) = 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.
- HST415CE(-)(-) = 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.
- HST415CF(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, (.00015-.00045 thick), with color black on thread end.
- HST415CZ(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305, with color black on thread end.
- 12 11 HST415GD(-)(-) = 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.
- 12 11 HST415GM(-)(-) = 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.
- 12 11 HST415HF(-)(-) = 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.
- 12 11 HST415KM(-)(-) = 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.
- 12 11 HST415KV(-)(-) = 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 HST415RN(-)(-) = Phosphate fluoride treat, no lube.
- HST415RP(-)(-) = Phosphate fluoride treat with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST415SY(-)(-) = Phosphate fluoride treat, solid film lube per AS5272, Type I with color red on thread end.
- HST415TA(-)(-) = Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST415TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST415UT(-)(-) = Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- 12 HST415UV(-)(-) = 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.
- 12 HST415WF(-)(-) = 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.
- HST415YV(-)(-) = 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.

- HST415NKJ(-)(-) = 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.
- HST415NKK(-)(-) = 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.
- HST415NKL(-)(-) = 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.
- HST415HK(-)(-) = 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 of the pin which this HST415 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER
EXAMPLE:**

