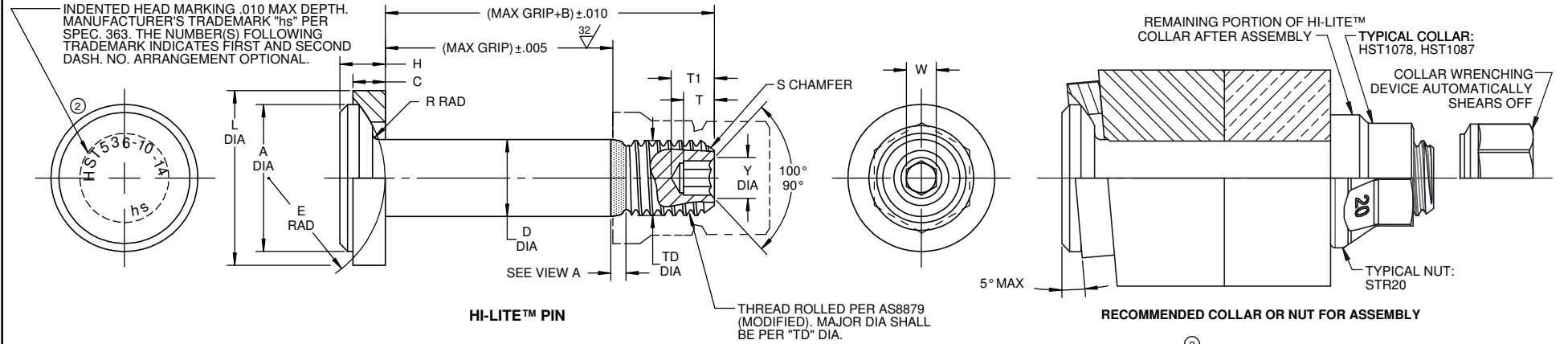


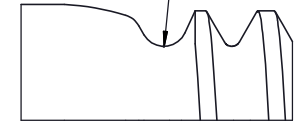


②

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

FIRST DASH NO.	PIN NOM DIA	A DIA REF	B REF	C MAX	D DIA		TD DIA	E RAD REF	H MAX	L MAX	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS MAX
					WITHOUT COATING	AFTER COATING								W HEX	T1 DEPTH MAX	T DEPTH MIN	Y DIA			
6	3/16	.374	.290	.087	.1895 .1890	.1895 .1885	.1840 .1810	.315	.121	.463	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.135	.080	.119 .104	5,380	3,181	1,050
7	7/32	.411	.305	.092	.2182 .2177	.2182 .2172	.2100 .2070	.334	.130	.501	.025 .015	1/32 x 37°	.2160-28 UNJF-3A	.0806 .0791	.135	.080	.119 .104	7,194	4,002	1,360
8	1/4	.477	.320	.110	.2495 .2490	.2495 .2485	.2440 .2410	.377	.159	.571	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.149	.090	.142 .122	9,300	5,823	1,950
10	5/16	.567	.380	.127	.3120 .3115	.3120 .3110	.3060 .3020	.440	.191	.712	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.163	.098	.180 .160	14,600	9,200	3,140
12	3/8	.656	.420	.145	.3745 .3740	.3745 .3735	.3680 .3640	.502	.238	.847	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.207	.125	.217 .197	21,000	14,000	4,850
14	7/16	.746	.485	.162	.4370 .4365	.4370 .4360	.4310 .4260	.565	.269	.986	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.235	.152	.253 .233	28,600	17,670	6,110
16	1/2	.835	.525	.181	.4995 .4990	.4995 .4985	.4930 .4880	.627	.307	1.193	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.271	.179	.289 .269	37,300	23,942	8,340
18	9/16	1.053	.600	.305	.5615 .5610	.5615 .5605	.5550 .5500	.690	.384	1.310	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.318	.215	.326 .306	47,200	28,348	9,890
20	5/8	1.132	.640	.321	.6240 .6235	.6240 .6230	.6180 .6120	.752	.409	1.440	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.318	.215	.326 .306	58,300	38,352	13,470
24	3/4	1.293	.895	.360	.7490 .7485	.7490 .7480	.7430 .7370	.877	.551	1.691	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.388	.269	.398 .378	83,900	55,600	19,400

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



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 AIRCAD	DATE 2015-07-28	TITLE HI-LITE™ PIN SELF-ALIGNING HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED J.GOYER	DATE 2015-07-28	
REVISION ②	DATE F.CARINGELLA 2018-09-03	DRAWING NUMBER HST536

FINISH TABLE:

PART	FINISH CODE	FINISH	LUBE	IDENTIFICATION
PIN	DD	SULFURIC-ACID ANODIZING PER ISO8080	CETYL ALCOHOL LUBE PER HI-SHEAR SPEC. 305	NONE
	NAP	HI-KOTE™ 1 NC ALUMINUM PIGMENTED COATING PER HI-SHEAR SPEC. 294	CETYL ALCOHOL LUBE PER HI-SHEAR SPEC. 305	NONE
	NKY	SULFURIC-ACID ANODIZING PER ISO8080 PLUS HI-KOTE™ 1 NC ALUMINUM PIGMENTED COATING PER HI-SHEAR SPEC. 294 ON THREADS ONLY	CETYL ALCOHOL LUBE PER HI-SHEAR SPEC. 305	NONE
WASHER	NAT	HI-KOTE™ 1 NC ALUMINUM PIGMENTED COATING PER HI-SHEAR SPEC. 294	NONE	NONE
	NS	SULFURIC-ACID ANODIZING PER ISO8080	NONE	NONE

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions in inches and to be met after finish. Strengths and loads are in LBS.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Use HST636 for oversize replacement.

MATERIAL: Pin = 6Al-4V titanium alloy per AMS4928 or AMS4967.
 Washer = 6Al-4V titanium alloy per AMS4928 or AMS4967.

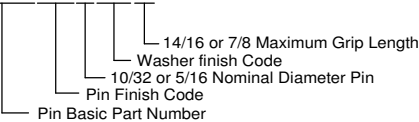
HEAT TREAT: Pin = 160,000 psi tensile minimum and 95,000 psi shear minimum.
 Washer = 160,000 psi tensile minimum and 95,000 psi shear minimum.

SPECIFICATION: HI-LITE™ Product Specification 414 excepted as noted.

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

HOW TO ORDER

EXAMPLE: Pin-Washer Assembly Part Number
 HST536NAP10NAT14



HST536

DRAWING NUMBER

HST536

2 OF 2