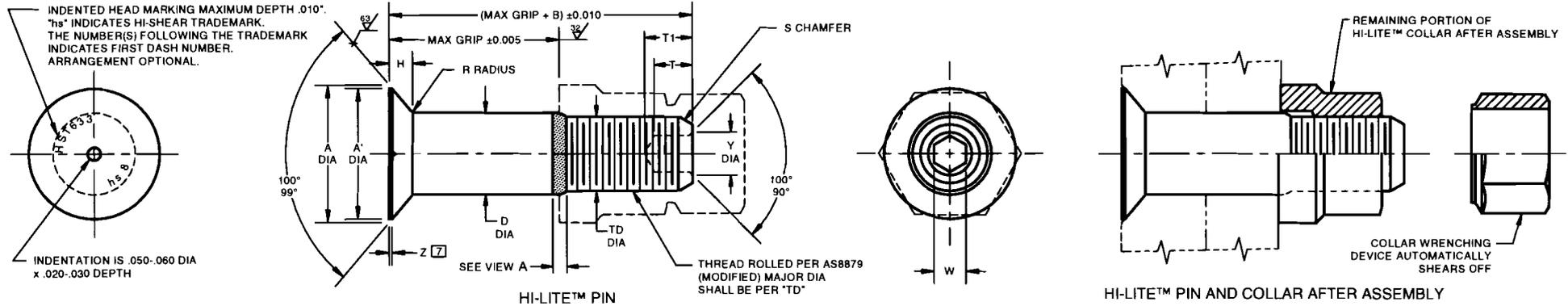




hi-shear corporation
2800 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90508 U.S.A.

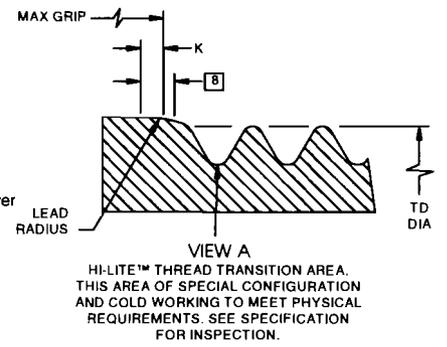


HI-LITE™ PIN

HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	A' DIA MIN	B REF	D DIA BEFORE FINISH	TD DIA	H	K MAX	R RAD	Z MAX	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM		
													W HEX	T DEPTH	Y DIA				
5	5/32				NOTE: USE HST533-6(-)														
6	13/64	.3813 .3765	.349	.325	.2026 .2021	.1840 .1810	.005	.0750 .0730	.016	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	3,180	
8	17/64	.5066 .5018	.475	.395	.2651 .2646	.2440 .2410	.006	.1013 .0993	.021	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	5,820	
10	21/64	.6335 .6287	.602	.500	.3276 .3271	.3060 .3020	.007	.1283 .1263	.026	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	9,200	
12	25/64	.7604 .7556	.729	.545	.3901 .3896	.3680 .3640	.008	.1553 .1533	.030	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	14,000	
14	29/64	.8884 .8812	.840	.635	.4526 .4521	.4310 .4260	.009	.1828 .1798	.035	.050 .040	.022	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	18,900	
16	33/64	1.0139 1.0068	.965	.685	.5151 .5146	.4930 .4880	.010	.2093 .2063	.039	.050 .040	.022	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	39,600	25,600	
18	37/64	1.1408 1.1337	1.085	.770	.5771 .5766	.5550 .5500	.010	.2365 .2335	.039	.050 .040	.025	1/16" x 37°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	49,700	32,400	
20	41/64	1.2723 1.2651	1.217	.825	.6396 .6391	.6180 .6120	.010	.2654 .2624	.041	.050 .040	.025	1/16" x 37°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	61,000	41,000	

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



- GENERAL NOTES:
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
 - "D" diameter may increase by .0005" after application of solid film lube, and .001" after application of coating.
 - Use HST733 for oversize replacement.

- HST633NKK(-)(-) = 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 lubepcr Hi-Shear Spec. 305.
- HST633NKL(-)(-) = 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.

SPECIFICATION: HI-LITE™ Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST633 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

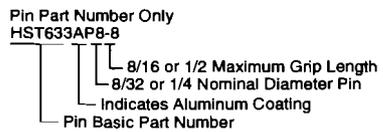
MATERIAL: 6AL-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HST633DL(-)(-) = Kalgard FA or EM620C solid film lube per AS5272, Type 1 and cetyl alcohol lube per Hi-Shear Spec. 305.
HST633AP(-)(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST633NKJ(-)(-) = 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.

HOW TO ORDER EXAMPLE:



"HI-LITE", "HST", and "HI-KOTE", are Trademarks of Hi-Shear Corporation.	
DRAWN BY D.P.S.	DATE 10-19-89
APPROVED DAW	DATE 10-19-89
REVISION ②	DATE F. CARINGELLA 10-2-13
TITLE HI-LITE™ PIN 100° FLUSH MS24694 TENSION HEAD TITANIUM 1/16" GRIP VARIATION, 1/64" OVERSIZE DRAWING NUMBER HST633	
1 OF 1	

HST633