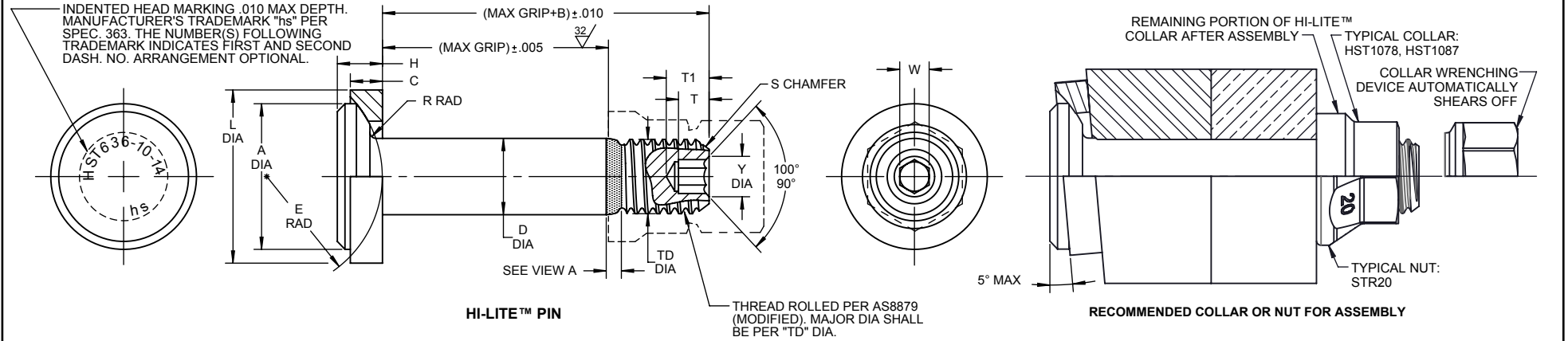
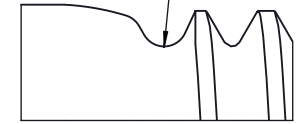




SEE COLLAR/NUT STANDARDS FOR COLLAR/NUT STRENGTHS. LOWER STRENGTH (PIN OR COLLAR/NUT) DETERMINES SYSTEM STRENGTH.

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	13/64	.374	.300	.087	.2026 .2021	.2026 .2016	.1840 .1810	.315	.121	.463	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.135	.080	.119 .104	6,130	3,181	1,050
7	15/64	.411	.315	.092	.2338 .2333	.2338 .2328	.2100 .2070	.334	.130	.501	.025 .015	1/32 x 37°	.2160-28 UNJF-3A	.0806 .0791	.135	.080	.119 .104	8,160	4,002	1,360
8	17/64	.477	.330	.110	.2651 .2646	.2651 .2641	.2440 .2410	.377	.159	.571	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.149	.090	.142 .122	10,490	5,823	1,950
10	21/64	.567	.390	.127	.3276 .3271	.3276 .3266	.3060 .3020	.440	.191	.712	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.163	.098	.180 .160	16,000	9,200	3,140
12	25/64	.656	.430	.145	.3901 .3896	.3901 .3891	.3680 .3640	.502	.238	.847	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.207	.125	.217 .197	22,700	14,000	4,850
14	29/64	.746	.495	.162	.4526 .4521	.4526 .4516	.4310 .4260	.565	.269	.986	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.235	.152	.253 .233	30,800	17,670	6,110
16	33/64	.835	.535	.181	.5151 .5146	.5151 .5141	.4930 .4880	.627	.307	1.193	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.271	.179	.289 .269	39,600	23,942	8,340
18	37/64	1.053	.610	.305	.5771 .5766	.5771 .5761	.5550 .5500	.690	.384	1.310	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.318	.215	.326 .306	49,900	28,348	9,890
20	41/64	1.132	.650	.321	.6396 .6391	.6396 .6386	.6180 .6120	.752	.409	1.440	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.318	.215	.326 .306	61,200	38,352	13,470
24	49/64	1.293	.905	.360	.7646 .7641	.7646 .7636	.7430 .7370	.877	.551	1.691	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.388	.269	.398 .378	87,400	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 F. CARINGELLA		DATE 2018-09-03		TITLE HI-LITE™ PIN SELF-ALIGNING HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED J. LO		DATE 2018-09-03			
REVISION 1		DATE		DRAWING NUMBER HST636	
				1 OF 2	

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.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Use HST736 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 except as noted.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HST636 oversize pin replaces.
 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
 HST636NAP10NAT14

