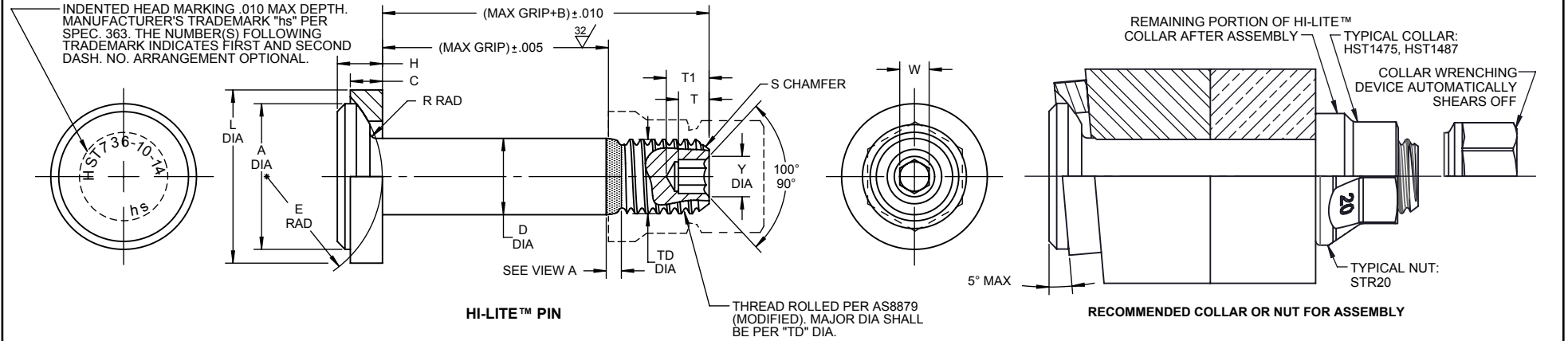
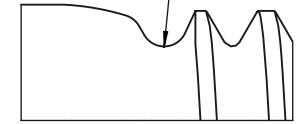




SEE COLLAR/NUT STANDARDS FOR COLLAR/NUT STRENGTHS. LOWER STRENGTH (PIN OR COLLAR/NUT) DETERMINES SYSTEM STRENGTH.

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			
8	9/32	.477	.330	.110	.2807 .2802	.2807 .2797	.2440 .2410	.377	.159	.571	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.149	.090	.142 .122	11,800	5,823	1,950
10	11/32	.567	.390	.127	.3432 .3427	.3432 .3422	.3060 .3020	.440	.191	.712	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.163	.098	.180 .160	17,600	9,200	3,140
12	13/32	.656	.430	.145	.4057 .4052	.4057 .4047	.3680 .3640	.502	.238	.847	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.207	.125	.217 .197	24,600	14,000	4,850
14	15/32	.746	.495	.162	.4682 .4677	.4682 .4672	.4310 .4260	.565	.269	.986	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.235	.152	.253 .233	32,700	17,670	6,110
16	17/32	.835	.535	.181	.5307 .5302	.5307 .5297	.4930 .4880	.627	.307	1.193	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.271	.179	.289 .269	42,000	23,942	8,340
18	19/32	1.053	.610	.305	.5927 .5922	.5927 .5917	.5550 .5500	.690	.384	1.310	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.318	.215	.326 .306	52,600	28,348	9,890
20	21/32	1.132	.650	.321	.6552 .6547	.6552 .6542	.6180 .6120	.752	.409	1.440	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.318	.215	.326 .306	64,300	38,352	13,470
24	25/32	1.293	.905	.360	.7802 .7797	.7802 .7792	.7430 .7370	.877	.551	1.691	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.388	.269	.398 .378	91,000	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 2018-09-04	TITLE HI-LITE™ PIN SELF-ALIGNING HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED C. REITZ	DATE 2018-09-04	
REVISION 1	DATE	DRAWING NUMBER HST736

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 HST1536 for oversize replacement.

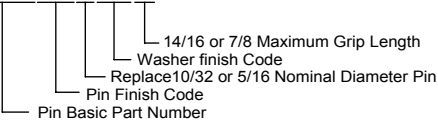
MATERIAL: Pin = 6Al-4V titanium alloy per AMS4928 or AMS4967.
 Washer = 6Al-4V titanium alloy per AMS4928 or AMS4967.

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 HST736 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
 HST736NAP10NAT14



HST736