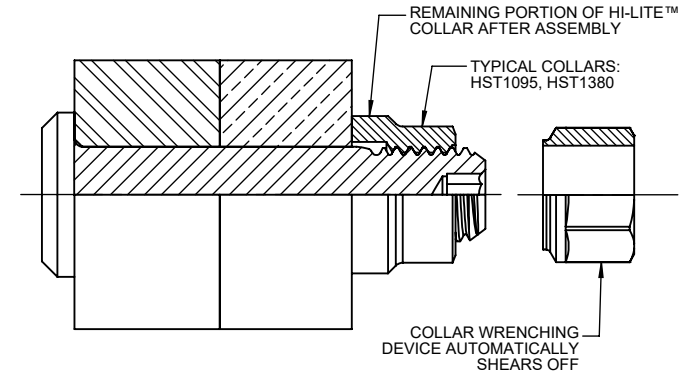
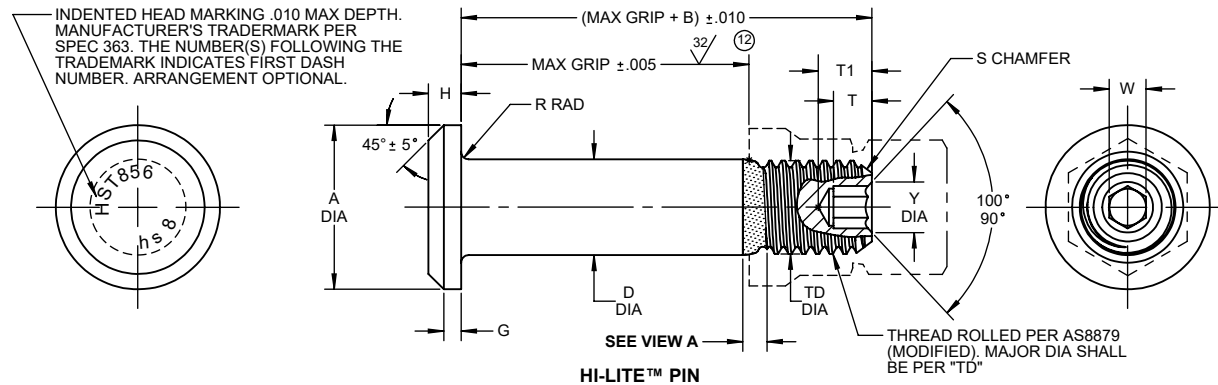




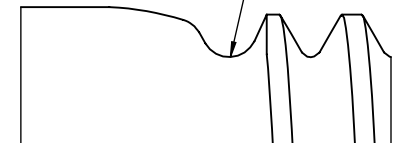
HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

12

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION TENSILE FATIGUE POUNDS MAXIMUM
				WITHOUT COATING	WITH COATING							W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA			
5	3/16					NOTE: USE HST756()6-()												
6	13/64	.377 .357	.300	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.080	.135	.119 .104	6,130	3,180	1,050
8	17/64	.440 .415	.330	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.090	.160	.142 .122	10,490	5,820	1,950
10	21/64	.505 .475	.390	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.110	.200	.180 .160	16,000	9,200	3,140
12	25/64	.600 .565	.430	.3901 .3896	.3901 .3891	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.140	.235	.217 .197	22,700	14,000	4,850
14	29/64	.676 .641	.510	.4526 .4521	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.170	.275	.253 .233	30,600	17,670	6,120
16	33/64	.770 .735	.610	.5151 .5146	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.200	.315	.289 .269	39,600	23,940	8,340
18	37/64	.877 .842	.710	.5771 .5766	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	49,700	28,350	9,900
20	41/64	.953 .918	.790	.6396 .6391	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	61,000	38,360	13,470

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 D.P.S.	DATE 1983-08-10	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED E.E. Beeles	DATE 1983-08-11	
REVISION 12	DATE A.CHAE 2022-07-08	DRAWING NUMBER HST856

GENERAL NOTES:

1. Concentricity: "A" diameter to "D" diameter within .010 FIM.
2. Dimensions are in inches and to be met after finish.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
6. Use HST860 for oversize replacement.

⑫ ☒ After February 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in the UK and European Union.

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

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

FINISH:

HST856-()-() = 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.

⑫ ☒ HST856AT()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294.

HST856CE()-() = 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.

HST856CF()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick) with color black on thread end.

⑫ ☒ HST856KM()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST856NKJ()-() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST856NAP()-() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 (0.0002 to 0.0005 Thickness) and cetyl alcohol lube per Hi-Shear Spec. 305.

HST856NKY()-() = Sulfuric acid anodizing per ISO8080, Hi-Kote 1 NC aluminum pigmented coating per HS294 on threads only and cetyl alcohol lube per Hi-Shear Spec. 305.

HST856NGD()-() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST856 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER
 EXAMPLE:**

Pin Part Number
 HST856CE8-8

8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

HST856

DRAWING NUMBER

HST856

2 OF 2