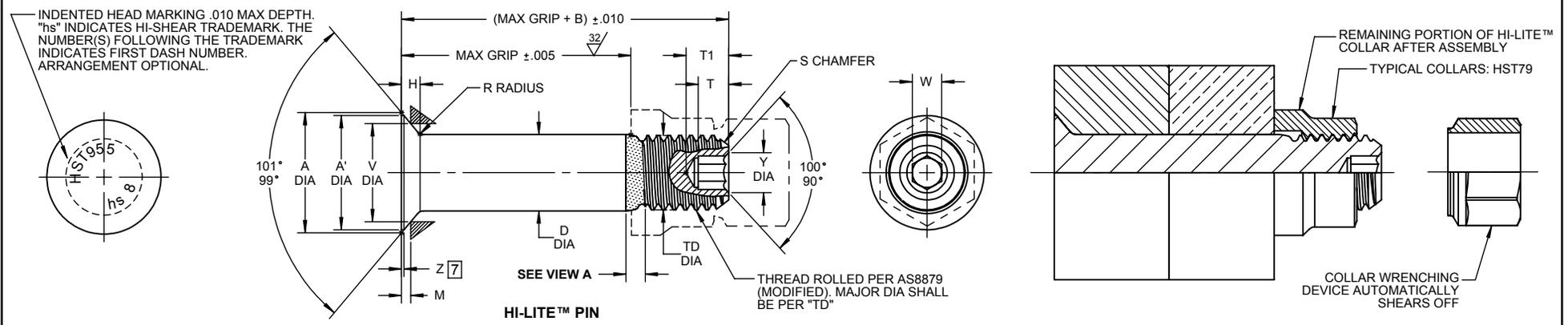


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HI-LITE™ PIN

HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA MAX	A' DIA MIN	B REF	D DIA		TD DIA	F	H REF	M GAGE PROT.	R RAD	V GAGE DIA	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			
					WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM										W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA
24	3/4	1.3000	1.251	.895	.7490 .7485	.7490 .7480	.7430 .7370	.012	.229	.0776 .0716	.050 .040	1.1124 1.1122	.022	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.300	.523	.398 .378
28	7/8	1.5091	1.461	1.000	.8740 .8735	.8740 .8730	.8680 .8610	.014	.263	.0694 .0622	.050 .040	1.3440 1.3438	.022	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.370	.608	.471 .451
32	1	1.7201	1.671	1.160	.9990 .9985	.9990 .9980	.9930 .9860	.014	.298	.0617 .0536	.050 .040	1.5732 1.5730	.022	5/64 x 37°	1.0000-12 UNJF-3A	.5100 .5040	.490	.770	.618 .598

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 are in inches and to be met after finish.
  - Surface texture per ASME B46.1.
  - Hole preparation per NAS618.
  - Curved or flat edge manufacturer's option.
  - After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

**SPECIFICATION:** HI-LITE™ Product Specification 380-1.  
**CODE:** First dash number indicates nominal diameter in 1/32nds. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER**  
 EXAMPLE: Pin Part Number HST955AP8-8  
 8/16 or 1/2 Maximum Grip Length  
 8/32 or 1/4 Nominal Diameter Pin  
 Finish Code  
 Pin Basic Part Number

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



VIEW A  
 HI-LITE™ THREAD TRANSITION AREA  
 SEE SPECIFICATION FOR INSPECTION

**MATERIAL:** 6AL-4V titanium alloy per AMS4928 or AMS4967 or Bistish Standard 2TA 28.

**HEAT TREAT:** Anneal per Hi-Shear Spec. 380-1.

- FINISH:**
- HST955AP(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST955AT(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294.
  - HST955CE(-) = 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.
  - HST955CF(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick), with color black on thread end.
  - HST955KN(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color white on thread end.
  - HST955KM(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST955VF(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST955NKA(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION	
DRAWN BY J. OBISPO	DATE 1989-04-21
APPROVED A. COBETTO	DATE 1989-04-24
REVISION 9	DATE K. TRAN 2017-10-05
TITLE HI-LITE™ PIN 100™ FLUSH SPECIAL SHEAR HEAD TITANIUM (ANNEALED) 1/16 GRIP VARIATION	
DRAWING NUMBER <b>HST955</b>	

HST955