



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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			
				WITHOUT COATING	WITH COATING							W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA
24	49/64	1.150 1.110	.905	.7646 .7641	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.300	.523	.398 .378
28	57/64	1.330 1.290	1.010	.8896 .8891	.8896 .8886	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.370	.608	.471 .451
32	1-1/64	1.510 1.470	1.170	1.0146 1.0141	1.0146 1.0136	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 37°	1.0000-12 UNJF-3A	.5100 .5040	.490	.770	.618 .598

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

- 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.
  5. 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.

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

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

- FINISH:**
- 5 HST958AP( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - 5 HST958AT( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294.
  - HST958CE( )-( ) = 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.
  - HST958CF( )-( ) = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick) with color black on thread end.
  - 5 HST958KM( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - 5 HST958KN( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 with color white on thread end.
  - HST958VF( )-( ) = Surface coating per Hi-Shear Spec. 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.

**SPECIFICATION:** HI-LITE™ Specification 380-1.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HST958 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  
HST958CE24-8

8/16 or 1/2 Maximum Grip Length  
3/4 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

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F. OBISPO	DATE 1990-10-26	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD TITANIUM (ANNEALED) 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED ANNE BROWN	DATE 1990-10-29	DRAWING NUMBER <b>HST958</b>	
REVISION 6	DATE K. TRAN 2017-10-05	1 OF 1	