

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	25/32	1.3000	1.251	.905	.7802 .7797	.7802 .7792	.7430 .7370	.012	.215	.0776 .0716	.050 .040	1.1124 1.1122	.022	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.300	.523	.398 .378
28	29/32	1.5091	1.461	1.010	.9052 .9047	.9052 .9042	.8680 .8610	.014	.240	.0694 .0622	.050 .040	1.3440 1.3438	.022	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.370	.608	.471 .451
32	1-1/32	1.7201	1.671	1.170	1.0302 1.0297	1.0302 1.0292	.9930 .9860	.014	.285	.0617 .0536	.050 .040	1.5732 1.5730	.022	5/64 x 37°	1.0000-12 UNJF-3A	.5100 .5040	.490	.770	.618 .598

- 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.

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

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

- FINISH:**
- [8] HST959AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - [8] HST959AT( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294.
  - HST959CE( )-( ) = 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.
  - HST959CF( )-( ) = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick), with color black on thread end.
  - [8] HST959KM( )-( ) = 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.
  - [8] HST959KN( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color white on thread end.
  - HST959VF( )-( ) = Surface coating per Hi-Shear Spec. 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.

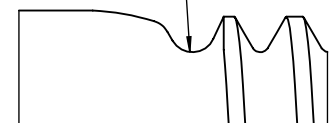
**SPECIFICATION:** HI-LITE™ Product Specification 380-1.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HST959 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER**  
 [6] **EXAMPLE:**

Pin Part Number  
 HST959AP24-8  
 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. OBISPO	DATE 1990-10-29	TITLE HI-LITE™ PIN 100° FLUSH SPECIAL SHEAR HEAD TITANIUM (ANNEALED) 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED ANNE BROWN	DATE 1990-11-14	DRAWING NUMBER <b>HST959</b>
REVISION 5	DATE K. TRAN 2017-10-05	1 OF 1