

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD COLD WORKED	S CHAMFER REF	THREAD MODIFIED	SOCKET			
				WITHOUT COATING	AFTER COATING							W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA
24	25/32	1.185 1.145	.905	.7802 .7797	.7802 .7792	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.300	.523	.398 .378
28	29/32	1.350 1.310	1.010	.9052 .9047	.9052 .9042	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.370	.608	.471 .451
32	1-1/32	1.530 1.490	1.170	1.0302 1.0297	1.0302 1.0292	.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 STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

- GENERAL NOTES:**
1. Concentricity: "A" 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.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST960 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

MATERIAL: 6AL-4V titanium alloy per AMS4928 or AMS4967 or British Standard 2TA 28.
HEAT TREAT: Anneal per Hi-Shear Spec. 380-1.

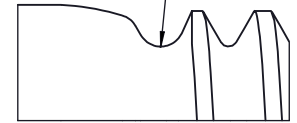
- FINISH:**
- 5 HST960AP()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 5 HST960AT()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294.
 - HST960CE()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, (.00015-.00045 thick), with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST960CF()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, (.00015-.00045 thick), with color black on thread end.
 - 6 5 HST960KM()-() = 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 HST960KN()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, with color white on thread end.
 - HST960VF()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: 6 HI-LITE™ Product Specification 380-1.

**HOW TO ORDER
 EXAMPLE:**

Pin Part Number
 HST960KN8-8
 8/16 or 1/2 Maximum Grip
 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

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY D.P.S.	DATE 1990-10-29	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD TITANIUM (ANNEALED) 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED ANNE BROWN	DATE 1990-11-15	DRAWING NUMBER HST960	
REVISION 6	DATE K. MURKER 2020-03-31	1 OF 1	