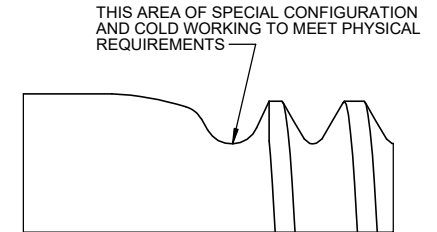


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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



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

5																
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
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
5	13/64						NOTE: USE HST110( ) 6-( )									
6	7/32	.315 295	.300	.2182 2177	.2182 2172	.1840 1810	.025	.055 .045	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,100	2,500
8	9/32	.412 387	.330	.2807 2802	.2807 2797	.2440 2410	.030	.069 .059	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	11,800	4,300
10	11/32	.505 475	.390	.3432 3427	.3432 3422	.3060 3020	.035	.078 .068	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	17,600	6,300
12	13/32	.600 565	.430	.4057 4052	.4057 4047	.3680 3640	.040	.088 .078	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	24,600	8,700
14	15/32	.676 641	.495	.4682 4677	.4682 4672	.4310 4260	.045	.105 .093	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	32,700	12,100
16	17/32	.770 735	.535	.5307 5302	.5307 5297	.4930 4880	.050	.116 .103	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 2207	.260 240	.289 269	42,000	15,300
18	19/32	.864 829	.610	.5927 5922	.5927 5917	.5550 5500	.055	.127 .112	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 2520	.290 .270	.326 .306	52,400	19,000
20	21/32	.953 918	.670	.6552 6547	.6552 6542	.6180 6120	.060	.137 .122	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 2520	.330 .305	.326 .306	64,100	23,000
24	25/32	1.108 1.066	.905	.7802 7797	.7802 7792	.7430 7370	.070	.151 .136	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 3150	.395 .365	.398 .378	90,900	30,700
28	29/32	1.285 1.241	1.010	.9052 9047	.9052 9042	.8680 8610	.090	.187 .172	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.3820 3780	.455 425	.471 451	122,000	45,000
32	1-1/32	1.468 1.424	1.170	1.0302 1.0297	1.0302 1.0292	.9930 9860	.110	.218 203	.060 .045	5/64 x 37°	1.0000-12 UNJF-3A	.5100 5040	.580 550	.618 598	158,000	60,900

"HI-LITE", "HST", AND "HI-KOTE",  
ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY D.P.S.	DATE 1983-11-04	TITLE <b>HI-LITE™ PIN PROTRUDING SHEAR HEAD TITANIUM</b> 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED E.E.BEELES	DATE 1983-11-07	
REVISION (18)	DATE K. PHAM 2022-06-20	DRAWING NUMBER <b>HST410</b>

**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] Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
- [6] Broach petals removed.
7. Oversize pin replacement for HST10 and HST110.

- (18) [8] 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 UK and European Union.
- [9] After September 30th of 2015, HI-KOTE™ 4 coating per HS397 will be replaced by HI-KOTE™ 4 NC coating per HS397.

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

**HEAT TREAT:** 160,000 psi tensile minimum (95,000 psi shear minimum for sizes up to 3/4; 90,000 psi shear minimum for 7/8 and larger).

- FINISH:** HST410-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.
- (18) [8] HST410AG( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- (18) [8] HST410AP( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- (18) [8] HST410AZ( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST410BJ( )-( ) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST410BL( )-( ) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- [6] HST410CT( )-( ) = Color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST410CZ( )-( ) = Color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- [9] HST410HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
- [6] HST410K( )-( ) = Solid film lube per "Lubeco™" 905. "LUBECO" is a trademark of Lubeco Incorporated.
- [6] HST410MA( )-( ) = Solid film lube per "KalGard™" RA. "KALGARD" is a trademark of Metal Improvement Company.
- HST410RP( )-( ) = Phosphate fluoride treat with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST410RS( )-( ) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color orange on thread end.
- HST410RV( )-( ) = Phosphate fluoride treat, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- (18) [8] HST410SU( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color light blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST410TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST410TF( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- HST410UT( )-( ) = Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- (18) HST410UV( )-( ) = Anodize per Hi-Shear Spec 306, Type II, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- (18) HST410VF( )-( ) = Anodize per Hi-Shear Spec 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
- (18) HST410WF( )-( ) = 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.
- (18) [8] HST410GD( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST410YV( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 on threads only, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST410NKJ( )-( ) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST410NKK( )-( ) = Sulfuric acid anodizing per ISO8080 and HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

- HST410NKL( )-( ) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST410NAP( )-( ) = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294. Cetyl alcohol lube per Hi-Shear Spec. 305.

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

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HST410 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

HST410AP8-8  
 └── 8/16 or 1/2 Maximum Grip Length  
 └── 8/32 or 1/4 Nominal Diameter Pin  
 └── Finish Code  
 └── Pin Basic Part Number

HST410

DRAWING NUMBER

**HST410**

2 OF 2