

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM	WITH COATING OR SOLID FILM								W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA		
5	5/32	.2922 .2874	.280	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0540 .0520	.025 .015	.010	1/32 x 37°	.1640-32 UNJC-3A	.0801 .0791	.080	.140	.119 .104	4,010	1,730
6	3/16	.3536 .3486	.290	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0688 .0667	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.080	.140	.119 .104	5,380	2,590
8	1/4	.4732 .4682	.320	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0939 .0918	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.090	.160	.142 .122	9,300	4,760
10	5/16	.5619 .5569	.380	.3120 .3115	.3120 .3110	.3060 .3020	.007	.1048 .1027	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.110	.200	.180 .160	14,600	7,100
12	3/8	.6912 .6862	.420	.3745 .3740	.3745 .3735	.3680 .3640	.008	.1329 .1308	.040 .030	.015	3/64 x 37°	.3875-24 UNJF-3A	.1617 .1582	.140	.235	.217 .197	21,000	10,600
14	7/16	.8041 .7969	.500	.4370 .4365	.4370 .4360	.4310 .4260	.009	.1540 .1510	.050 .040	.022	3/64 x 37°	.4325-20 UNJF-3A	.1930 .1895	.170	.280	.253 .233	28,600	14,450
16	1/2	.9166 .9095	.600	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1750 .1720	.050 .040	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.200	.320	.289 .269	37,300	19,550

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

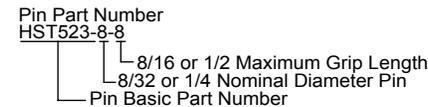
- NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .003 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions are in inches and to be met after finish.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Evidence of broken edge across point.
 - Use HST543 for oversize replacement.
 - After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 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.

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:



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.
HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

- FINISH:**
- HST523(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST523AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST523AG(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST523AZ(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST523GN(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 on threads (no overspray is allowed on the bolt shank) and top of head only (non-bearing surfaces, .005 max overspray on the head bearing surface) with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY D.P.S.	DATE 1985-12-03	TITLE HI-LITE™ PIN 100° FLUSH MS20426 HEAD TITANIUM 1/16 GRIP VARIATION	
APPROVED E.E.B.	DATE 1985-12-10	DRAWING NUMBER HST523	
REVISION 2	DATE K. TRAN 2017-10-10	1 OF 1	