

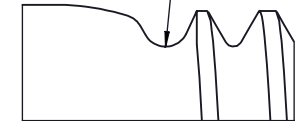
HI-LITE™ PIN

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				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT ALUMINUM COATING	WITH ALUMINUM COATING							W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA		
5				NOTE: USE HST622( )6(-)													
6	13/64	.377 .357	.300	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.080	.140	.119 .104	6,130	3,180
8	17/64	.440 .415	.330	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.090	.160	.142 .122	10,490	5,820
10	21/64	.505 .475	.390	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.110	.200	.180 .160	16,000	9,200
12	25/64	.600 .565	.430	.3901 .3896	.3901 .3891	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.140	.235	.217 .197	22,700	14,000
14	29/64	.676 .641	.510	.4526 .4521	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.170	.280	.253 .233	30,600	18,900
16	33/64	.770 .735	.610	.5151 .5146	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.200	.320	.289 .269	39,600	25,600
18	37/64	.877 .842	.710	.5771 .5766	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.240	.360	.326 .306	49,700	32,400
20	41/64	.953 .918	.790	.6396 .6391	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.240	.400	.326 .306	61,000	41,000
24	49/64	1.150 1.110	1.030	.7646 .7641	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.300	.425	.398 .378	87,200	59,500

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

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 2006-03-27	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED E.E. BEELES	DATE 2006-03-27	
REVISION 3	DATE K. TRAN 2017-10-09	DRAWING NUMBER <b>HST632</b>

**GENERAL NOTES:**

1. Concentricity: "A" to "D" diameter within .010 FIM.
- ③ 2. Dimensions are in inches and to be met after finish.
- ③ 3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Use HST642 for oversize replacement.
- ③ ⑥ 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.

**HEAT TREAT:**

160,000 psi tensile minimum (95,000 psi shear minimum).

**FINISH:**

- HST632-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.
- ③ ⑥ HST632AP( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
- ③ ⑥ HST632AG( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ③ ⑥ HST632GV( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 on threads only (no overspray allowed on the bolt shank) color code green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST632NKJ( )-( ) = 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
- HST632NKK( )-( ) = 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.
- HST632NKL( )-( ) = 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.

**SPECIFICATION:**

HI-LITE™ Product Specification 380.

**CODE:**

First dash number indicates nominal diameter in 1/32nds of the pin which HST632 oversize pin replaces.  
 Second dash number indicates maximum grip in 1/16ths.  
 See Finish note for explanation of code letters.

**HOW TO ORDER**

③ **EXAMPLE:**

Pin Part Number  
 HST632-8-8

└─ 8/16 or 1/2 Maximum Grip Length  
 └─ Replaces 8/32 or 1/4 Nominal Diameter Pin  
 └─ Pin Basic Part Number

HST632

DRAWING NUMBER

**HST632**

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