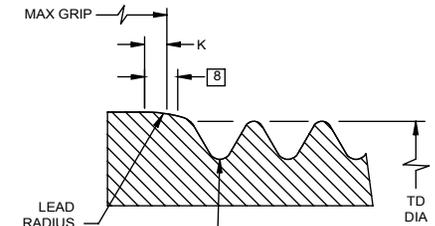


FIRST DASH NO.	PIN NOM DIA	A DIA	A' DIA MIN	B REF	D DIA BEFORE FINISH	TD DIA	F	H	K MAX	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
														W HEX	T DEPTH	Y DIA		
5	5/32				NOTE: USE HST633-6(-)													
6	7/32	.3813 .3765	.349	.325	.2182 .2177	.1840 .1810	.005	.0684 .0664	.016	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,100	3,180
8	9/32	.5066 .5018	.475	.395	.2807 .2802	.2440 .2410	.006	.0948 .0928	.021	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	11,800	5,820
10	11/32	.6335 .6287	.602	.500	.3432 .3427	.3060 .3020	.007	.1218 .1198	.026	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	17,600	9,200
12	13/32	.7604 .7556	.729	.545	.4057 .4052	.3680 .3640	.008	.1488 .1468	.030	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	24,600	14,000
14	15/32	.8884 .8812	.840	.635	.4682 .4677	.4310 .4260	.009	.1763 .1733	.035	.050 .040	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	32,700	18,900
16	17/32	1.0139 1.0068	.965	.685	.5307 .5302	.4930 .4880	.010	.2027 .1997	.039	.050 .040	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	42,000	25,600
18	19/32	1.1408 1.1337	1.085	.770	.5927 .5922	.5550 .5500	.010	.2300 .2270	.039	.050 .040	.025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	52,400	32,400
20	21/32	1.2723 1.2651	1.217	.825	.6552 .6547	.6180 .6120	.010	.2589 .2559	.041	.050 .040	.025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	64,100	41,000

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



VIEW A
HI-LITE™ THREAD TRANSITION AREA. THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS. SEE SPECIFICATION FOR INSPECTION.

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION	
DRAWN BY D.P.S	DATE 1989-10-19
APPROVED DAW	DATE 1989-10-19
REVISION 3	DATE K. TRAN 2017-10-10
TITLE HI-LITE™ PIN 100° FLUSH MS24694 TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE DRAWING NUMBER HST733	

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 3. "H" is dimensioned from maximum "D" diameter.
 4. Dimensions are in inches and to be met after finish.
 5. Surface texture per ASME B46.1.
 6. Hole preparation per NAS618.
 - 7 Curved or flat edge manufacturer's option.
 - 8 Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
 - 9 "D" diameter may increase by .0005" after application of solid film lube, and .001" after application of coating.
 10. Oversize replacement for HST533 and HST633 pins.
 - 11 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: 95,000 psi shear minimum.

- FINISH:**
- HST733DL()-() = Kalgard FA or EM620C solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 11 HST733AP()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST733NKJ()-() = 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.
 - HST733NKK()-() = 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.
 - HST733NKL()-() = 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 HST733 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:**

