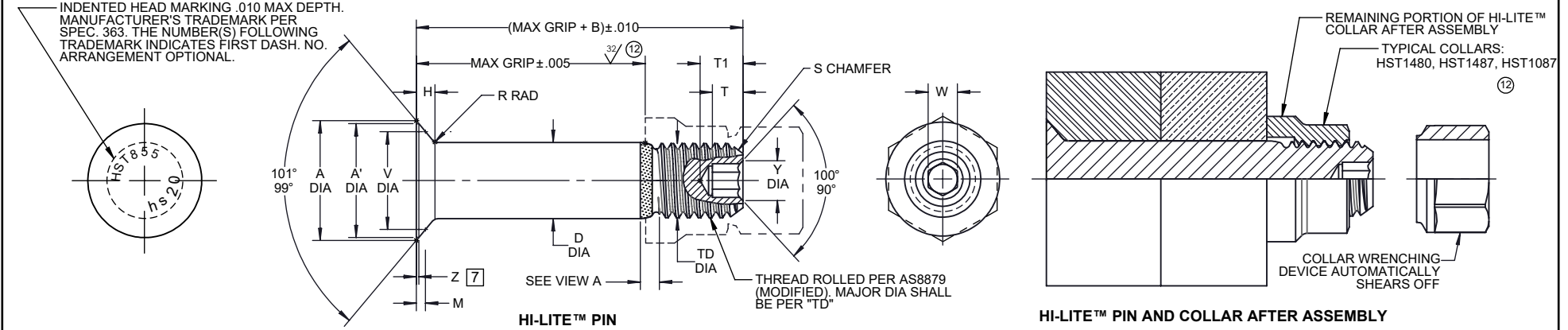
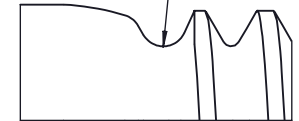




		1											7											8										
FIRST DASH NO.	PIN NOM DIA	A DIA	A' DIA MIN	B REF	D DIA		TD DIA	F	H REF	M GAGE PROT	R RAD COLD WORKED	V GAGE DIA	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE LBS. MIN												
					WITHOUT ALUM. COATING	WITH ALUM. COATING										W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA															
	5							NOTE: USE HST755-6																										
10	6	13/64	.3277	.2963	.300	.2026 .2021	.2026 .2016	.1840 .1810	.005	.052	.0295 .0263	.030 .020	.2560 .2558	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.080	.135	.119 .104	6,130	2,400	900											
	7	15/64	.3766	.3420	.315	.2338 .2333	.2338 .2328	.2100 .2070	.006	.065	.0323 .0293	.030 .020	.2982 .2980	.015	1/32 x 37°	.2160-28 UNJF-3A	.0806 .0791	.080	.145	.119 .104	8,160	3,250	1,137											
	8	17/64	.4283	.3969	.330	.2651 .2646	.2651 .2641	.2440 .2410	.006	.068	.0227 .0195	.030 .020	.3732 .3730	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.090	.160	.142 .122	10,490	4,500	1,575											
	10	21/64	.5361	.5047	.390	.3276 .3271	.3276 .3266	.3060 .3020	.007	.087	.0234 .0198	.040 .030	.4791 .4789	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.110	.200	.180 .160	16,000	6,850	2,397											
	12	25/64	.6415	.6101	.430	.3901 .3896	.3901 .3891	.3680 .3640	.008	.105	.0295 .0259	.040 .030	.5698 .5696	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.140	.235	.217 .197	22,700	10,200	3,570											
	14	29/64	.7425	.6941	.495	.4526 .4521	.4526 .4516	.4310 .4260	.009	.121	.0347 .0307	.050 .040	.6582 .6580	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.170	.275	.253 .233	30,600	13,100	4,585											
	16	33/64	.8423	.7939	.535	.5151 .5146	.5151 .5141	.4930 .4880	.010	.137	.0504 .0464	.050 .040	.7200 .7198	.022	5/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.200	.315	.289 .269	39,600	18,000	6,300											
	18	37/64	.9300	.8816	.610	.5771 .5766	.5771 .5761	.5550 .5500	.010	.147	.0533 .0485	.050 .040	.8012 .8010	.022	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	49,700	22,500	7,875											
	20	41/64	1.0440	.9956	.670	.6396 .6391	.6396 .6386	.6180 .6120	.010	.168	.0633 .0589	.050 .040	.8902 .8900	.022	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	61,000	29,200	10,200											

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.O.	DATE 1983-08-10	TITLE HI-LITE™ PIN 100° FLUSH SPECIAL SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED E.E. BEELES	DATE 1983-08-11	
REVISION (12)	DATE C.Artos 2023-04-07	DRAWING NUMBER HST855

- 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 Fatigue test pins having grip equal two diameters or longer using these loads at R=0.1.
 - 9. Use HST859 pin for oversize replacement.
 - 10 Use HST755, -.8 diameter pin for -.7 oversize replacement.

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

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

- FINISH:**
- HST855-()-() = Andodize per Hi-Shear Spec. 306, Type I, color blue, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 12 HST855AP()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 12 HST855AT()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294.
 - HST855CE()-() = 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.
 - HST855CF()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, (.00015-.00045 thick) with color black on thread end.
 - 12 HST855KM()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST855NKJ()-() = 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.
 - HST855NAP()-() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 (0.0002 to 0.0005 Thickness) and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST855NKY()-() = Sulfuric Acid Anodizing per ISO8080, Hi-Kote 1 NC Aluminum Pigmented Coating per HS294 on Threads only and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST855NGD()-() = HI-KOTE™ 1 NC Aluminum Pigmented Coating per Hi-Shear Spec. 294 on threads only and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST855NGM()-() = HI-KOTE™ 1 NC Aluminum Pigmented Coating per Hi-Shear Spec. 294 on threads only and top of head only, white on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 380, except as noted 8 .

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST855 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
HST855CE8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number

HST855

DRAWING NUMBER

HST855

2 OF 2