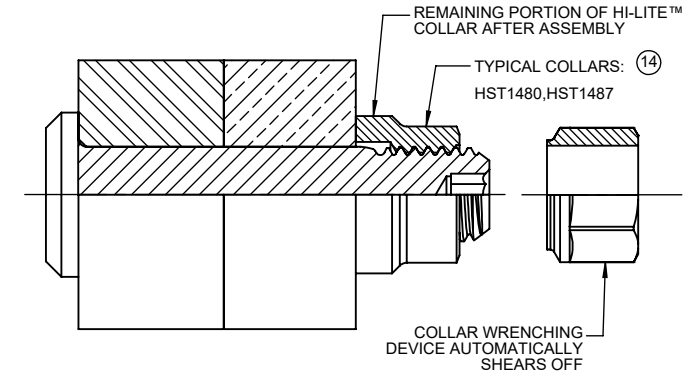


HI-LITE™ PIN

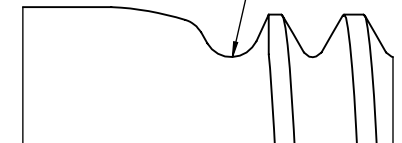


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

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	TENSION FATIGUE POUNDS MAXIMUM
				WITHOUT COATING	WITH COATING							W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA			
5	3/16					NOTE: USE HST856()6-()												
6	7/32	.390 .370	.300	.2182 .2177	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.080	.135	.119 .104	7,100	3,180	1,050
8	9/32	.460 .435	.330	.2807 .2802	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.090	.160	.142 .122	11,800	5,820	1,950
10	11/32	.520 .490	.390	.3432 .3427	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.110	.200	.180 .160	17,600	9,200	3,140
12	13/32	.620 .585	.430	.4057 .4052	.4057 .4047	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.140	.235	.217 .197	24,600	14,000	4,850
14	15/32	.695 .660	.510	.4682 .4677	.4682 .4672	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.170	.275	.253 .233	32,700	17,670	6,120
16	17/32	.790 .755	.610	.5307 .5302	.5307 .5297	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.200	.315	.289 .269	42,000	23,940	8,340
18	19/32	.900 .865	.710	.5927 .5922	.5927 .5917	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	52,400	28,350	9,900
20	21/32	.970 .935	.790	.6552 .6547	.6552 .6542	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	64,100	38,360	13,470

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. OBISPO	DATE 1990-10-29	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED A. BROWN	DATE 1990-11-14	
REVISION (14)	DATE A. CHAE 2023-04-07	DRAWING NUMBER HST860

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.
- 6. Oversize replacement for HST756 and HST856 pins.
- 7 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 the UK and European Union.

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

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

FINISH: HST860-()-() = 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.

7 HST860AT()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294.

HST860CE()-() = 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.

HST860CF()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick) with color black on thread end.

7 HST860KM()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST860NKJ()-() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST860NAP()-() = 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.

HST860NKY()-() = Sulfuric acid anodizing per ISO8080, HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only and cetyl alcohol lube per Hi-Shear Spec. 305.

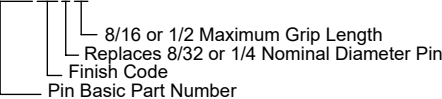
HST860NGD()-() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST860 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
HST860CE8-8



HST860

DRAWING NUMBER

HST860

2 OF 2