



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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	WITH COATING								W HEX	P DEPTH	T DEPTH	Y DIA		
5	5/32	.3393 .3308	.280	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.012	1/32 x 37°	.1640-32 UNJC-3A	.0801 .0791	.070 .060	.100 .080	.104 .094	4,010	1,650
6	3/16	.3911 .3825	.290	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.070 .060	.100 .080	.119 .104	5,380	2,000
8	1/4	.5111 .5026	.320	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.080 .070	.110 .090	.142 .122	9,300	3,700
10	5/16	.6037 .5951	.380	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.100 .080	.130 .110	.180 .160	14,600	5,000
12	3/8	.7090 .7005	.420	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.130 .120	.160 .140	.217 .197	21,000	7,200

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 D.P.S.	DATE 1985-12-19	TITLE HI-LITE™ PIN 130° FLUSH SOCKET RECESS SHEAR HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED E.E.B.	DATE 1985-12-19	
REVISION 1	DATE F.CARINGELLA 2017-12-13	DRAWING NUMBER HST325

- GENERAL NOTES:**
- ① Head edge out of roundness shall not exceed "F".
 - 2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - 3. "H" is dimensioned from maximum "D" diameter.
 - ④ 4. Dimensions are in inches and to be met after finish.
 - ⑤ 5. Surface texture per ASME B46.1.
 - 6. Hole preparation per NAS618.
 - ⑦ 7. Maximum "D" diameter may be increased by .002 to allow for solid film or aluminum coating application.
 - ⑧ 8. Curved or flat edge manufacturer's option.
 - ⑨ 9. 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.

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

HEAT TREAT: 95,000 psi shear minimum.

- FINISH:**
- HST325-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑨ 9. HST325AG-()-() = 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.
 - ⑨ 9. HST325AP-()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec.294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST325CE-()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick), with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST325CF-()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.0015-.00045 thick), with color code black on thread end,
 - HST325CZ-()-() = Cetyl alcohol lube per Hi-Shear Spec. 305. with color black on thread end.
 - HST325RP-()-() = Phosphate fluoride treat with color code orange on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST325SY-()-() = Phosphate fluoride treat, solid film lube per AS5272.
 - HST325TA-()-() = Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 with color orange 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.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER
 ① **EXAMPLE:**

Pin Part Number
 HST325AP-8-8

8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

Pin and Collar Assembly Part Number-Combination
 HST32571-8-8

Size and Grip Length, See Above Example
 Collar Number
 Pin Part Number