2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA a LISI AEROSPACE Company

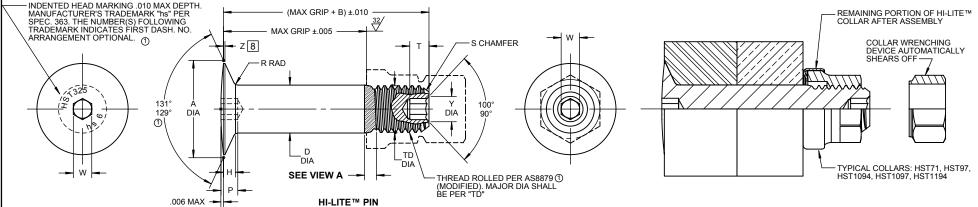
Design Holder

CAGE No. 73197

For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:

HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



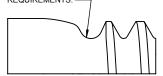


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

					7		1			8		1						
FIRST	PIN	_		D DIA							s		SOCKET				DOUBLE	TENSION
DASH NO.	NOM DIA	A DIA	B REF	WITHOUT	WITH COATING	TD DIA	F	н	RAD	MAX	CHAMFER REF	THREAD MODIFIED	W HEX	P DEPTH	T DEPTH	Y DIA	SHEAR POUNDS MINIMUM	POUNDS MINIMUM
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 CORPÓRATION

1 OF 2

D.P.S.	DATE 1985-12-19	HI-LITE™ PIN 130° FLUSH SOCKET RECESS					
APPROVED E.E.B.	DATE 1985-12-19	SHEAR HEAD TITANIUM 1/16 GRIP VARIATION					
REVISION 1	DATE F.CARINGELLA 2017-12-13	DRAWING NUMBER HST325 1.0					

2017-12-13

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.

① 4. Dimensions are in inches and to be met after finish. ① 5. Surface texture per ASME B46.1.

6. Hole preparation per NAS618.

[7] Maximum "D" diameter may be increased by .002 to allow for solid film or aluminum coating application.

8 Curved or flat edge manufacturer's option.

① 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.

HST325-()-()

= Cetyl alcohol lube per Hi-Shear Spec. 305.

① 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 Špec. 305.

① 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

① (.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 and Collar Assembly Part Number Combination

Pin Basic Part Number

HST32571-8-8

Size and Grip Length, See Above Example

Collar Number

Pin Part Number

DRAWING NUMBER