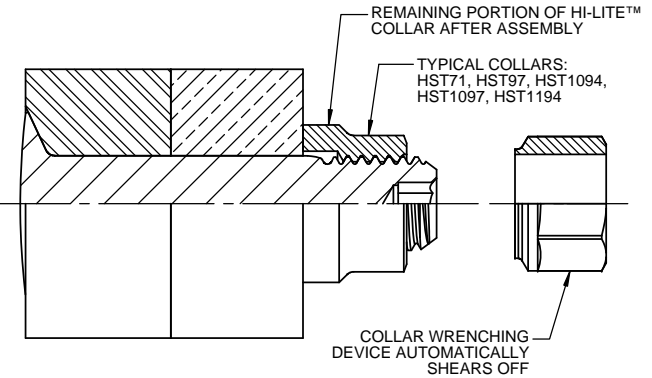
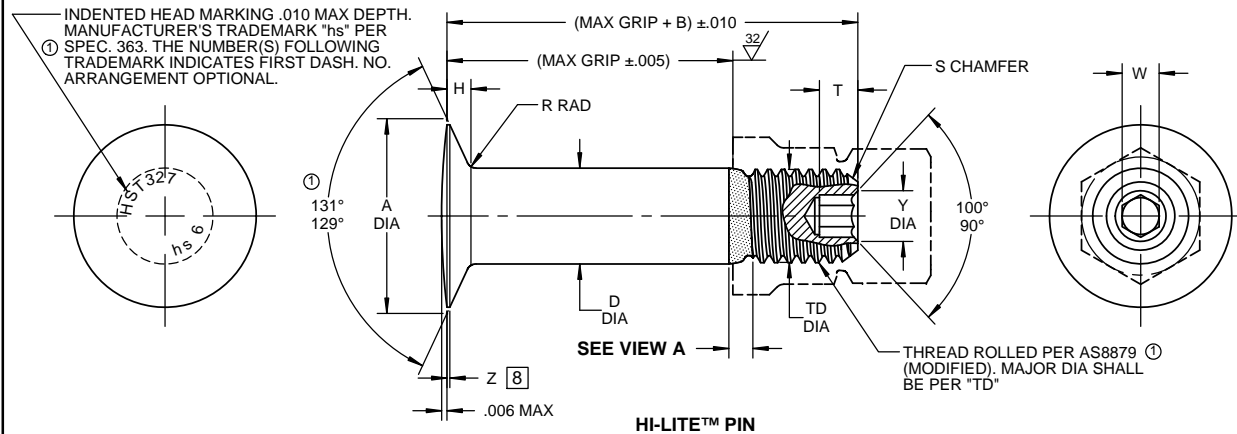


① For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:  
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://WWW.LISI-AEROSPACE.COM/LICENSES)



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	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM								W HEX	T DEPTH	Y DIA		
5	5/32	.3780 .3694	.280	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0500 .0480	.025 .015	.012	1/32 x 37°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	.104 .094	4,010	1,500
6	3/16	.4297 .4211	.290	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0560 .0540	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,380	2,400
8	1/4	.5669 .5583	.320	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0740 .0720	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,300	4,500
10	5/16	.7066 .6980	.380	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0820 .0900	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,600	6,850
12	3/8	.8463 .8377	.420	.3745 .3740	.3745 .3735	.3680 .3640	.008	.1100 .1080	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,000	10,200

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 S.GRAPHICS	DATE 1986-01-13	TITLE HI-LITE™ PIN 130° FLUSH SPECIAL CROWN SHEAR HEAD TITANIUM 1/16 GRIP VARIATION	
APPROVED E.E.B.	DATE 1986-02-11	DRAWING NUMBER <b>HST327</b>	
REVISION ①	DATE 2017-07-27	1 OF 2	

- 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 .0002 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 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:**
- HST327-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.
  - ⑨ HST327AG( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - ⑨ HST327AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - ① HST327CE( )-( ) = 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.
  - ① HST327CF( )-( ) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, (.00015-.00045 thick). with color black on thread end.
  - HST327CZ( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305, with color black on thread end.
  - HST327RP( )-( ) = Phosphate fluoride treat with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - ① HST327SY( )-( ) = Phosphate fluoride treat, solid film lube per AS5272, Type I.
  - HST327TA( )-( ) = Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, 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  
 HST327AP8-8

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  
 HST327771-8-8

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

HST327

DRAWING NUMBER

**HST327**

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