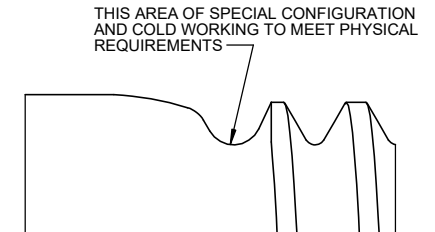


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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



VIEW A
HI-LITE™ THREAD TRANSITION AREA
SEE SPECIFICATION FOR INSPECTION

[7] [1]																	
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	13/64						NOTE: USE HST111() 6-()										
6	7/32	.3303 .3253	.300	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,100	2,000
8	9/32	.4260 .4210	.330	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	11,800	3,700
10	11/32	.5051 .5001	.390	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	17,600	5,000
12	13/32	.5916 .5866	.430	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	24,600	7,200
14	15/32	.6992 .6932	.495	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0970 .0945	.050 .040	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	32,700	10,000
16	17/32	.7852 .7792	.535	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1070 .1045	.050 .040	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	42,000	13,500
18	19/32	.8692 .8622	.610	.5927 .5922	.5927 .5917	.5550 .5500	.010	.1160 .1130	.050 .040	.022	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	52,400	17,000
20	21/32	.9562 .9492	.670	.6552 .6547	.6552 .6542	.6180 .6120	.010	.1260 .1230	.050 .040	.022	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	64,100	21,000
24	25/32	1.1282 1.1162	.905	.7802 .7797	.7802 .7792	.7430 .7370	.012	.1460 .1410	.050 .040	.022	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	90,900	30,700
28	29/32	1.3509 1.3342	1.010	.9052 .9047	.9052 .9042	.8680 .8610	.014	.1870 .1800	.050 .040	.022	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.455 .425	.471 .451	122,000	42,000
32	1-1/32	1.5498 1.5307	1.170	1.0302 1.0297	1.0302 1.0292	.9930 .9860	.014	.2180 .2100	.050 .040	.022	5/64 x 37°	1.0000-12 UNJF-3A	.5100 .5040	.580 .550	.618 .598	158,000	55,000

"HI-LITE", "HST", AND "HI-KOTE",
ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY J. OBISPO	DATE 1983-11-04	TITLE HI-LITE™ PIN 100° FLUSH SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED E.E.BEELES	DATE 1983-11-07	
REVISION 15	DATE K. PHAM 2022-05-10	DRAWING NUMBER HST411

GENERAL NOTES:

- 1 Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .003 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 Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
- 8 Curved or flat edge manufacturer's option.
- 9 Broach petals removed.
10. Oversize replacement for HST11 and HST111.
- 11 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 UK and European Union.
- 12 After September 30th of 2015, HI-KOTE™ 4 coating per HS397 will be replaced by HI-KOTE™ 4 NC coating per HS397.

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

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum for sizes up to 3/4; 90,000 psi shear minimum for 7/8 and larger).

FINISH: HST411(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.

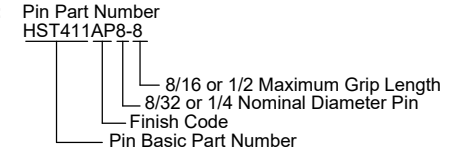
- 15 11 HST411AG(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 15 11 HST411AP(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 15 11 HST411AZ(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST411BJ(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST411BL(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 9 HST411CT(-)(-) = Color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 12 HST411HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397
- 9 HST411K(-)(-) = Solid film lube per "Lubeco™ 905". "LUBECO" is a trademark of Lubeco Incorporated.
- 15 11 HST411KM(-)(-) = 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.
- 9 HST411MA(-)(-) = Solid film lube per "KalGard™ RA". "KALGARD" is a trademark of Metal Improvement Company.
- HST411RP(-)(-) = Phosphate fluoride treat with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST411RS(-)(-) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color orange on thread end.
- HST411SY(-)(-) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color red on thread end.
- HST411TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST411TF(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- 15 HST411WF(-)(-) = 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.
- HST411YV(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 on threads only, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST411NKJ(-)(-) = 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.
- HST411NKK(-)(-) = Sulfuric acid anodizing per ISO8080 and HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST411NKL(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST411NAP(-)(-) = HI-KOTE™ 1 NC Aluminum Coating per Hi-Shear Spec. 294, Cetyl alcohol lube per Hi-Shear Spec. 305

SPECIFICATION: HI-LITE™ Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST411 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

**HOW TO ORDER
 EXAMPLE:**



HST411

DRAWING NUMBER

HST411

2 OF 2