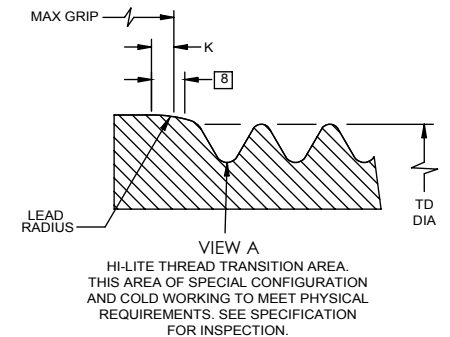


FIRST DASH NO.	PIN NOM DIA	A DIA	A' DIA MIN	B REF	D DIA BEFORE ALUMINUM COATING OR SOLID FILM LUBE	TD DIA	F REF	H	K MAX	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
														W HEX	T DEPTH	Y DIA		
5	5/32	.3304 .3256	.311	.312	.1640 .1635	.1595 .1570	.004	.0698 .0678	.013	.025 .015	.012	1/32 x 37°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	.104 .094	4,010	2,180
6	3/16	.3813 .3765	.349	.325	.1895 .1890	.1840 .1810	.005	.0805 .0785	.016	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,380	3,180
8	1/4	.5066 .5018	.475	.395	.2495 .2490	.2440 .2410	.006	.1080 .1060	.021	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,300	5,820
10	5/16	.6335 .6287	.602	.500	.3120 .3115	.3060 .3020	.007	.1350 .1330	.026	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,600	9,200
12	3/8	.7604 .7556	.729	.545	.3745 .3740	.3680 .3640	.008	.1620 .1600	.030	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,000	14,000
14	7/16	.8884 .8812	.840	.635	.4370 .4365	.4310 .4260	.009	.1895 .1865	.035	.050 .040	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	28,600	18,900
16	1/2	1.0139 1.0068	.965	.685	.4995 .4990	.4930 .4880	.010	.2160 .2130	.039	.050 .040	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	37,300	25,600
18	9/16	1.1408 1.1337	1.085	.770	.5615 .5610	.5550 .5500	.010	.2430 .2400	.039	.050 .040	.025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	47,200	32,400
20	5/8	1.2723 1.2651	1.217	.825	.6240 .6235	.6180 .6120	.010	.2720 .2690	.041	.050 .040	.025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	58,300	41,000

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



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

DRAWN BY D.P.S.	DATE 1989-10-19	TITLE HI-LITE™ PIN 100° FLUSH MS24694 TENSION HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED DAW	DATE 1989-10-19	
REVISION ④	DATE K. TRAN 2017-10-09	DRAWING NUMBER <b>HST533</b>

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
  2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
  3. "H" is dimensioned from maximum "D" diameter.
  - ④ 4. Thread dimensions are in inches and apply after finish; all other dimensions apply before finish.
  - ④ 5. Surface texture per ASME B46.1.
  6. Hole preparation per NAS618.
  - 7 Curved or flat edge manufacturer's option.
  - 8 Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
  - 9 "D" diameter may increase by .0005" after application of solid film lube, and .001" after application of coating.
  10. Use HST633 for oversize replacement.
  - ④ 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 European Union.

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

**HEAT TREAT:** 95,000 psi shear minimum.

- FINISH:** HST533DL( )-( ) = Kalgard FA or EM620C solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.
- ④ 11 HST533AP( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST533NKJ( )-( ) = 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.
- HST533NKK( )-( ) = 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.
- HST533NKL( )-( ) = 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.

**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**  
 ④ **EXAMPLE:**

Pin Part Number  
 HST533AP8-8

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

HST533

DRAWING NUMBER

**HST533**

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