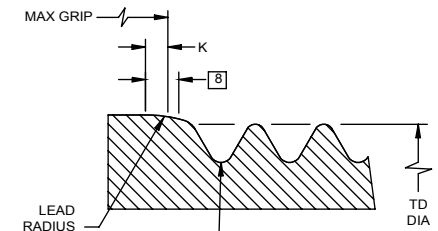


HI-LITE™ PIN

HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	A' DIA MIN	B REF	D DIA BEFORE FINISH	TD DIA	F	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				NOTE: USE HST633-6- ()													
6	7/32	.3813 .3765	.349	.325	.2182 .2177	.1840 .1810	.005	.0684 .0664	.016	.030 .020	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,100	3,180
8	9/32	.5066 .5018	.475	.395	.2807 .2802	.2440 .2410	.006	.0948 .0928	.021	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	11,800	5,820
10	11/32	.6335 .6287	.602	.500	.3432 .3427	.3060 .3020	.007	.1218 .1198	.026	.040 .030	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	17,600	9,200
12	13/32	.7604 .7556	.729	.545	.4057 .4052	.3680 .3640	.008	.1488 .1468	.030	.040 .030	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	24,600	14,000
14	15/32	.8884 .8812	.840	.635	.4682 .4677	.4310 .4260	.009	.1763 .1733	.035	.050 .040	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	32,700	18,900
16	17/32	1.0139 1.0068	.965	.685	.5307 .5302	.4930 .4880	.010	.2027 .1997	.039	.050 .040	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	42,000	25,600
18	19/32	1.1408 1.1337	1.085	.770	.5927 .5922	.5550 .5500	.010	.2300 .2270	.039	.050 .040	.025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	52,400	32,400
20	21/32	1.2723 1.2651	1.217	.825	.6552 .6547	.6180 .6120	.010	.2589 .2559	.041	.050 .040	.025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	64,100	41,000

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



VIEW A
 HI-LITE™ THREAD TRANSITION AREA. THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS. SEE SPECIFICATION FOR INSPECTION.

"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	
APPROVED DAW	DATE 1989-10-19	100° FLUSH MS24694 TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE	
REVISION ③	DATE K. TRAN 2017-10-10	DRAWING NUMBER HST733	

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.
- ③ 4. Dimensions are in inches and to be met after finish.
- ③ 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. Oversize replacement for HST533 and HST633 pins.
- ③ 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: HST733DL()-() = Kalgard FA or EM620C solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.

③ 11 HST733AP()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST733NKJ()-() = 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.

HST733NKK()-() = 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.

HST733NKL()-() = 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 of the pin which HST733 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER

③ **EXAMPLE:**

Pin Part Number
 HST733AP8-8

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

HST733

DRAWING NUMBER

HST733

2 OF 2