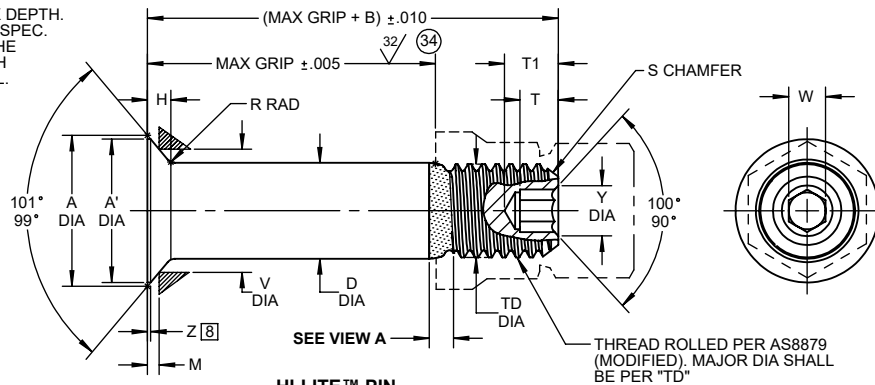
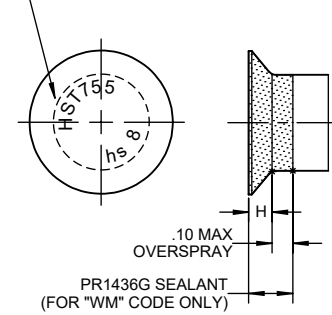
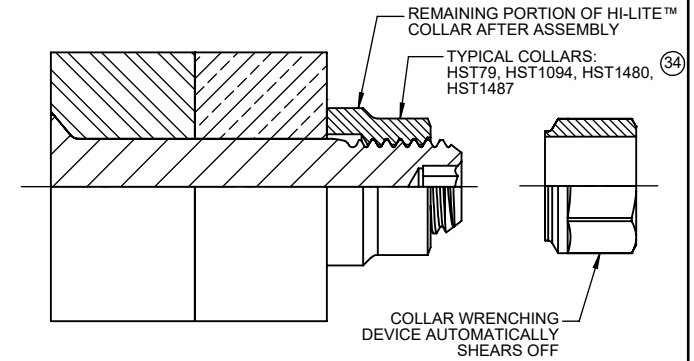


INDENTED HEAD MARKING .010 MAX DEPTH.
MANUFACTURE'S TRADEMARK PER SPEC.
363. THE NUMBER(S) FOLLOWING THE
TRADEMARK INDICATES FIRST DASH
NUMBER. ARRANGEMENT OPTIONAL.



HI-LITE™ PIN

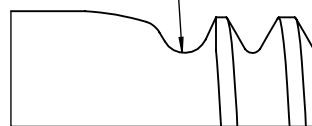


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA MAX	A' DIA MIN	B REF	D DIA		TD DIA	F	H REF	M GAGE PROT.	R RAD	V GAGE DIA	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION- TENSION FATIGUE POUNDS MINIMUM
					WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM										W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA			
5	5/32	.2827	.260	.280	.1635 .1630	.1635 .1625	.1595 .1570	.004	.049	.0330 .0298	.025 .015	.2028 .2026	.010	1/32 x 37°	.1640-32 UNJC-32	.0801 .0791	.080	.135	[9]	4,010	1,650	615
6	3/16	.3277	.293	.290	.1895 .1890	.1895 .1885	.1840 .1810	.005	.056	.0295 .0263	.030 .020	.2560 .2558	.015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.080	.135	.119 .104	5,380	2,400	900
7	7/32	.3766	.342	.305	.2182 .2177	.2182 .2172	.2100 .2070	.006	.065	.0323 .0293	.030 .020	.2982 .2980	.015	1/32 x 37°	.2160-28 UNJF-3A	.0806 .0791	.080	.145	.119 .104	7,194	3,250	1,137
8	1/4	.4283	.394	.320	.2495 .2490	.2495 .2485	.2440 .2410	.006	.074	.0227 .0195	.030 .020	.3732 .3730	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.090	.160	.142 .122	9,300	4,500	1,575
10	5/16	.5361	.501	.380	.3120 .3115	.3120 .3110	.3060 .3020	.007	.092	.0234 .0198	.040 .030	.4791 .4789	.015	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.110	.200	.180 .160	14,600	6,850	2,397
12	3/8	.6415	.607	.420	.3745 .3740	.3745 .3735	.3680 .3640	.008	.110	.0295 .0259	.040 .030	.5698 .5696	.015	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.140	.235	.217 .197	21,000	10,200	3,570
14	7/16	.7425	.691	.485	.4370 .4365	.4370 .4360	.4310 .4260	.009	.126	.0347 .0307	.050 .040	.6582 .6580	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.170	.275	.253 .233	28,600	13,100	4,585
16	1/2	.8423	.791	.525	.4995 .4990	.4995 .4985	.4930 .4880	.010	.142	.0504 .0464	.050 .040	.7200 .7198	.022	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.200	.315	.289 .269	37,300	18,000	6,300
18	9/16	.9300	.881	.600	.5615 .5610	.5615 .5605	.5550 .5500	.010	.153	.0533 .0485	.050 .040	.8012 .8010	.022	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	47,200	22,500	7,875
20	5/8	1.0440	.995	.640	.6240 .6235	.6240 .6230	.6180 .6120	.010	.174	.0633 .0589	.050 .040	.8902 .8900	.022	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	58,300	29,200	10,200
24	3/4	1.3000	1.251	.895	.7490 .7485	.7490 .7480	.7430 .7370	.012	.229	.0776 .0716	.050 .040	1.1124 1.1122	.022	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.300	.465	.398 .378	83,900	46,000	16,100
28	7/8	1.5091	1.461	1.000	.8740 .8735	.8740 .8730	.8680 .8610	.014	.263	.0694 .0622	.050 .040	1.3440 1.3438	.022	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.370	.608	.471 .451	107,000	55,000	19,250
32	1	1.7201	1.671	1.160	.9990 .9985	.9990 .9980	.9930 .9860	.014	.298	.0617 .0536	.050 .040	1.5732 1.5730	.022	5/64 x 37°	1.0000-12 UNJF-3A	.5100 .5040	.490	.770	.618 .598	140,000	71,000	24,850
36	1-1/8	1.9350	1.887	1.305	1.240 1.235	1.240 1.230	1.1170 1.1100	.015	.340	.0560 .0475	.060 .050	1.8026 1.8024	.022	5/64 x 37°	1.1250-12 UNJF-3A	.5725 .5675	.550	.850	.693 .673	178,000	91,000	31,850

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 CORPORATION

DRAWN BY J.OBISPO		DATE 2014-08-14		TITLE HI-LITE™ PIN 100° FLUSH SPECIAL SHEAR HEAD TITANIUM 1/16 GRIP VARIATION	
D.P.S.		DATE 1983-02-04			
APPROVED R.TING		DATE 1983-02-04		DRAWING NUMBER HST755 1 OF 2	
REVISION 34		DATE CARTOS 2023-04-07			

- 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 Fatigue test required on pins having grip length equals to two diameters or longer.
Use maximum load rate per table. Minimum load rate is 10% of maximum load.
 - 8 Curved or flat edge manufacturer's option.
 - 9 Evidence of broken edge across points.
 10. Use HST855 for oversize replacement.
 - 34 11 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 the 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.
 - 13 Finish code is obsolete and replaced by "NAP" Finish code

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).

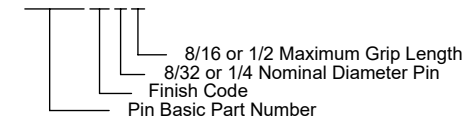
- 34 **FINISH:** HST755-()-() = Anodized per Hi-Shear Spec. 306, Type I, color blue, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 11 HST755AP()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 11 HST755AT()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294.
- HST755CE()-() = 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.
- HST755CF()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick), with color black on thread end.
- 12 HST755HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
- HST755JB()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick), or EN6118, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 11 HST755KM()-() = 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.
- 11 HST755KN()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color white on thread end.
- HST755RP()-() = Phosphate fluoride treat with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST755UV()-() = Surface coating per Hi-Shear Spec. 306, Type II, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292., and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST755VF()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 11 HST755WM()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color white on thread end, and apply Precoat No. PR1436G sealant (.002-.005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
- 13 HST755NKA()-() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST755NAP()-() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 (0.0002 to 0.0005 Thickness) and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST755NKY()-() = Sulfuric Acid Anodizing per ISO8080, Hi-Kote 1 NC Aluminum Pigmented Coating per HS294 on threads only and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST755NGD()-() = HI-KOTE™ 1 NC Aluminum Pigmented Coating per Hi-Shear Spec. 294 on threads only and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST755NGM()-() = HI-KOTE™ 1 NC Aluminum Pigmented Coating per Hi-Shear Spec. 294 on threads only and top of head only, white on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 380, except as noted.

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
EXAMPLE:**

Pin Part Number
HST755AP8-8



HST755

DRAWING NUMBER

HST755

2 OF 2