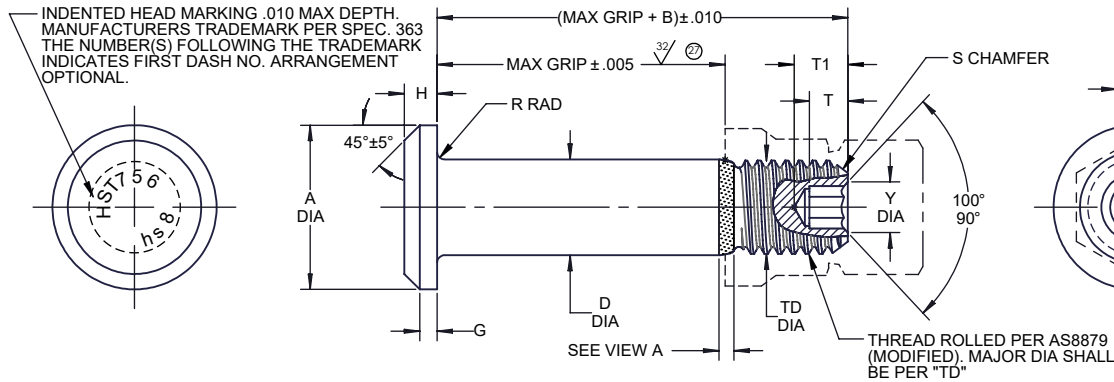
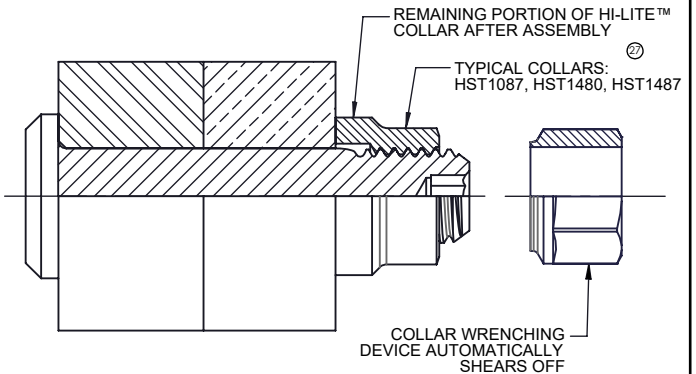




HI-LITE™ PIN



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	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION- TENSION FATIGUE LBS. MAX.
				WITHOUT COATING OR SOLID FILM	WITH COATING OR SOLID FILM							W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA			
5	5/32	.322 .306	.280	.1635 .1630	.1635 .1625	.1595 .1570	.030	.065 .055	.025 .015	1/32 x 37°	.1640-32 UNJC-3A	.0806 .0791	.080	.135	.119 .104	4,010	2,180	715
6	3/16	.377 .357	.290	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.080	.135	.119 .104	5,380	3,180	1,050
7	7/32	.410 .390	.305	.2182 .2177	.2182 .2172	.2100 .2070	.040	.081 .071	.025 .015	1/32 x 37°	.2160-28 UNJF-3A	.0806 .0791	.080	.145	.119 .104	7,194	4,000	1,360
8	1/4	.440 .415	.320	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.090	.160	.142 .122	9,300	5,820	1,950
10	5/16	.505 .475	.380	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.110	.200	.180 .160	14,600	9,200	3,140
12	3/8	.600 .565	.420	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.140	.235	.217 .197	21,000	14,000	4,850
14	7/16	.676 .641	.485	.4370 .4365	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.170	.275	.253 .233	28,600	17,670	6,120
16	1/2	.770 .735	.525	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.200	.315	.289 .269	37,300	23,940	8,340
18	9/16	.877 .842	.600	.5615 .5610	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	47,200	28,350	9,900
20	5/8	.953 .918	.640	.6240 .6235	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	58,300	38,360	13,470

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 D.P.S.	DATE 1983-02-04	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED R.TING	DATE 1983-02-22	
REVISION (27)	DATE C.Arlos 2023-04-07	DRAWING NUMBER HST756

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions are in inches and to be met after finish.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 5. Evidence of broken edge across points.
 6. Use HST856 for oversize replacement.
- 27 7 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.

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

HEAT TREAT: 95,000 psi shear minimum.

- 27 **FINISH:** HST756(-)(-) = 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.
- 7 HST756AP(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 7 HST756AT(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294.
- HST756CE(-)(-) = 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.
- HST756CF(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick), with color black on thread end.
- HST756JB(-)(-) = 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 or EN6117.
- 7 HST756KM(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 7 HST756KN(-)(-) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, with color white on thread end.
- HST756RP(-)(-) = Phosphate fluoride treat with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST756UV(-)(-) = Anodize 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.
- HST756VF(-)(-) = Anodize per Hi-Shear Spec. 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST756NKJ(-)(-) = 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.
- HST756NAP(-)(-) = 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.
- HST756NKY(-)(-) = 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.
- HST756NGD(-)(-) = HI-KOTE™ 1 NC Aluminum Pigmented Coating per Hi-Shear Spec. 294 on threads only and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 380, except fatigue loads as tabulated.

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
 HST756AP8-8

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

HST756

DRAWING NUMBER

HST756

2 OF 2