



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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			
				WITHOUT COATING	WITH COATING							W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA
24	3/4	1.150 1.110	.895	.7490 .7485	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.300	.523	.398 .378
28	7/8	1.330 1.290	1.000	.8740 .8735	.8740 .8730	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.370	.608	.471 .451
32	1	1.510 1.470	1.160	.9990 .9985	.9990 .9980	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 37°	1.0000-12 UNJF-3A	.5100 .5040	.490	.770	.618 .598

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

- GENERAL NOTES:**
- Concentricity: "A" diameter to "D" diameter within .010 FIM.
 - Dimensions are in inches and to be met after finish.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - 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 or British Standard 2TA 28.

HEAT TREAT: Anneal per Hi-Shear Spec. 380-1.

- FINISH:**
- [5] HST956AP()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - [5] HST956AT()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294.
 - HST956CE()-() = 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.
 - HST956CF()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick) with color black on thread end.
 - [10] [5] HST956KM()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - [5] HST956KN()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 with color white on thread end.
 - HST956VF()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Specification 380-1.

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
HST956CE24-8

8/16 or 1/2 Maximum Grip Length
3/4 Nominal Diameter Pin
Finish Code
Pin Basic Part Number

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.F. OBISPO	DATE 1989-04-21	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD TITANIUM (ANNEALED) 1/16 GRIP VARIATION	
APPROVED A. COBETTO	DATE 1989-04-24	DRAWING NUMBER HST956	
REVISION (10)	DATE K. MURKER 2020-03-27	1 OF 1	