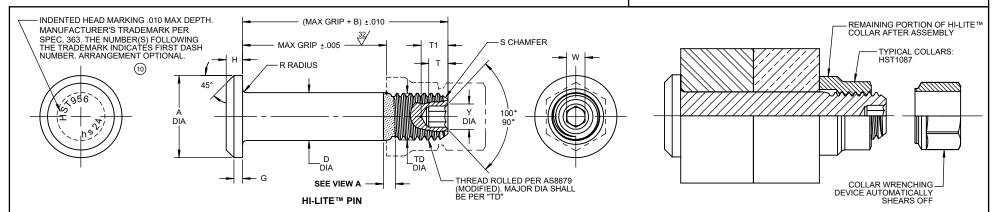
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA a LISI AEROSPACE Company

Design Holder

CAGE No. 73197

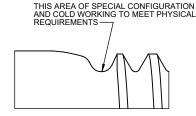
For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at: HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



## HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

FIRST	PIN	Α	В	<b>D</b> DIA		TD	G		R	s	THREAD	SOCKET			
DASH NO.	NOM DIA	DIA	REF	WITHOUT COATING	WITH COATING	DIA	REF	Н	RAD	CHAMFER REF	MODIFIED	W	T DEPTH MIN	T1 DEPTH MAX	<b>Y</b> 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: 1. Concentricity: "A" diameter 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] 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. HOW TO ORDER

**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.

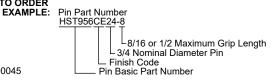
HST956VF()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.

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.

VIEW A

HI-LITE™ THREAD TRANSITION AREA SEE SPECIFICATION FOR INSPECTION



ARE TRADEMARKS OF HI-SHEAR CORPORATION						
DRAWN BY	DATE	TITLE				
J.F. OBISPO	1989-04-21	HI-LITE™ PIN				
		PROTRUDING TENSION HEAD				
APPROVED	DATE	TITANII INA (ANINITALED)				

TITANIUM (ANNEALED) A. COBETTO 1989-04-24 1/16 GRIP VARIATION

K. MURKER **HST956** 2020-03-27

1 OF 1