



HI-LITE[®]ST™ / HI-TIGUE[®] PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM LUBE	WITH COATING OR SOLID FILM LUBE								W HEX.	T DEPTH	Y DIA.		
-5	5/32	.2612 .2564	.280	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.012	1/32" x 37°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	.109 .104	4,010	1,290
-6	3/16	.3016 .2966	.290	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,380	2,000
-8	1/4	.3948 .3898	.320	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	9,300	3,700
-10	5/16	.4739 .4689	.380	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	14,600	5,000
-12	3/8	.5604 .5554	.420	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	21,000	7,200
-14	7/16	.6680 .6620	.485	.4370 .4365	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 .040	.020	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	28,600	10,000
-16	1/2	.7540 .7480	.525	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.020	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	37,300	13,500

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

- ① GENERAL NOTES:
- Head edge out of roundness shall not exceed "F."
 - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Use HSTB611 for oversize replacement.

MATERIAL: 6AL-4V titanium alloy per Spec. AMS4928 or AMS4967.
HEAT TREAT: 95,000 psi shear minimum.
FINISH: HSTB411-()-() =Cetyl alcohol lube per Hi-Shear Spec. 305.
HSTB411AZ-()-() =Hi-Kote 1 per Hi-Shear Spec. 294 with color black 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.
Second dash number indicates maximum grip in 1/16ths.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HSTB411-8-8
8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HSTB41177-8-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

U.S. Patents 4,326,825, 4,485,510 and 4,957,401. Other U.S. and foreign patents pending. "Hi-Lite" and "Hi-Tigue" are registered trademarks and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.	
DRAWN S. Graphics 11-10-83	DATE 11-10-83
APPROVED E.E. B... 11-10-83	DATE 11-10-83
REVISION 3	DATE D. P. S. 2-13-91
TITLE HI-LITE [®] ST™/HI-TIGUE [®] PIN 100° FLUSH SHEAR HEAD TITANIUM 1/16" GRIP VARIATION	
DRAWING NUMBER HSTB411	

HSTB411