## HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

**Collar Wrenching Device Automatically Shears Off**

**OVERSPRAY PR1436G SEALANT**

COATING

**HI-LITE™ THREAD TRANSITION AREA**

**SEE SPECIFICATION FOR INSPECTION**

**SYSTEM STRENGTH.**

**REMAINING PORTION OF HI-LITE™ COLLAR AFTER ASSEMBLY**

**TYPICAL COLLARS:** HST 79, HST 1094

**HI-SHEAR Corporation, USA**

**Design Holder**

**CAGE No. 73197**

**For the current list of licensed manufacturers, please visit the**

**LISI AEROSPACE website at:**

**HTTP://WWW.LISI-AEROSPACELICENSES**

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### HI-LITE™ PIN

#### FIRST DASH NO. | PIN NOM. DIA | A DIA | B REF | DIA | F | H | R RAD | Z MAX | S CHAMFER | THREAD MODIFIED | SOCKET | DOUBLE SHEAR Pounds | TENSION POUNDS | MINIMUM
|-------|------------|--------|-------|-----|---|---|------|------|---------|-----------------|--------|----------------------|---------------|--------
| 5     | 5/32       | .280   | .287  | 1630| 1630| 1625| .004 | .041  | .025 | .015       | 1/32 x 37°     | .0645   | 135                  | 906           | .075    |
| 6     | 3/16       | .290   | .291  | 1630| 1630| 1625| .005 | .040  | .030 | .015       | 1/32 x 37°     | .0806   | 100                  | 911           | .119    |
| 8     | 7/32       | .320   | .320  | 1630| 1630| 1625| .006 | .039  | .025 | .020       | 1/32 x 37°     | .0971   | 90                   | 111           | .142    |
| 10    | 5/16       | .380   | .380  | 1630| 1630| 1625| .007 | .038  | .030 | .015       | 3/32 x 37°     | .1295   | 170                  | 180           | .160    |
| 12    | 3/8        | .554   | .554  | 1630| 1630| 1625| .008 | .076  | .040 | .030       | 3/32 x 37°     | .1582   | 180                  | 217           | .197    |
| 14    | 7/16       | .680   | .680  | 1630| 1630| 1625| .009 | .096  | .050 | .022       | 3/32 x 37°     | .1930   | 230                  | 253           | .233    |
| 16    | 1/2        | 1.750  | 1.680 | 1.750| 1.680| 1.750| .010 | .108  | .050 | .022       | 3/32 x 37°     | .2242   | 240                  | 269           | .299    |
| 18    | 9/16       | 2.050  | 2.050 | 2.050| 2.050| 2.050| .011 | .116  | .050 | .022       | 1/8 x 37°      | .2555   | 270                  | 306           | .306    |
| 20    | 5/8        | 2.600  | 2.600 | 2.600| 2.600| 2.600| .012 | .126  | .050 | .022       | 1/8 x 37°      | .2865   | 290                  | 326           | .326    |
| 24    | 3/4        | 3.450  | 3.400 | 3.450| 3.400| 3.450| .013 | .140  | .050 | .022       | 1/8 x 37°      | .3150   | 305                  | 355           | .355    |
| 32    | 1         | 5.190  | 5.190 | 5.190| 5.190| 5.190| .015 | .180  | .050 | .022       | 5/32 x 37°     | .4500   | 450                  | 500           | .500    |

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**HI-LITE™, "HST", and "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION**

**DRAWN BY:**

J. OBISPO

1985-08-04

**APPROVED BY:**

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1985-08-04

**REVISED:**

B. CLARK

2021-07-12

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**GENERAL NOTES:**
1. Head edge out of roundness shall not exceed .003 FIM.
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 NAS1618.
7. Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
8. Curved or flat edge manufacturer's option.
10. Use HST111 for oversize replacement.
11. 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 UK & 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.

**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).

**HEAT TREAT:**
S90,000 psi shear minimum for 7/8 and larger).

**FINISH:**
- Cetyl alcohol lube per Hi-Shear Spec. 305.
- HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
- I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
- HI-KOTE™ 4 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and apply Precat No. PR1436G sealant (.002-.005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
- HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and apply "KalGard™ RA". "KALGARD" is a trademark of Metal Improvement Company.
- Solid film lube per "Lubeco™ 805". "LUBECO" is a trademark of Lubeco Incorporated.
- HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, with color silver on thread end.
- HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 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.
- HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, with color silver on thread end.
- HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, Cetyl Alcohol Lube Per Hi-Shear Spec. 305.
- HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
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**SPECIFICATION:**

**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.