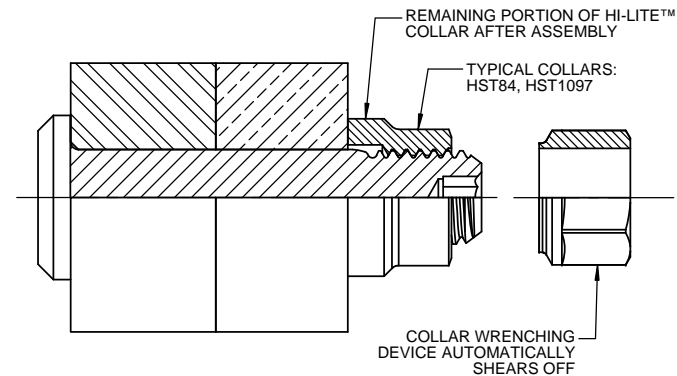
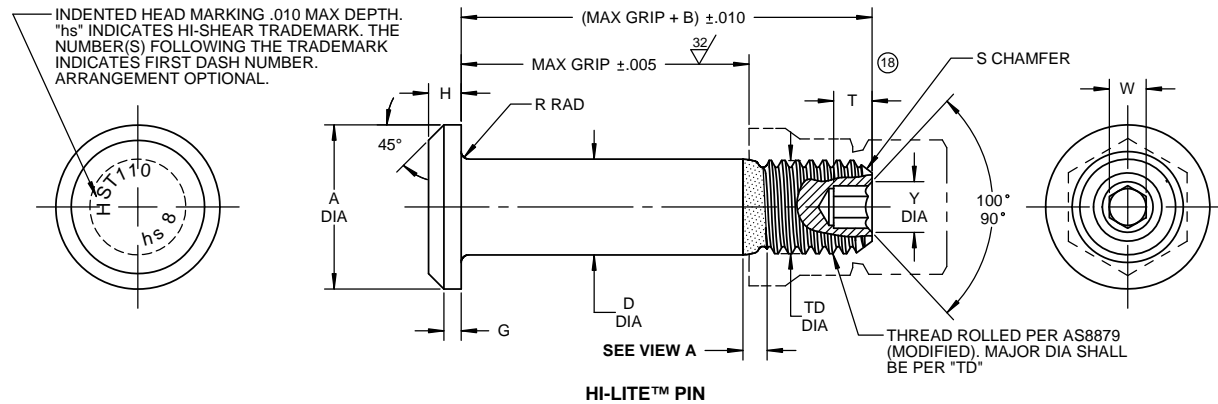


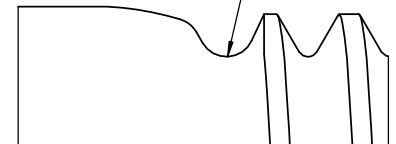
(18)

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



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

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS



VIEW A

HI-LITE™ THREAD TRANSITION AREA
SEE SPECIFICATION FOR INSPECTION

5

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
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
5	3/16						NOTE: USE HST10()6(-)									
6	13/64	.315 .295	.300	.2026 .2021	.2026 .2016	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,130	2,500
8	17/64	.412 .387	.330	.2651 .2646	.2651 .2641	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	10,490	4,300
10	21/64	.505 .475	.390	.3276 .3271	.3276 .3266	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	16,000	6,300
12	25/64	.600 .565	.430	.3901 .3896	.3901 .3891	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	22,700	8,700
14	29/64	.676 .641	.495	.4526 .4521	.4526 .4516	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	30,600	12,100
16	33/64	.770 .735	.535	.5151 .5146	.5151 .5141	.4930 .4880	.050	.116 .103	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	39,600	15,300
18	37/64	.864 .829	.610	.5771 .5766	.5771 .5761	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.2555 .2520	.290 .270	.326 .306	49,700	19,000
20	41/64	.953 .918	.670	.6396 .6391	.6396 .6386	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.2555 .2520	.330 .305	.326 .306	61,000	23,000
24	49/64	1.108 1.066	.905	.7646 .7641	.7646 .7636	.7430 .7370	.070	.151 .136	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.3185 .3150	.395 .365	.398 .378	87,200	30,700
28	57/64	1.285 1.241	1.010	.8896 .8891	.8896 .8886	.8680 .8610	.090	.187 .172	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.3820 .3780	.455 .425	.471 .451	118,000	45,000
32	1-1/64	1.468 1.424	1.170	1.0146 1.0141	1.0146 1.0136	.9930 .9860	.110	.218 .203	.060 .045	5/64 x 37°	1.0000-12 UNJF-3A	.5100 .5040	.580 .550	.618 .598	154,000	60,900

"HI-LITE", "HST", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY D.P.S.	DATE 1983-11-04	TITLE HI-LITE™ PIN PROTRUDING SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED E.E.BEELES	DATE 1983-11-07	
REVISION (18)	DATE M.BEARD 2017-04-18	DRAWING NUMBER HST110

1 OF 2

- 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. Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
 6. Broach petals removed.
 7. Use HST410 for oversize replacement.
 8. 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.
 9. 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).

- FINISH:**
- HST110(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
- 8 HST110AG(-)(-) = 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.
- 8 HST110AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 8 HST110AZ(-)(-) = 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.
- HST110BJ(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST110BL(-)(-) = 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.
- 6 HST110CT(-)(-) = Color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST110CZ(-)(-) = Color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 9 HST110HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
- 6 HST110K(-)(-) = Solid film lube per "Lubeco™" 905. "LUBECO" is a trademark of Lubeco Incorporated.
- 6 HST110MA(-)(-) = Solid film lube per "KalGard™" RA. "KALGARD" is a trademark of Metal Improvement Company.
- HST110RP(-)(-) = Phosphate fluoride treat with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST110RS(-)(-) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color orange on thread end.
- HST110RV(-)(-) = Phosphate fluoride treat, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 8 HST110SU(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color light blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST110TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST110TF(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- HST110UT(-)(-) = Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- HST110UV(-)(-) = Surface coating 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.
- HST110VF(-)(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST110WF(-)(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 8 HST110GD(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST110YV(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 on threads only, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST110NKJ(-)(-) = 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.
- HST110NKK(-)(-) = Sulfuric acid anodizing per ISO8080 and HI-KOTE™ 1 NC 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.
- HST110NKL(-)(-) = HI-KOTE™ 1 NC 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.

SPECIFICATION: HI-LITE™ Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST110 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER

18 **EXAMPLE:** Pin Part Number
 HST110AP8-8

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

HST110

DRAWING NUMBER

HST110

2 OF 2