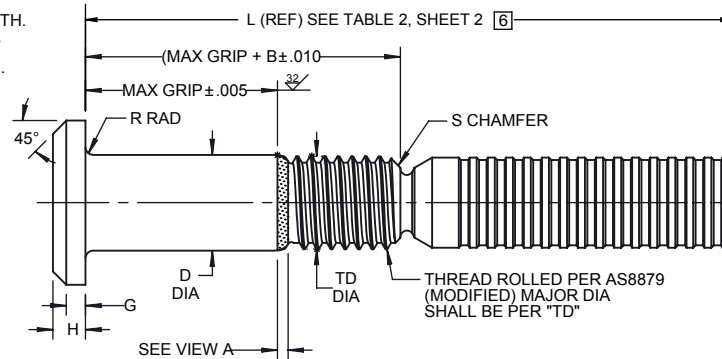
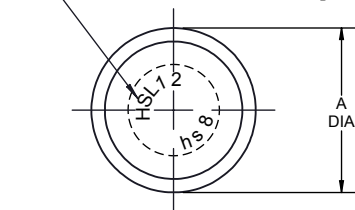
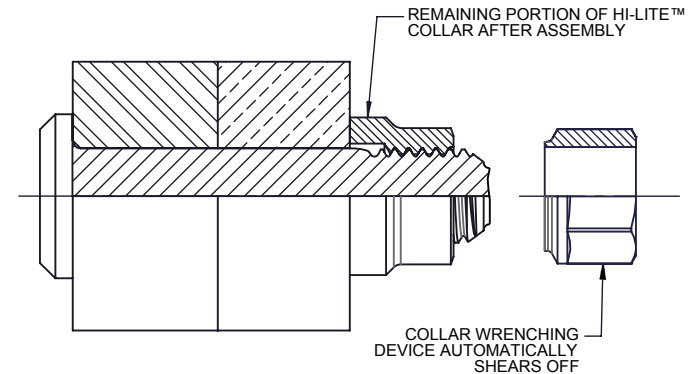


INDENTED HEAD MARKING .010 MAX DEPTH.
MANUFACTURER'S TRADEMARK "hs" PER
SPEC. 363. THE NUMBER(S) FOLLOWING
TRADEMARK INDICATES FIRST DASH. NO.
ARRANGEMENT OPTIONAL. ④



HI-LITE™ PIN



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	K MAX	R RAD	S CHAMFER REF	THREAD MODIFIED	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	5/32	.322 .306	.280	.1635 .1625	.1595 .1570	.030	.065 .055	.013	.025 .015	1/32 x 37°	.1640-32 UNJC-3A	4,010	2,180
6	3/16	.377 .357	.290	.1895 .1885	.1840 .1810	.035	.074 .064	.016	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	5,380	3,180
8	1/4	.440 .415	.320	.2495 .2485	.2440 .2410	.045	.090 .080	.021	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	9,300	5,820
10	5/16	.505 .485	.380	.3120 .3110	.3060 .3020	.055	.112 .102	.026	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	14,600	9,200
12	3/8	.600 .580	.420	.3745 .3735	.3680 .3640	.075	.140 .130	.030	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	21,000	14,000
14	7/16	.676 .651	.500	.4370 .4360	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	28,600	18,900
16	1/2	.770 .745	.600	.4995 .4985	.4930 .4880	.095	.188 .178	.039	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	37,300	25,600

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

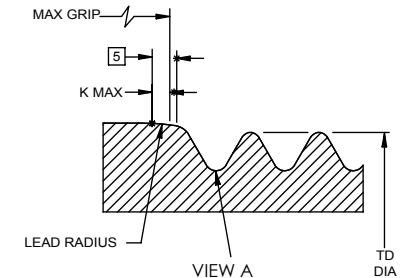
- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIM.
 - Dimensions are in inches and to be met after finish, except as noted.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
 - Shorter or longer grips than those listed may be available as specials.
 - After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

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

④ EXAMPLE:

Pin Part Number
HSL12AP8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number



HI-LITE THREAD TRANSITION AREA.
THIS AREA OF SPECIAL CONFIGURATION
AND COLD WORKING TO MEET PHYSICAL
REQUIREMENTS. SEE SPECIFICATION
FOR INSPECTION.

MATERIAL: 6AL-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

- FINISH:**
- HSL12AP() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HSL12AG() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HSL12NKA() = HI-KOTE™ 1NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 380-2.

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F. OBISPO	DATE 2000-11-02	TITLE HI-LITE™ PIN PROTRUDING TESNION HEAD BREAK STEM, INTERFERENCE FIT TITANIUM 1/16 GRIP VARIATION	
APPROVED M.C.	DATE 2000-11-03	DRAWING NUMBER HSL12	
REVISION ④	DATE K. TRAN 2017-10-31	1 OF 2	

TABLE 2

SECOND DASH NUMBER	L REF 6						
	-5 DIA.	-6 DIA.	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.
1	-	-	-	-	-	-	-
2	.875	1.000	1.000	-	-	-	-
3	1.000	1.125	1.125	1.250	-	-	-
4	1.125	1.250	1.250	1.375	1.375	-	-
5	1.250	1.375	1.375	1.500	1.500	1.625	1.625
6	1.375	1.500	1.500	1.625	1.625	1.750	1.750
7	1.500	1.625	1.625	1.750	1.750	1.875	1.875
8	1.625	1.750	1.750	1.875	1.875	2.000	2.000
9	1.750	1.875	1.875	2.000	2.000	2.125	2.125
10	1.875	2.000	2.000	2.125	2.125	2.250	2.250
11	2.000	2.125	2.125	2.250	2.250	2.375	2.375
12	2.125	2.250	2.250	2.375	2.375	2.500	2.500
13	2.250	2.375	2.375	2.500	2.500	2.625	2.625
14	2.375	2.500	2.500	2.625	2.625	2.750	2.750
15	2.500	2.625	2.625	2.750	2.750	2.875	2.875
16	2.625	2.750	2.750	2.875	2.875	3.000	3.000
17	2.750	2.875	2.875	3.000	3.000	3.125	3.125
18	2.875	3.000	3.000	3.125	3.125	3.250	3.250
19	3.000	3.125	3.125	3.250	3.250	3.375	3.375
20	3.125	3.250	3.250	3.375	3.375	3.500	3.500
21	-	3.375	3.375	3.500	3.500	3.625	3.625
22	-	3.500	3.500	3.625	3.625	3.750	3.750
23	-	3.625	3.625	3.750	3.750	3.875	3.875
24	-	3.750	3.750	3.875	3.875	4.000	4.000
25	-	-	-	4.000	4.000	4.125	4.125
26	-	-	-	4.125	4.125	4.250	4.250
27	-	-	-	4.250	4.250	4.375	4.375
28	-	-	-	4.375	4.375	4.500	4.500
29	-	-	-	-	4.500	4.625	4.625
30	-	-	-	-	4.625	4.750	4.750
31	-	-	-	-	4.750	4.875	4.875
32	-	-	-	-	4.875	5.000	5.000
33	-	-	-	-	5.000	5.125	5.125
34	-	-	-	-	5.125	5.250	5.250
35	-	-	-	-	5.250	5.375	5.375
36	-	-	-	-	5.375	5.500	5.500
37	-	-	-	-	5.500	5.625	5.625
38	-	-	-	-	5.625	5.750	5.750
39	-	-	-	-	5.750	5.875	5.875
40	-	-	-	-	5.875	6.000	6.000
41	-	-	-	-	6.000	6.125	6.125
42	-	-	-	-	6.125	6.250	6.250
43	-	-	-	-	6.250	6.375	6.375
44	-	-	-	-	6.375	6.500	6.500

DRAWING NUMBER

HSL12