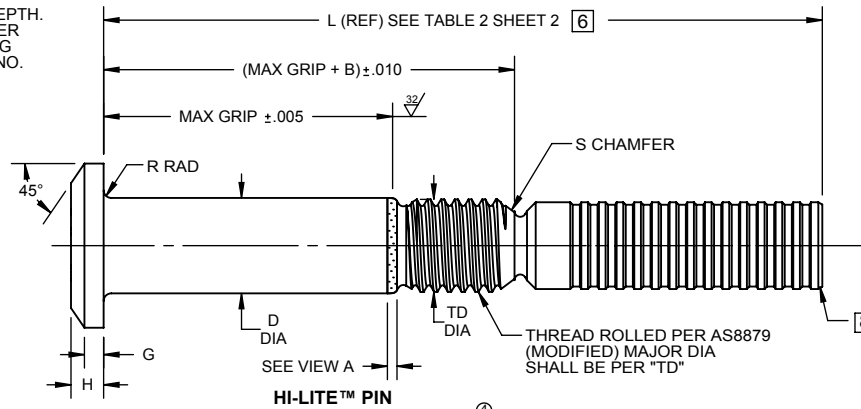
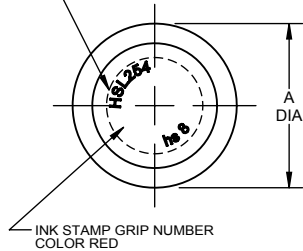


INDENTED HEAD MARKING .010 MAX DEPTH.  
MANUFACTURER'S TRADEMARK "hs" PER  
SPEC. 363. THE NUMBER(S) FOLLOWING  
TRADEMARK INDICATES FIRST DASH. NO.  
ARRANGEMENT OPTIONAL. ④



HI-LITE™ PIN

④

TABLE 1

| FIRST DASH NO. | PIN NOM DIA | A DIA        | B REF | D DIA          | TD DIA         | G REF | H            | R RAD        | S CHAMFER REF | THREAD MODIFIED     | DOUBLE SHEAR POUNDS MINIMUM | TENSION POUNDS MINIMUM |
|----------------|-------------|--------------|-------|----------------|----------------|-------|--------------|--------------|---------------|---------------------|-----------------------------|------------------------|
| 6              | 7/32        | .390<br>.370 | .300  | .2182<br>.2172 | .1840<br>.1810 | .035  | .074<br>.064 | .025<br>.015 | 1/32 x 45°    | .1900-32<br>UNJF-3A | 9,400                       | 4,350                  |
| 8              | 9/32        | .460<br>.435 | .330  | .2807<br>.2797 | .2440<br>.2410 | .045  | .090<br>.080 | .025<br>.015 | 1/32 x 45°    | .2500-28<br>UNJF-3A | 15,500                      | 7,750                  |
| 10             | 11/32       | .520<br>.490 | .390  | .3432<br>.3422 | .3060<br>.3020 | .055  | .112<br>.102 | .030<br>.020 | 3/64 x 45°    | .3125-24<br>UNJF-3A | 23,200                      | 12,300                 |
| ⑧ 12           | 13/32       | .620<br>.585 | .430  | .4057<br>.4047 | .3680<br>.3640 | .075  | .140<br>.130 | .030<br>.020 | 3/64 x 45°    | .3750-24<br>UNJF-3A | 32,400                      | 19,100                 |
| ⑧ 14           | 15/32       | .695<br>.660 | .510  | .4682<br>.4672 | .4310<br>.4260 | .095  | .160<br>.150 | .030<br>.020 | 3/64 x 45°    | .4375-20<br>UNJF-3A | 43,100                      | 25,800                 |
| ⑧ 16           | 17/32       | .790<br>.755 | .610  | .5307<br>.5297 | .4930<br>.4880 | .095  | .188<br>.178 | .030<br>.020 | 3/64 x 45°    | .5000-20<br>UNJF-3A | 55,400                      | 34,300                 |

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIM.
  - ④ Dimensions are in inches and to be met after finish.
  - ④ Surface texture per ASME B46.1.
  - Hole preparation per NAS618.
  - Lead radius must be tangent to "D" diameter at maximum grip.
  - ⑥ Shorter or longer grips than those listed may be available as specials.
  - Oversize pin for HSL54 and HSL154.
  - ⑧ Paint or dye pin tail flat end with color: orange for -12 size, green for -14 size, and blue for -16 size. Paint overspray is permissible.
  - ④ ⑨ 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.

**MATERIAL:** Nickel base alloy per AMS5662.

**HEAT TREAT:** 125,000 psi shear minimum.

**FINISH:** ④ ⑨ HSL254AP( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

④ ⑨ HSL254AG( )-( ) = 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.

HSL254DL( )-( ) = KALGARD FA or EM620C solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.

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

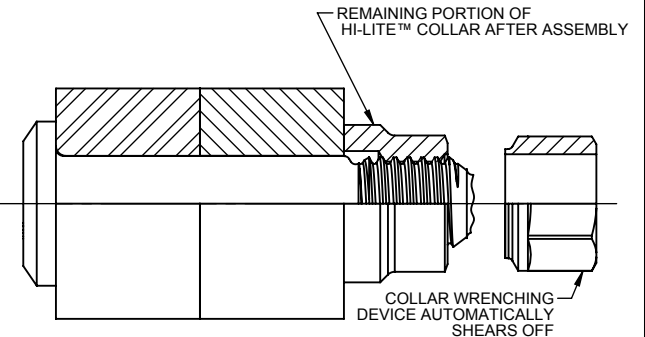
**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HSL254 oversize pin replaces.  
Second dash number indicates maximum grip in 1/16ths.  
See "Finish" note for explanation of code letters.

**HOW TO ORDER**

④ **EXAMPLE:**

Pin Part Number  
HSL254AP8-8

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



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

THIS AREA OR SPECIAL CONFIGURATION  
AND COLD WORKING TO MEET PHYSICAL  
REQUIREMENTS.



VIEW A

HI-LITE™ THREAD TRANSITION AREA.  
SEE SPECIFICATION FOR INSPECTION

"HI-KOTE", "HI-LITE", "PULL-STEM" AND "HSL",  
ARE TRADEMARKS OF HI-SHEAR CORPORATION

|                        |                                    |                                                                                                                                                           |
|------------------------|------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------|
| DRAWN BY<br>J.F.OBISPO | DATE<br>1996-04-17                 | TITLE<br>HI-LITE™ PIN<br>PROTRUDING TENSION HEAD<br>BREAK STEM, INTERFERENCE FIT<br>NICKEL BASE ALLOY (INCONEL 718)<br>1/16 GRIP VARIATION, 1/32 OVERSIZE |
| APPROVED<br>J.RAUSCH   | DATE<br>1996-22-17                 | DRAWING NUMBER<br><b>HSL254</b>                                                                                                                           |
| REVISION<br>④          | DATE<br>F.CARINGELLA<br>2017-12-08 | 1 OF 2                                                                                                                                                    |

TABLE 2

| SECOND<br>DASH<br>NUMBER | L REF [6] |       |       |       |       |       |       |
|--------------------------|-----------|-------|-------|-------|-------|-------|-------|
|                          |           | -6    | -8    | -10   | -12   | -14   | -16   |
| 1                        |           | -     | -     | -     | -     | -     | -     |
| 2                        |           | 1.000 | 1.000 | -     | -     | -     | -     |
| 3                        |           | 1.125 | 1.125 | 1.250 | -     | -     | -     |
| 4                        |           | 1.250 | 1.250 | 1.375 | 1.375 | -     | -     |
| 5                        |           | 1.375 | 1.375 | 1.500 | 1.500 | 1.625 | -     |
| 6                        |           | 1.500 | 1.500 | 1.625 | 1.625 | 1.750 | 1.750 |
| 7                        |           | 1.625 | 1.625 | 1.750 | 1.750 | 1.875 | 1.875 |
| 8                        |           | 1.750 | 1.750 | 1.875 | 1.875 | 2.000 | 2.000 |
| 9                        |           | 1.875 | 1.875 | 2.000 | 2.000 | 2.125 | 2.125 |
| 10                       |           | 2.000 | 2.000 | 2.125 | 2.125 | 2.250 | 2.250 |
| 11                       |           | 2.125 | 2.125 | 2.250 | 2.250 | 2.375 | 2.375 |
| 12                       |           | 2.250 | 2.250 | 2.375 | 2.375 | 2.500 | 2.500 |
| 13                       |           | 2.375 | 2.375 | 2.500 | 2.500 | 2.625 | 2.625 |
| 14                       |           | 2.500 | 2.500 | 2.625 | 2.625 | 2.750 | 2.750 |
| 15                       |           | 2.625 | 2.625 | 2.750 | 2.750 | 2.875 | 2.875 |
| 16                       |           | 2.750 | 2.750 | 2.875 | 2.875 | 3.000 | 3.000 |
| 17                       |           | 2.875 | 2.875 | 3.000 | 3.000 | 3.125 | 3.125 |
| 18                       |           | 3.000 | 3.000 | 3.125 | 3.125 | 3.250 | 3.250 |
| 19                       |           | 3.125 | 3.125 | 3.250 | 3.250 | 3.375 | 3.375 |
| 20                       |           | 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

**HSL254**