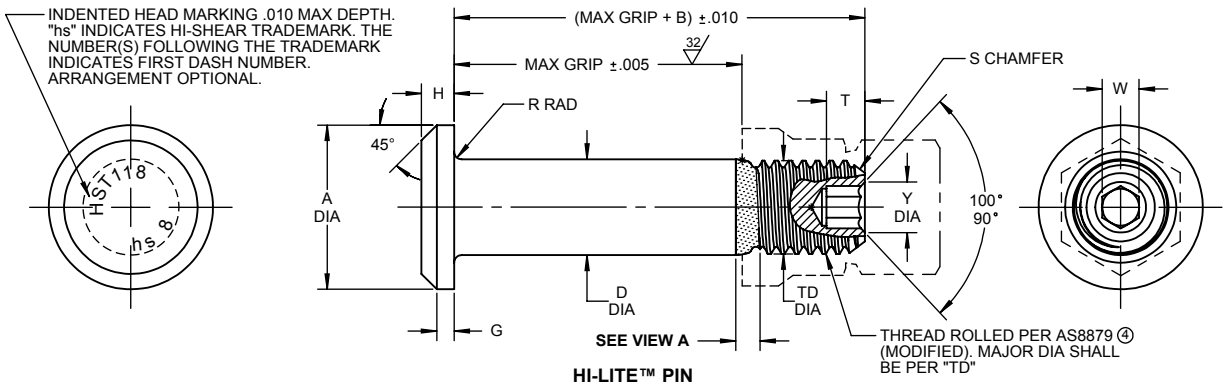
lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

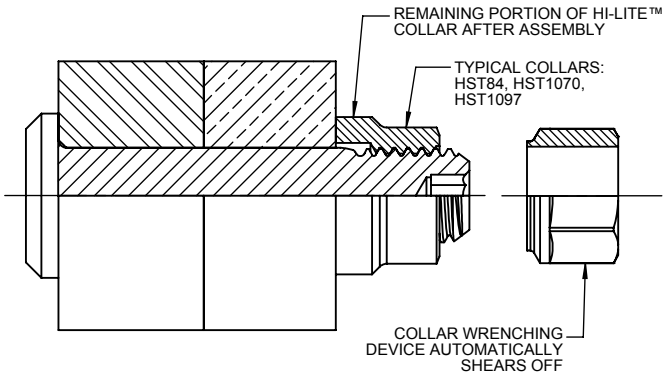
Design Holder

CAGE No. 73197

④ For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



HI-LITE™ PIN

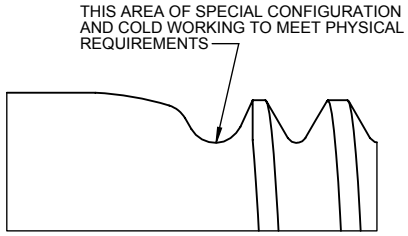


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

④

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 W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	3/16				NOTE: USE HST18( )6-( )										
6	13/64	.315 .295	.300	.2026 .2016	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,130	2,500
8	17/64	.412 .387	.330	.2651 .2641	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	10,490	4,300
10	21/64	.505 .475	.390	.3276 .3266	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	16,000	6,300
12	25/64	.600 .565	.430	.3901 .3891	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	22,700	8,700
14	29/64	.676 .641	.495	.4526 .4516	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	30,600	12,100
16	33/64	.770 .735	.535	.5151 .5141	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	39,600	15,300



VIEW A

HI-LITE™ THREAD TRANSITION AREA
SEE SPECIFICATION FOR INSPECTION

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

DRAWN BY	DATE	TITLE
D.P.S.	1990-08-03	HI-LITE™ PIN PROTRUDING SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED JGWILCOX	DATE 1990-08-03	
REVISION ④	DATE M.BEARD 2017-04-27	DRAWING NUMBER **HST118**

1 OF 2

HST118

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GENERAL NOTES:
1. Concentricity: "A" diameter to "D" diameter within .010 FIM.
④ 2. Dimensions are in inches and to be met after finish.
④ 3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
[5] Non-lubed pins must be used with wet sealant or with lubed collars.
6. Use HST218 for oversize replacement.

MATERIAL: ④Alloy steel per AMS6415, AMS6349, AMS6322 or AMS6327 or AMS6325.

HEAT TREAT: 95,000 psi minimum (160,000 - 180,000 psi tensile per AMS-H-6875).

FINISH:
HST118-( )-( ) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST118PA( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST118PB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
[5] HST118PN( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
HST118RZ( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST118TF( )-( ) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
HST118TP( )-( ) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305

SPECIFICATION: HI-LITE™ Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST118 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
HST118PB8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

~~Pin and Collar Assembly Part Number Combination~~
~~HST118PB1070-8-8~~
- ~~Size and Grip Length, See Above Example~~
- ~~Collar Part Number~~
- ~~Pin Finish~~
- ~~Pin Part Number~~

HST118

DRAWING NUMBER
HST118