



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
											W HEX	T DEPTH	Y DIA		
5				NOTE: USE HST20-6 ()											
6	13/64	.377 .357	.300	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,130	3,180
8	17/64	.440 .415	.330	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	10,490	5,820
10	21/64	.505 .475	.390	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	16,000	9,200
12	25/64	.600 .565	.430	.3901 .3891	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	22,700	14,000
14	29/64	.676 .641	.510	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	30,600	18,900
16	33/64	.770 .735	.610	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	39,600	25,600

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

- GENERAL NOTES:**
1. Concentricity: "A" 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. Non-lubed pins must be used with wet sealant or with lubed collar.
 6. Use HST220 for oversize replacement.

MATERIAL: ③ Alloy steel per AMS6415, AMS6349, or AMS6322, AMS6325, AMS6327.

HEAT TREAT: 160,000 - 180,000 psi tensile per AMS-H-6875.

FINISH: HST120-()-() = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST120CG()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST120PB()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 ⑤ HST120PN()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

SPECIFICATION: HI-LITE™ Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST120 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER
 ③ **EXAMPLE:**

Pin Part Number
HST120PB8-8
 — 8/16 or 1/2 Maximum Grip Length
 — Replaces 8/32 or 1/4 Nominal Diameter Pin
 — Finish Code
 — Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HST120PB1078-8-8
 — Size and Grip Length, See Above Example
 — Collar Part Number
 — Pin Finish
 — Pin Part Number

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



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 D.P.S.	DATE 1991-09-05	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED J.G. WILCOX	DATE 1991-09-16		
REVISION ③	DATE K. TRAN 2017-10-10	DRAWING NUMBER HST120	