2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A

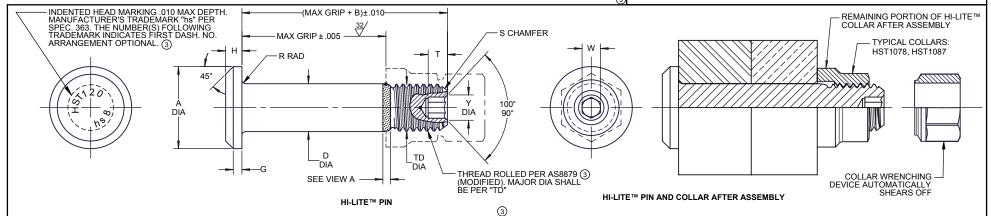
HI-SHEAR Corporation, USA a LISI AEROSPACE Company

Design Holder

CAGE No. 73197

For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:

HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



SOCKET DOUBLE **TENSION** FIRST PIN TD G SHEAR THREAD DASH NOM **POUNDS** н т Υ DIA REF DIA DIA REF RAD CHAMFER POUNDS **MODIFIED** NO. DIA MINIMUM **DEPTH** HEX DIA MINIMUM REF NOTE: USE HST20-6-() 5 .377 .2026 .1840 .025 .1900-32 UNJF-3A .0806 .100 .119 6 13/64 .300 .035 1/32 x 45° 6,130 3,180 .2016 .357 .1810 .064 .015 .0791 .080 .104 .440 .2651 .2440 .090 .025 .2500-28 .0967 .110 .142 .330 17/64 .045 1/32 x 45° 10.490 5.820 .2410 UNJF-3A 415 .2641 .080 .015 .0947 .122 .090 .505 .3276 .3060 .112 .030 .3125-24 1295 .130 .180 10 .390 .055 21/64 3/64 x 45° 16,000 9,200 UNJF-3A 1270 475 .3266 .3020 102 .020 .110 .160 .600 .3901 .3680 .140 .030 .3750-24 1617 .160 .217 12 25/64 .430 .075 3/64 x 45° 22,700 14,000 UNJF-3A .130 .565 .3891 .3640 .020 1582 197 .140 .676 .4526 .4310 .160 .030 1930 .190 .253 4375-20 29/64 14 .510 .095 3/64 x 45° 30,600 18,900 UNJF-3A .641 .4516 .4260 .150 .020 1895 .170 .233 .188 .030 .5000-20 UNJF-3A 2242 .220 770 4930 289 5151 33/64 .610 .095 3/64 x 45° 39,600 25,600 4880 178 2207 .200 .269 .735 .5141 .020

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.

③ 2. Dimensions are in inches and to be met after finish.

③ 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.

HOW TO ORDER ③ EXAMPLE:

CODE:

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.

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.

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

HI-LITE™ THREAD TRANSITION AREA SEE SPECIFICATION FOR INSPECTION

VIEW A

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL

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

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

REQUIREMENTS-

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

©2017 Hi-Shear Corporation