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

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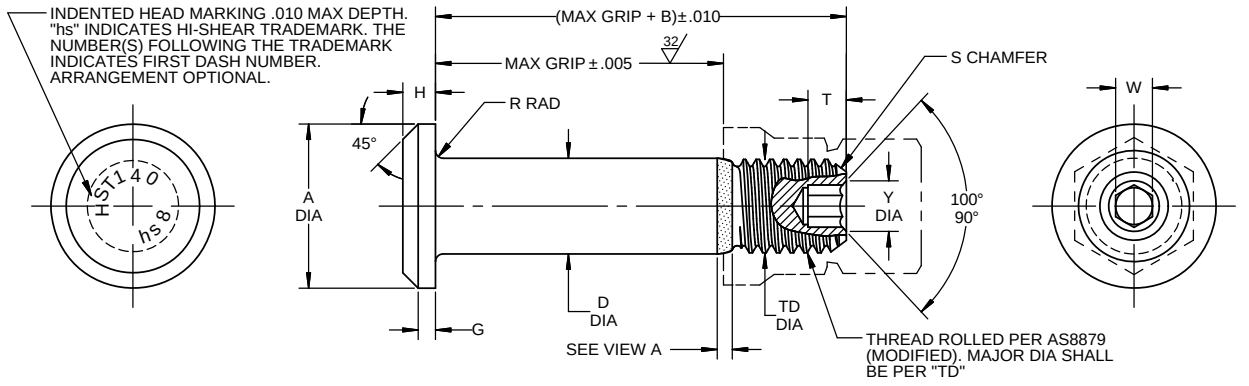
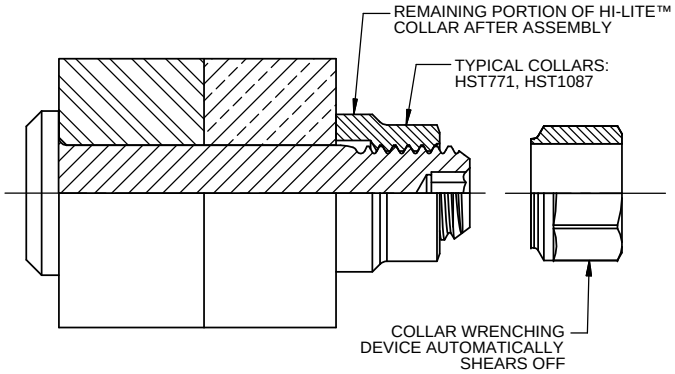
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



HI-LITE™ PIN



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

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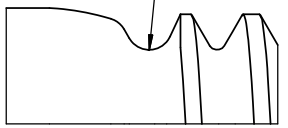
FIRST DASH NO.	PIN NOM DIA	**A** DIA	**B** REF	**D** DIA WITHOUT PLATING, OR SOLID FILM LUBE	**D** DIA WITH PLATING, OR SOLID FILM LUBE	**TD** DIA	**G** REF	**H**	**R** RAD	**S** CHAMFER REF	**THREAD** MODIFIED	SOCKET **W** HEX	SOCKET **T** DEPTH	SOCKET **Y** DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	5/32				NOTE: USE HST40-6-( )											
6	13/64	.315 .295	.300	.2026 .2021	.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 .2646	.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 .3271	.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 .3896	.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 .4521	.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 .5146	.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

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	DATE	TITLE
D.P.S.	1983-12-23	HI-LITE™ PIN PROTRUDING SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED	DATE	
E.E.BEELES	1984-01-03	
REVISION	DATE	DRAWING NUMBER
③	M.BEARD 2017-05-01	**HST140** 1 OF 2

HST140

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GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within .010 FIM.
③ 2. Dimensions are in inches and to be met after finish.
[3] Non-lubed pins must be used with lubed collars.
③ 4. Surface texture per ASME B46.1.
5. Hole preparation per NAS618.
6. Use HST240 for oversize replacement.

MATERIAL: A-286 high temperature alloy per AMS5737 or AMS5731.

HEAT TREAT: 95,000 psi shear minimum at 70°F.

FINISH:
HST140-( )-( ) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
[3] HST140DU( )-( ) = Solid film lube per AS5272, Type I.
HST140GU( )-( ) = Silver plate per AMS2410.
[3] HST140NY( )-( ) = Passivate per Hi-Shear Spec. 258 with black paint on thread.
HST140PY( )-( ) = Passivate per Hi-Shear Spec. 258.
HST140TF( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
HST140V( )-( ) = Solid film lubricant per "Lubeco" 2123, Type II.
HST140NKJ( )-( ) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
HST140NKL( )-( ) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
③ HST140HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LITE™ Product Specification 380.

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
③ **EXAMPLE:** Pin Part Number
HST140V8-8

- 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~~
~~HST140V771-8-8~~

- ~~Size and Grip Length, See Above Example~~
- ~~Collar part Number~~
- ~~Pin Finish~~
- ~~Pin Part Number~~

HST140

DRAWING NUMBER
HST140