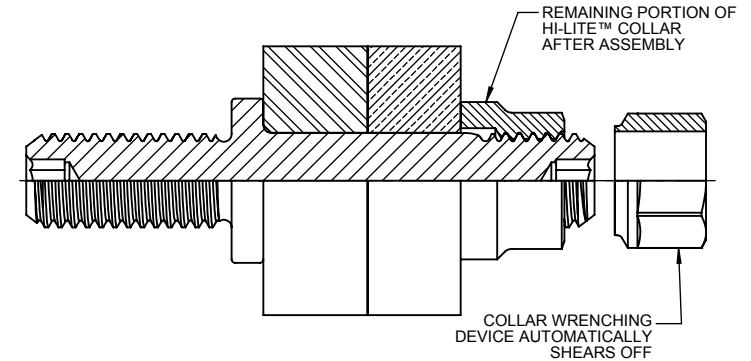


HI-LITE™ THREADED STUD PIN



HI-LITE™ THREADED STUD PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
										W HEX	T DEPTH	Y DIA		
6	3/16	.377 .357	.290	.1895 .1885	.1840 .1810	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,380	3,180
8	1/4	.440 .415	.320	.2495 .2485	.2440 .2410	.087 .077	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,300	5,820
10	5/16	.502 .472	.380	.3120 .3110	.3060 .3020	.108 .098	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,600	9,200
12	3/8	.565 .530	.420	.3745 .3735	.3680 .3640	.130 .120	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,000	14,000

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

- GENERAL NOTES:**
1. Concentricity: Head to "D" diameter within .010 FIM. Threaded stud to "D" diameter within .005 FIM.
 2. Dimensions are in inches and to be met after finish.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.

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

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

FINISH: HST230-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.

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. Third dash number indicates stud end grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER
EXAMPLE:**

Threaded Stud Pin Part Number
 HST230-8-8-8

8/16 or 1/2 Threaded Stud End Length
 8/16 or 1/2 Pin Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Pin Basic 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 1989-12-22	TITLE HI-LITE™ THREADED STUD PIN PROTRUDING HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION
APPROVED DAW	DATE 1990-01-02	
REVISION 4	DATE F.CARINGELLA 2019-06-19	DRAWING NUMBER HST230