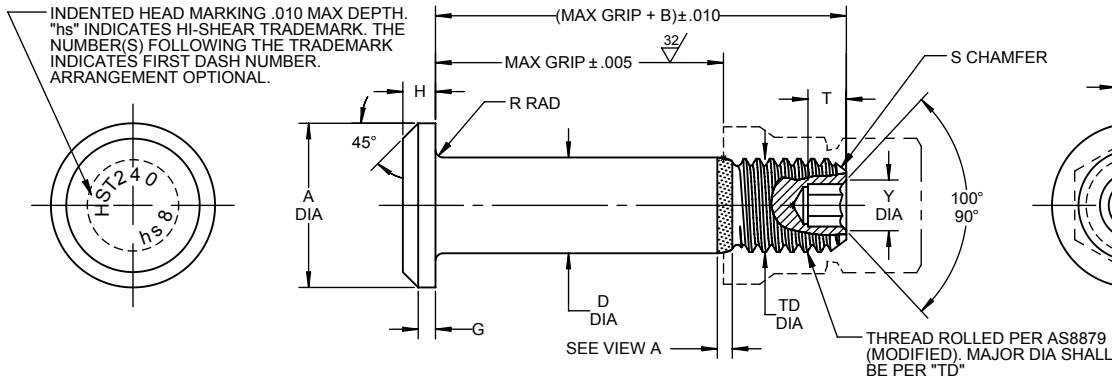
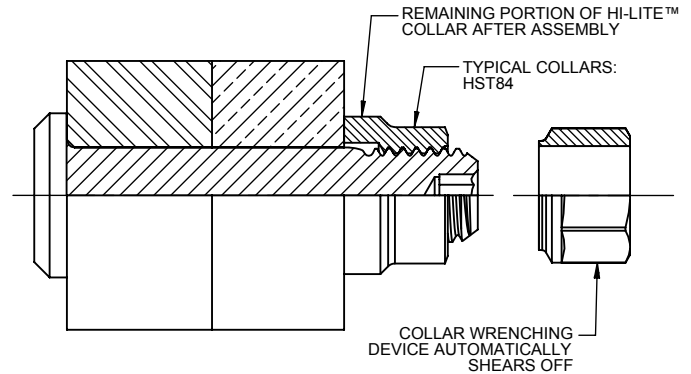


④ For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
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HI-LITE™ PIN



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

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
				WITHOUT PLATING OR SOLID FILM LUBE	WITH PLATING OR SOLID FILM LUBE							W HEX	T DEPTH	Y DIA		
5	5/32			NOTE: USE HST140-6-()												
6	7/32	.315 295	.300	.2182 2177	.2182 2172	.1840 1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,100	2,500
8	9/32	.412 387	.330	.2807 2802	.2807 2797	.2440 2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	11,800	4,300
10	11/32	.505 475	.390	.3432 3427	.3432 3422	.3060 3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	17,600	6,300
12	13/32	.600 565	.430	.4057 4052	.4057 4047	.3680 3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	24,600	8,700
14	15/32	.676 641	.495	.4682 4677	.4682 4672	.4310 4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	32,700	12,100
16	17/32	.770 735	.535	.5307 5302	.5307 5297	.4930 4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 2207	.220 200	.289 269	42,000	15,300

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIM.
 - Dimensions are in inches and to be met after finish.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Non-lubed pins must be used with lubed collars.
 - Maximum "D" diameter may be increased by .0002 to allow for solid film lube application.
 - Override pin for HST40 and HST140.

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

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

- FINISH:** HST240-(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST240DU(-)(-) = Solid film lube per AS5272, Type I.
- ⑤ HST240GU(-)(-) = Silver plate per AMS2410.
- ⑤ HST240PY(-)(-) = Passivate per Hi-Shear Spec. 258.
- HST240TF(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- HST240V(-)(-) = Solid film lubricant per "Lubeco" 2123, Type II.
- HST240NKJ(-)(-) = 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.
- HST240NKL(-)(-) = 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.
- ④ HST240HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397

SPECIFICATION: HI-LITE™ Product Specification 380.

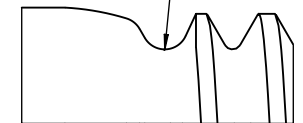
CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST240 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

④ **EXAMPLE:** Pin Part Number HST240TF8-8

8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 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 1983-12-23	TITLE HI-LITE™ PIN PROTRUDING SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED E.E.BEELES	DATE 1984-11-16	DRAWING NUMBER HST240	
REVISION ④	DATE M.BEARD 2017-04-24	1 OF 1	