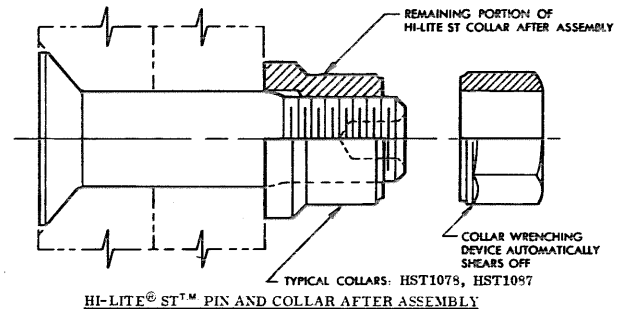
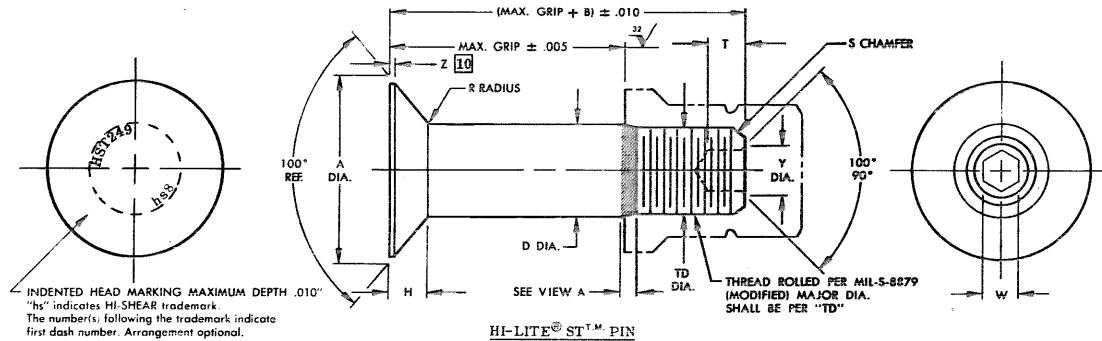


hi-shear
CORPORATION

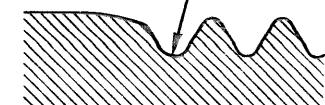
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA. 8		TD DIA.	1		R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE		F	H					W HEX.	T DEPTH	Y DIA.		
- 5				NOTE: USE HST49-6													
- 6	3/16	.3813 .3765	.290	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0750 .0730	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	3,180
- 8	1/4	.5066 .5018	.320	.2651 .2646	.2651 .2641	.2440 .2410	.006	.1013 .0993	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	5,820
- 10	5/16	.6335 .6287	.380	.3276 .3271	.3276 .3266	.3060 .3020	.007	.1283 .1263	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	9,200
- 12	3/8	.7604 .7556	.420	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1553 .1533	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	14,000
- 14	7/16	.8884 .8812	.485	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1828 .1798	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	18,900
- 16	1/2	1.0139 1.0068	.525	.5151 .5146	.5151 .5141	.4930 .4880	.010	.2093 .2063	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	39,600	25,600

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH IPIN OR COLLAR DETERMINES SYSTEM STRENGTH.

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



VIEW A
HI-LITE THREAD TRANSITION AREA.
SEE SPECIFICATION FOR INSPECTION.

- GENERAL NOTES:
- Head edge out of roundness shall not exceed "F."
 - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - "H" dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Non-lubed pins must be used with lubed collars.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Maximum "D" diameter may be increased by .0002 to allow for solid film or plating application.
 - Evidence of broken edge across points.
 - Curved or flat edge manufacturer's option.

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

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum) at 70°F.

FINISH: HST249-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HST249DU-()-() = Solid film lube per MIL-L-8937.
HST249GU-()-() = Silver plate per AMS2410.
HST249PY-()-() = Passivate per Hi-Shear Spec. 258.
HST249TF-()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.

SPECIFICATION: Hi-Lite Product Specification 390.

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
EXAMPLES:

Pin Part Number Only
HST249-8-8
8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HST2491078-8-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

U.S. Patents 4,326,925 and 4,495,510. Other U.S. and foreign patents pending. "Hi-Lite" is a registered trademark, and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.	
DRAWN D.P.S.	DATE 11-7-85
APPROVED E.E.B.	DATE 11-7-85
REVISION	DATE
TITLE HI-LITE® ST™ PIN 100° FLUSH MS24694 TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION - 1/64" OVERSIZE DRAWING NUMBER HST249	

HST249