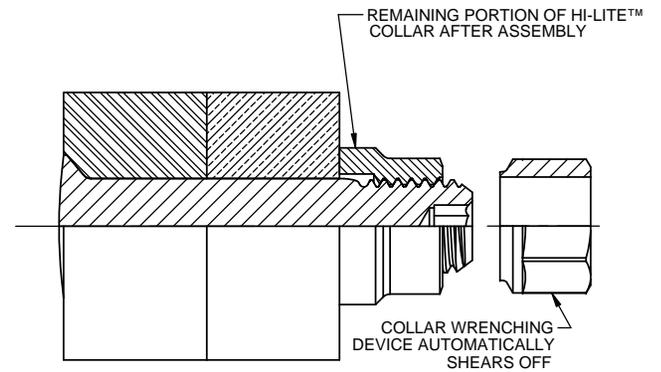
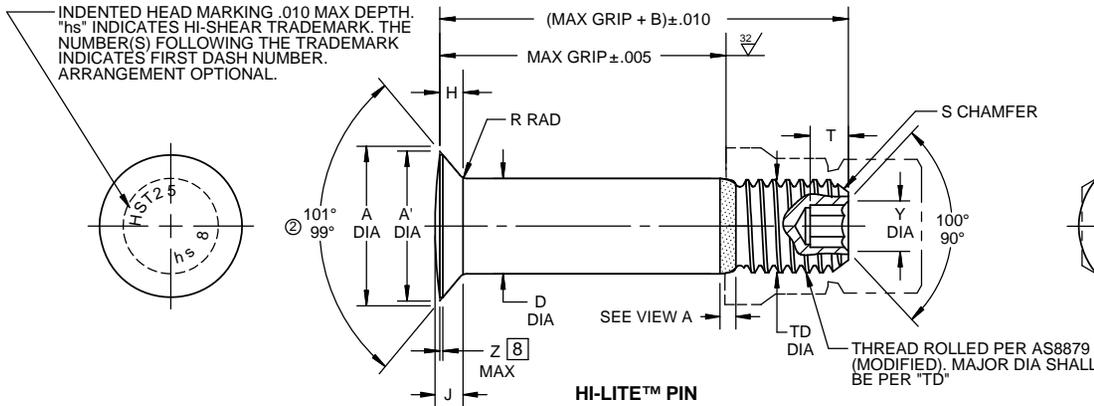


②

For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://WWW.LISI-AEROSPACE.COM/LICENSES)

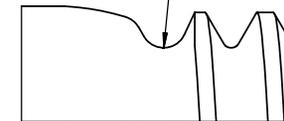


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA THEO	A' DIA	B REF	D DIA		TD DIA	F	H REF	J	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
					WITHOUT COATING OR SOLID FILM	WITH COATING OR SOLID FILM									W HEX	T DEPTH	Y DIA		
5	5/32	.2636	.252 .239	.280	.1635 .1630	.1635 .1625	.1595 .1570	.004	.042	.056 .055	.025 .015	.010	1/32 x 37°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	.104 .094	5,280	1,700
6	3/16	.3048	.293 .276	.290	.1895 .1890	.1895 .1885	.1840 .1810	.005	.048	.065 .064	.030 .020	.012	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,060	2,600
8	1/4	.4001	.388 .365	.320	.2495 .2490	.2495 .2485	.2440 .2410	.006	.063	.086 .084	.030 .020	.015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	12,260	4,400
10	5/16	.4992	.487 .459	.380	.3120 .3115	.3120 .3110	.3060 .3020	.007	.078	.107 .105	.040 .030	.018	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	19,160	7,000
12	3/8	.5984	.586 .553	.420	.3745 .3740	.3745 .3735	.3680 .3640	.008	.093	.129 .126	.040 .030	.020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	27,600	10,000
14	7/16	.6976	.686 .646	.485	.4370 .4365	.4370 .4360	.4310 .4260	.009	.111	.150 .147	.050 .040	.022	3/64 x 37°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	37,500	13,500
16	1/2	.7968	.785 .740	.525	.4995 .4990	.4995 .4985	.4930 .4880	.010	.124	.172 .168	.050 .040	.025	3/64 x 37°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	49,100	18,000

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN 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

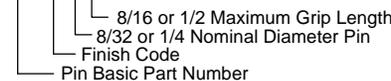
- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions are in inches and to be met after finish.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Maximum "D" diameter may be increased by .0002 too allow for solid film or aluminum coating application.
 - Curved or flat edge manufacturer's option.
 - Use HST125 for oversize replacement.

- FINISH:** HST25(-)(-) = Passivate per Hi-Shear Spec. 258 an cetyl alcohol lube per Hi-Shear Spec. 305.
 HST25DU(-)(-) = Solid film lube per MIL-PRF-46010.
 HST25GU(-)(-) = Silver Plate per AMS2410
 HST25PY(-)(-) = Passivate per Hi_Shear Spec. 258.
 HST21TF(-)(-) = HI-KOTE™2 solid film lube per Hi-Shear Spec. 292.
 HST21V(-)(-) = Solid film lubricant per "Lubeco" 2123, Type II.
 ② HST25HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

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

② **EXAMPLE:** Pin Part Number HST25AP8-8



"HI-LITE", "HST", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION	
DRAWN BY D.P.S.	DATE 1989-07-25
APPROVED E.E.BEELES	DATE 1989-07-25
REVISION ②	DATE M.BEARD 2017-05-01
TITLE HI-LITE™ PIN 100° SPECIAL FLUSH CROWN SHEAR HEAD INCONEL 718 1/16 GRIP VARIATION DRAWING NUMBER HST25	
1 OF 1	