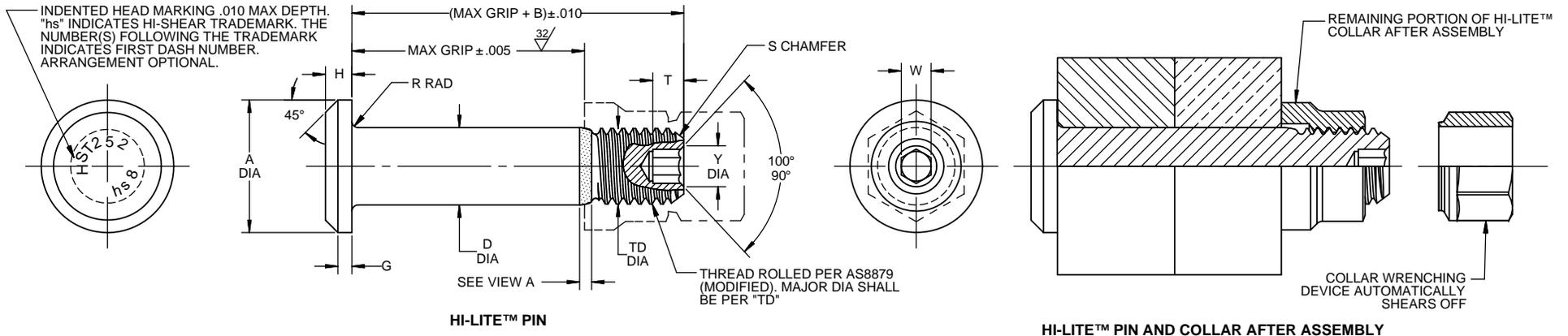


④ For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://WWW.LISI-AEROSPACE.COM/LICENSES)



HI-LITE™ PIN

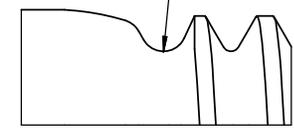
HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

④

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 COATING OR SOLID FILM	WITH COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
NOTE: USE HST152()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	9,400	3,000
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	15,500	5,100
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	23,200	8,000
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	32,400	11,300
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	43,100	15,500
16	17/32	.770 .735	.535	.5307 .5302	.5307 .5297	.4930 .4880	.050	.116 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,400	20,000

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 J.F.OBISPO	DATE 1996-01-20	TITLE HI-LITE™ PIN PROTRUDING SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED MC	DATE 1996-01-21	
REVISION ④	DATE M.BEARD 2017-04-26	DRAWING NUMBER HST252

1 OF 2

HST252

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 - ④ 2. Dimensions are in inches and to be met after finish.
 - ④ 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 5. Oversize replacement for HST52 and HST152.
 - ④ ⑥ After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

- FINISH:** HST252(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- ④ ⑥ HST252AC(-)(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 with color code green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ④ ⑥ HST252AG(-)(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ④ ⑥ HST252AP(-)(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ④ ⑥ HST252GD(-)(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 on threads only, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST252TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ④ HST252HK(-)(-) = 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 HST252 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
HST252AP8-8

