lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company
Design Holder
CAGE No. 73197

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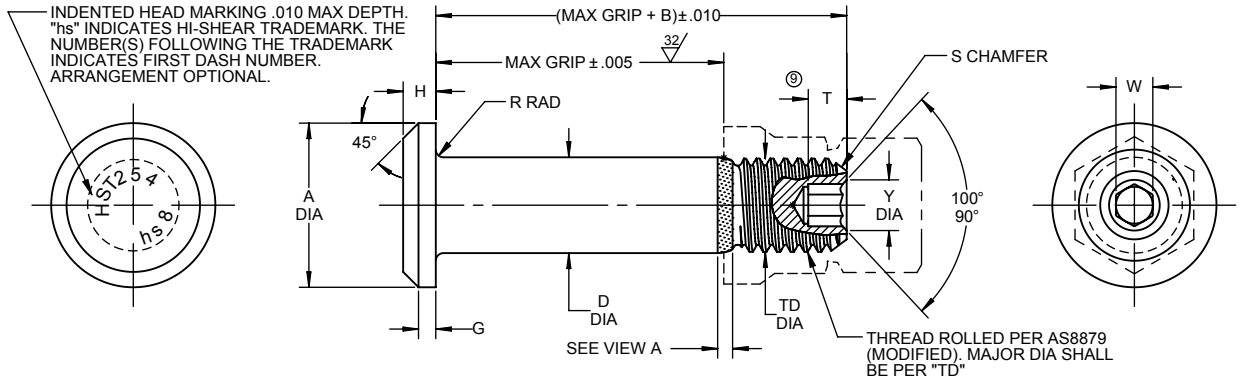
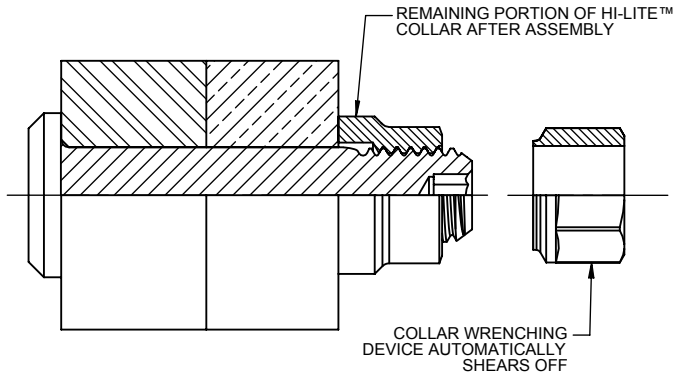


HI-LITE™ PIN

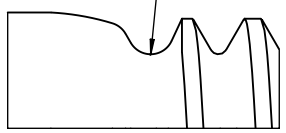


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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 WITHOUT COATING OR SOLID FILM	D DIA WITH COATING OR SOLID FILM	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				NOTE: USE HST54-6-( )												
6	7/32	.390 .370	.300	.2182 .2177	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,400	4,350
8	9/32	.460 .435	.330	.2807 .2802	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	15,500	7,750
10	11/32	.520 .490	.390	.3432 .3427	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	23,200	12,300
12	13/32	.620 .590	.430	.4057 .4052	.4057 .4047	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	32,400	19,100
14	15/32	.695 .660	.510	.4682 .4677	.4682 .4672	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	43,100	25,800
16	17/32	.790 .755	.610	.5307 .5302	.5307 .5297	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,400	34,300
18	19/32	.900 .865	.710	.5927 .5922	.5927 .5917	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	69,200	43,500

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	DATE	TITLE
J.F.OBISPO	1996-10-23	HI-LITE™ PIN PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED	DATE	
MC	1996-11-11	
REVISION	DATE	DRAWING NUMBER
⑨	F.CARINGELLA 2017-04-27	**HST254** 1 OF 2

HST254

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GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIM.
⑨ 2. Dimensions are in inches and to be met after finish.
⑨ 3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Oversize replacement for HST54 and HST154.
[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 (210,000 psi tensile minimum).

FINISH:
HST254-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.
[6] HST254AC( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 with color code green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
[6] HST254AG( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
[6] HST254AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
[6] HST254AZ( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST254CT( )-( ) = Color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST254CZ( )-( ) = Color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
[6] HST254GD( )-( ) = HI-KOTE™1 aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST254RP( )-( ) = Phosphate fluoride treat with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST254RS( )-( ) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color code orange thread end.
HST254RV( )-( ) = Phosphate fluoride treat, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST254TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST254NKJ( )-( ) = 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.
HST254NKL( )-( ) = 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.
⑨ HST254HK( )-( ) = 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 HST254 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER
⑨ **EXAMPLE:** Pin Part Number
HST254AP8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

HST254

DRAWING NUMBER
HST254