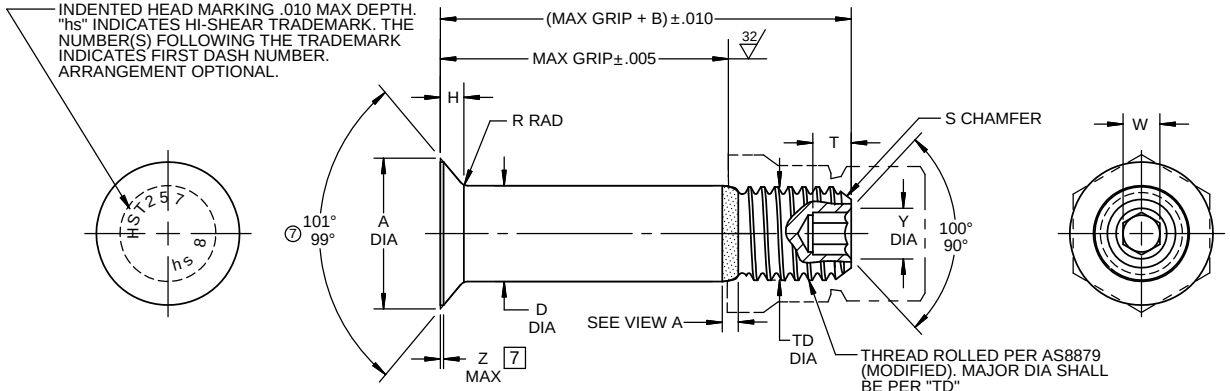
lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

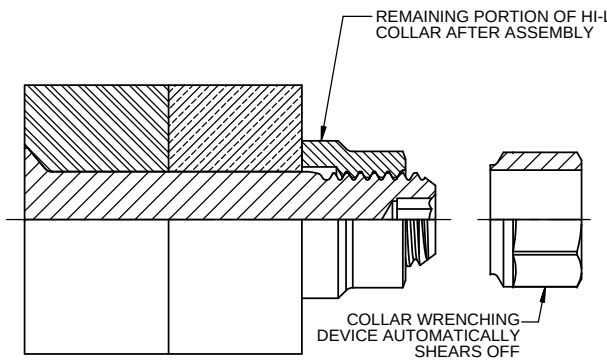
Design Holder

CAGE No. 73197

⑦ For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



HI-LITE™ PIN

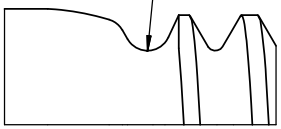


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

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	F [1]	H	R RAD	Z MAX [7]	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5				NOTE: USE HST157-6-( )													
6	7/32	.3303 .3253	.300	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,400	2,600
8	9/32	.4260 .4210	.330	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	15,500	4,400
10	11/32	.5051 .5001	.390	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	23,200	6,800
12	13/32	.5916 .5866	.430	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	32,400	9,500
14	15/32	.6992 .6932	.495	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0970 .0945	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	43,100	12,500
16	17/32	.7852 .7792	.535	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1070 .1045	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,400	TBD

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	1997-03-31	HI-LITE™ PIN 100° FLUSH SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED	DATE	
MC	1997-04-01	
REVISION	DATE	DRAWING NUMBER
⑦	M.BEARD 2017-04-19	**HST257** 1 OF 2

HST257

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GENERAL NOTES:
[1] Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
3. "H" is dimensioned from maximum "D" diameter.
⑦ 4. Dimensions are in inches and to be met after finish.
⑦ 5. Surface texture per ASME B46.1.
6. Hole preparation per NAS618.
[7] Curved or flat edge manufacturer's option.
[8] Broach petals removed.
9. Oversize replacement for HST57 and HST157.
[10] 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:
HST257-( )-( ) = Passivate per Hi-Shear 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
[10] HST257AC( )-( ) = 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.
[10] HST257AG( )-( ) = 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.
[10] HST257AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST257DU( )-( ) = Solid film lube per AS5272, Type I.
[8] HST257MA( )-( ) = Solid film lube per KALGARD RA.
HST257TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST257TP( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
[10] HST257GM( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 on threads (no overspray on the shank is allowed) and top of head only (.005 max overspray on the head bearing surface permissible) with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
⑦ HST257HK( )-( ) = 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 HST257 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER
⑦ **EXAMPLE:** Pin Part Number
HST257AP8-8
- 8/16 or 1/2 Maximum Grip Length
- Replaces 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

HST257

DRAWING NUMBER
HST257