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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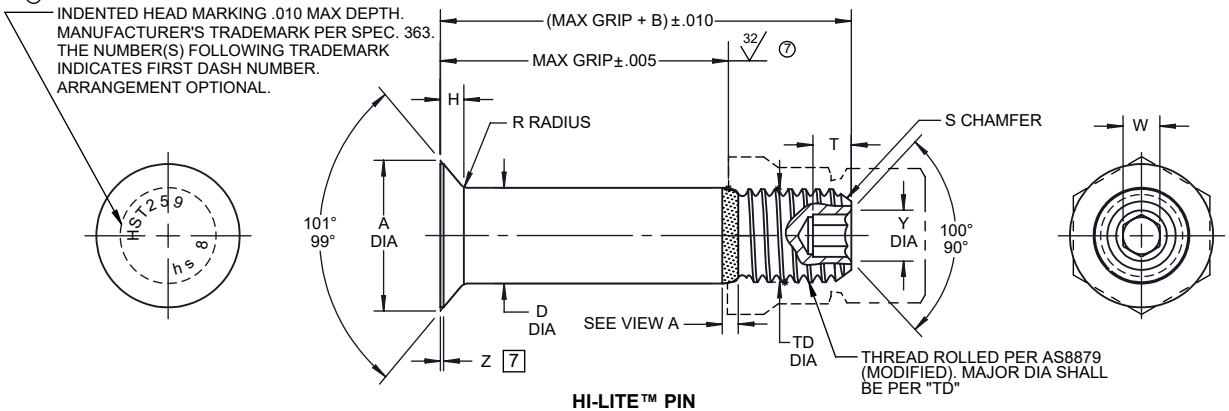
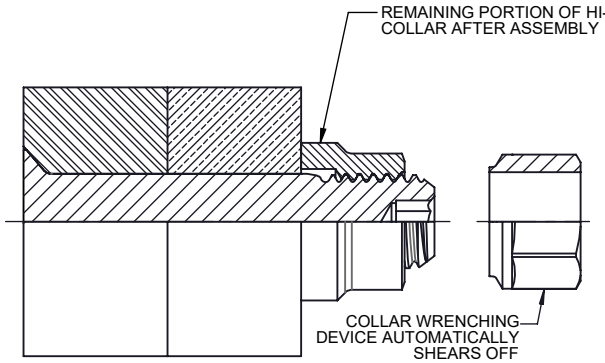


HI-LITE™ PIN

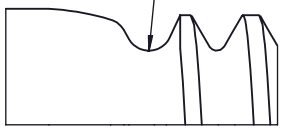


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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 [1]	F REF	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 HST159( )6-( )													
6	7/32	.3813 .3765	.300	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0684 .0664	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,400	4,350
8	9/32	.5066 .5018	.330	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0948 .0928	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	15,500	7,750
10	11/32	.6335 .6287	.390	.3432 .3427	.3432 .3422	.3060 .3020	.007	.1218 .1198	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	23,200	12,300
12	13/32	.7604 .7556	.430	.4057 .4052	.4057 .4047	.3680 .3640	.008	.1488 .1468	.040 .030	.015	3/64 x 45°	.3725-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	32,400	19,100
14	15/32	.8884 .8812	.510	.4682 .4677	.4682 .4672	.4310 .4260	.009	.1763 .1733	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	43,100	25,800
16	17/32	1.0139 1.0068	.610	.5307 .5302	.5307 .5297	.4930 .4880	.010	.2027 .1997	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,400	34,300

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 MS24694 TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED	DATE	
MC	1997-04-1	
REVISION	DATE	DRAWING NUMBER
⑦	A.CHAE 2022-10-07	HST259

HST259

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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.
4. Dimensions are in inches and to be met after finish.
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 HST59 and HST159.
⑦ [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 the UK and European Union.

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

⑦ **FINISH:**
HST259-( )-( ) = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
⑦ [10] HST259AC( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color code green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
⑦ [10] HST259AG( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
⑦ [10] HST259AP( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST259DU( )-( ) = Solid film lube per AS5272, Type I.
⑦ [10] HST259GD( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating on threads only per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
⑦ [10] HST259GM( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC 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.
[8] HST259MA( )-( ) = Solid film lube per Kalgard RA.
HST259TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST259TP( )-( ) = 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.
HST259HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397
⑦ HST259NAP( )-( ) = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST259 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:

Pin Part Number
HST259AP8-8
- 8/16 or 1/2 Maximum Grip Length
- Replaces 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

HST259

DRAWING NUMBER
HST259