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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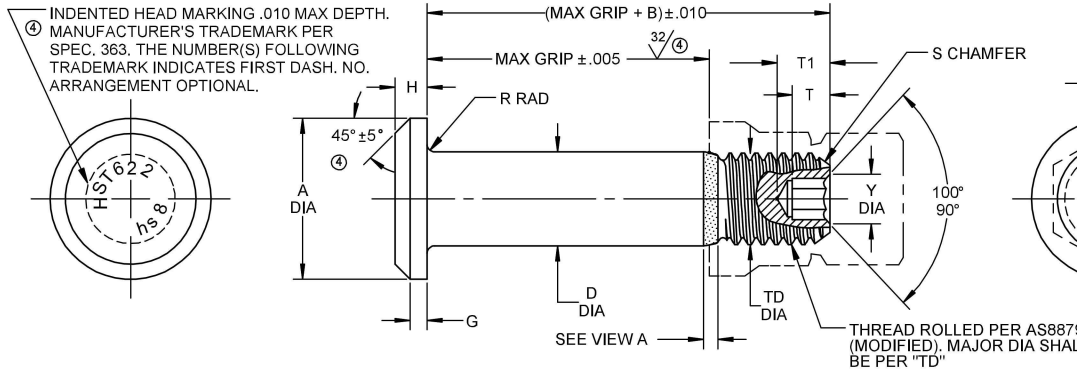
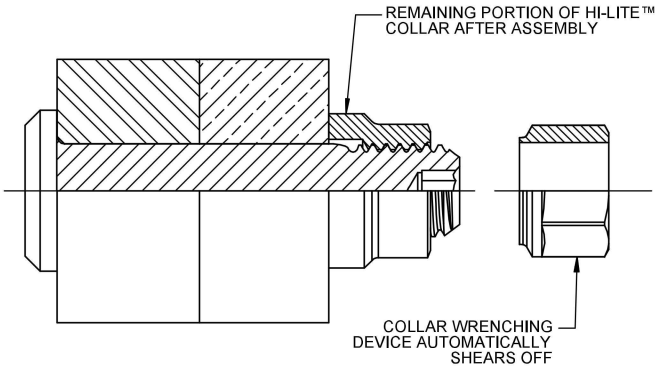


HI-LITE™ PIN



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

④

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 MIN	SOCKET T1 DEPTH MAX	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	5/32	.322 .306	.280	.1635 .1630	.1635 .1625	.1595 .1570	.030	.065 .055	.025 .015	1/32 x 37°	.1640-32 UNJC-3A	.0801 .0791	.080	.135	[5]	4,010	1,940
6	3/16	.377 .357	.290	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	.0806 .0791	.080	.135	.119 .104	5,380	2,590
8	1/4	.440 .415	.320	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	.0967 .0947	.090	.160	.142 .122	9,300	4,760
10	5/16	.505 .475	.380	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	.1295 .1270	.110	.200	.180 .160	14,600	7,100
12	3/8	.600 .565	.420	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	.1617 .1582	.140	.235	.217 .197	21,000	10,600

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

GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions are in inches and to be met after finish.
3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Evidence of broken edge across point.
6. Use HST632 for oversize replacement.

④ [7] 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 UK and European Union.

MATERIAL: 6AL-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

FINISH: HST622-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.

④ [7] HST622AP( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.

④ [7] HST622AG( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

④ [7] HST622GV( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, on threads only (no overspray allowed on the bolt shank) color code green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST622NKJ( )-( ) = 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.

HST622NKK( )-( ) = Sulfuric acid anodizing per ISO8080 and 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.

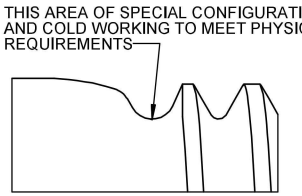
HST622NKL( )-( ) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 380, except tensile values per tabulation.

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 EXAMPLES:

Pin Part Number
HST622-8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Pin Basic Part Number



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	2009-09-03	HI-LITE™ PIN PROTRUDING TENSION HEAD TITANIUM (FOR USE IN COMPOSITE APPLICATION) 1/16 GRIP VARIATION
APPROVED	DATE	
-	2009-09-03	
REVISION	DATE	DRAWING NUMBER
④	K. PHAM 2022-03-17	HST622 1 OF 1

HST622