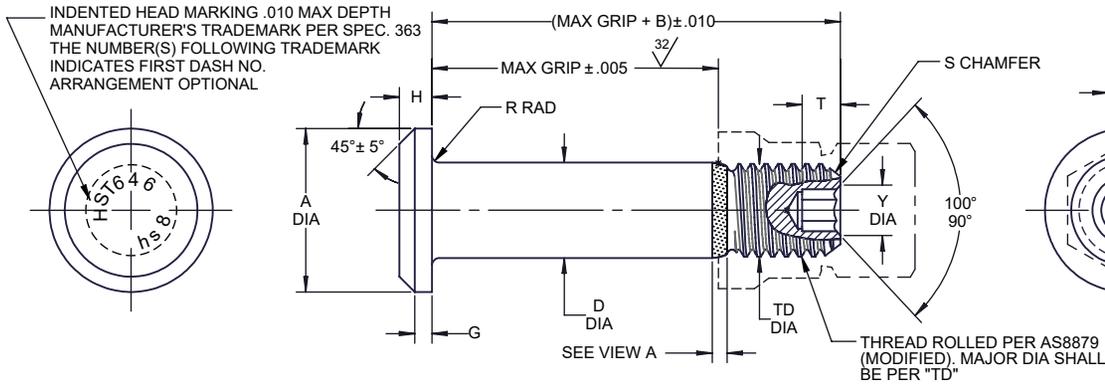


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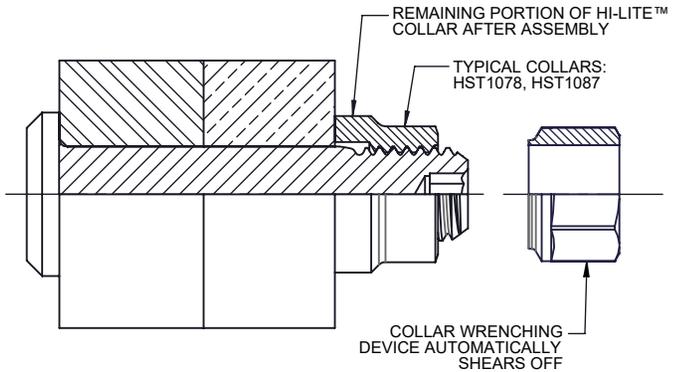


**HI-LITE™ PIN**

5

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 PLATING, OR SOLID FILM	WITH PLATING, OR SOLID FILM							W HEX	T DEPTH	Y DIA		
5	5/32	.322 .306	.280	.1635 .1630	.1635 .1625	.1595 .1570	.030	.065 .055	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	6	5,280	2,940
6	3/16	.377 .357	.290	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,060	4,350
8	1/4	.440 .415	.320	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	12,260	7,750
10	5/16	.505 .475	.380	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	19,160	12,300
12	3/8	.600 .565	.420	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	27,600	19,100
14	7/16	.676 .641	.485	.4370 .4365	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	37,500	25,800
16	1/2	.770 .735	.525	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	49,100	34,300

**HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY**



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

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS



**VIEW A**

HI-LITE™ THREAD TRANSITION AREA  
 SEE SPECIFICATION FOR INSPECTION

<b>"HI-LITE", "HST", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION</b>		
DRAWN BY D.P.S.	DATE 1983-03-18	TITLE <b>HI-LITE™ PIN PROTRUDING TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION</b>
APPROVED R.TING	DATE 1983-03-18	
REVISION 7	DATE C.Artos 2023-11-13	DRAWING NUMBER <b>HST646</b>

- ⑦ **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 Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
  - ⑥ Evidence of broken edge across points.

**MATERIAL:** PH13-8Mo stainless steel per AMS5629.

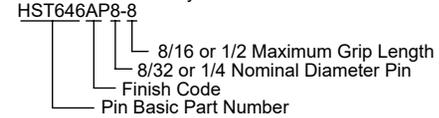
**HEAT TREAT:** 125,000 psi shear minimum.

- FINISH** ⑦ HST646-( )-( ) = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑦ HST646AP( )-( ) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST646DU( )-( ) = Solid film lube per AS5272, Type I.
- HST646TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST646TP( )-( ) = 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.
- HST646HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
- HST646NAP( )-( ) = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 (0.0002 to 0.0005) 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. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER EXAMPLE:** Pin Part Number Only



HST646

DRAWING NUMBER

**HST646**

2 OF 2