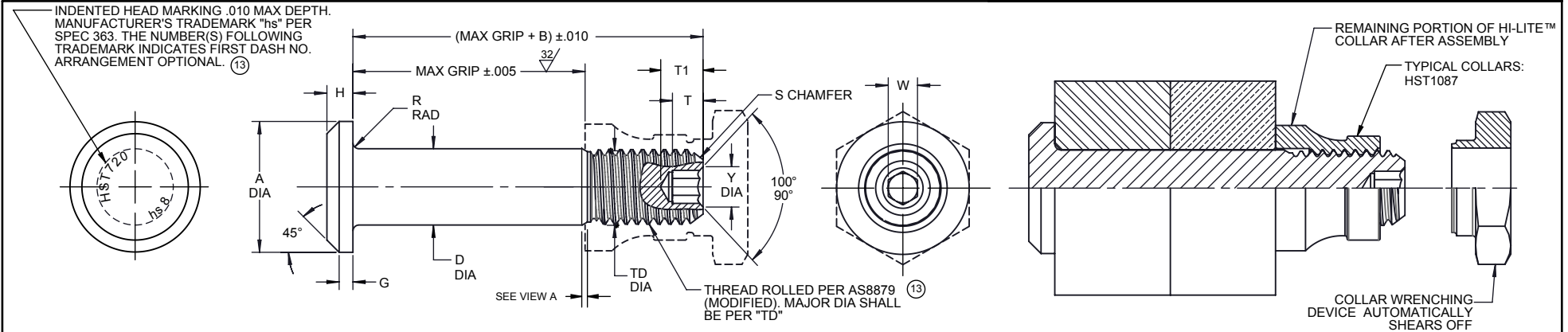




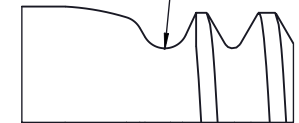
HI-LITE™ PIN

HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	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
											W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA		
5	5/32	.322 .306	.280	.1635 .1625	.1595 .1570	.030	.065 .055	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.080	.135	[5]	4,560	2,450
6	3/16	.377 .357	.290	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.080	.135	.119 .104	6,125	3,850
8	1/4	.440 .415	.320	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.090	.160	.142 .122	10,600	6,550
10	5/16	.505 .475	.380	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.110	.200	.180 .160	16,600	10,350
12	3/8	.600 .565	.420	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.140	.235	.217 .197	23,900	15,750
14	7/16	.676 .641	.485	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.170	.275	.253 .233	32,500	21,200
16	1/2	.770 .735	.525	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.200	.315	.289 .269	42,400	28,800
18	9/16	.877 .842	.600	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	53,700	36,400
20	5/8	.953 .918	.640	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	66,300	46,100
24	3/4	1.150 1.110	.895	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.300	.465	.398 .378	95,400	66,900
28	7/8	1.330 1.290	1.000	.8740 .8730	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.370	.608	.471 .451	129,000	93,000
32	1	1.510 1.470	1.160	.9990 .9980	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5050	.490	.770	.618 .598	168,500	120,500
36	1-1/8	1.695 1.655	1.305	1.1240 1.1230	1.1170 1.1100	.350	.490 .475	.070 .055	5/64 x 45°	1.1250-12 UNJF-3A	.5725 .5675	.550	.850	.693 .673	214,000	153,800

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

"HI-LITE", "HST", AND "HI-KOTE",
 ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY D.P.S.	DATE 1983-02-22	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION
APPROVED R. TING	DATE 1983-02-22	
REVISION 13	DATE K. TRAN 2017-11-30	DRAWING NUMBER HST720

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIR.
2. Dimensions 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 points.
6. Use HST764 for oversize replacement.

MATERIAL: 13 Alloy steel per AMS6415, AMS6349 or AMS6322, AMS6325, AMS6327.

HEAT TREAT: 13 180,000-200,000 psi tensile per Spec. AMS-H-6875.

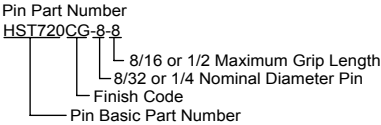
- FINISH: 13 HST720-()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 with color code black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
- 13 HST720BJ-()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 13 HST720BL-()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, with color black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
- 13 HST720CG-()-() = Cadmium plate per AMS-QQ-P-416, Type II, Class 2 with color code green on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 380.

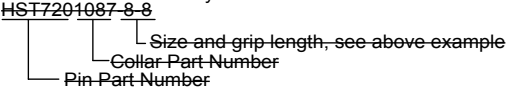
CODE: First dash number indicates nominal diameter in 1/32nds
Second dash number indicates maximum grip in 1/16ths.
See finish note for explanation of code letters.

HOW TO ORDER

13EXAMPLE:



Pin and Collar Assembly Part Number Combination



HST720