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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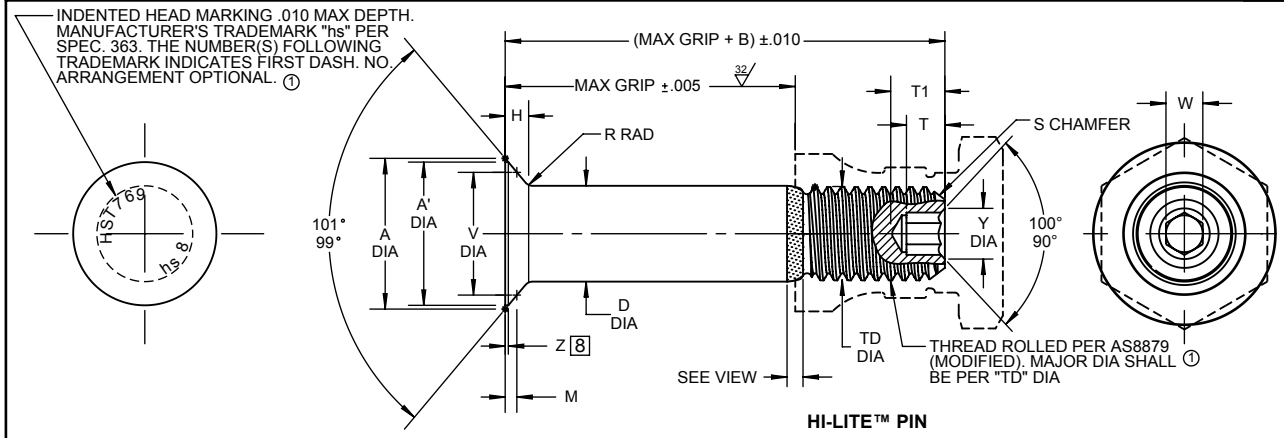
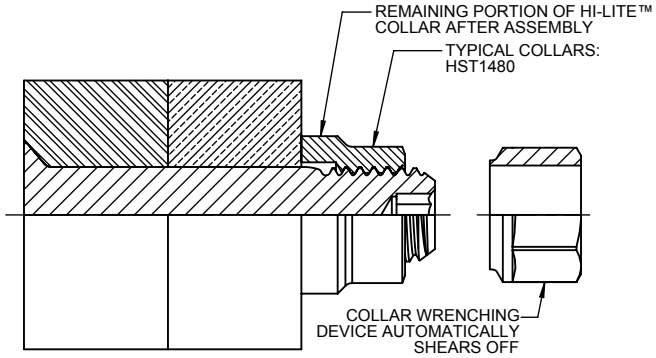
*HTTP://WWW.LISI-AEROSPACE.COM/LICENSES*

①




**HI-LITE™ PIN**

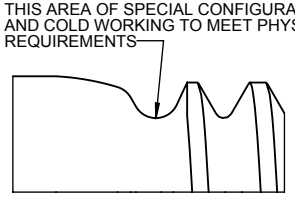



**HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY**

[1] [8] ① [7]

| FIRST DASH NO. | PIN NOM DIA | A DIA MAX | A' DIA MIN | B REF | D DIA | TD DIA | F | H REF | M GAGE PROT. | R RAD Cold-Worked | V GAGE DIA | Z MAX | 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 | TENSION-TENSION FATIGUE POUNDS MAXIMUM |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5 | | | | | NOTE: Use HST765-6 | | | | | | | | | | | | | | | | |
| 6 | 7/32 | .3277 | .2963 | .300 | .2182<br>.2172 | .1840<br>.1810 | .005 | .044 | .0295<br>.0263 | .030<br>.020 | .2560<br>.2558 | .015 | 1/32 x 45° | .1900-32<br>UNJF-3A | .0806<br>.0791 | .080 | .135 | .119<br>.104 | 9,400 | 3,000 | 1,050 |
| 8 | 9/32 | .4283 | .3969 | .330 | .2807<br>.2797 | .2440<br>.2410 | .006 | .060 | .0227<br>.0195 | .030<br>.020 | .3732<br>.3730 | .015 | 1/32 x 45° | .2500-28<br>UNJF-3A | .0967<br>.0947 | .090 | .160 | .142<br>.122 | 15,500 | 5,780 | 2,020 |
| 10 | 11/32 | .5361 | .5047 | .390 | .3432<br>.3422 | .3060<br>.3020 | .007 | .079 | .0234<br>.0198 | .040<br>.030 | .4791<br>.4789 | .015 | 3/64 x 45° | .3125-24<br>UNJF-3A | .1295<br>.1270 | .110 | .200 | .180<br>.160 | 23,200 | 8,680 | 3,030 |
| 12 | 13/32 | .6415 | .6101 | .430 | .4057<br>.4047 | .3680<br>.3640 | .008 | .097 | .0295<br>.0259 | .040<br>.030 | .5698<br>.5696 | .015 | 3/64 x 45° | .3750-24<br>UNJF-3A | .1617<br>.1582 | .140 | .235 | .217<br>.197 | 32,400 | 12,700 | 4,440 |
| 14 | 15/32 | .7425 | .6941 | .495 | .4682<br>.4672 | .4310<br>.4260 | .009 | .114 | .0347<br>.0307 | .050<br>.040 | .6582<br>.6580 | .022 | 3/64 x 45° | .4375-20<br>UNJF-3A | .1930<br>.1895 | .170 | .275 | .253<br>.233 | 43,100 | 16,550 | 5,790 |
| 16 | 17/32 | .8423 | .7939 | .535 | .5307<br>.5297 | .4930<br>.4880 | .010 | .128 | .0504<br>.0464 | .050<br>.040 | .7200<br>.7198 | .022 | 3/64 x 45° | .5000-20<br>UNJF-3A | .2242<br>.2207 | .200 | .315 | .289<br>.269 | 55,400 | 22,900 | 8,010 |
| 18 | 19/32 | .9300 | .8816 | .610 | .5927<br>.5917 | .5550<br>.5500 | .010 | .140 | .0533<br>.0485 | .050<br>.040 | .8012<br>.8010 | .022 | 1/16 x 45° | .5625-18<br>UNJF-3A | .2555<br>.2520 | .240 | .365 | .326<br>.306 | 69,200 | 28,400 | 9,940 |
| 20 | 21/32 | 1.0440 | .9956 | .650 | .6552<br>.6542 | .6180<br>.6120 | .010 | .161 | .0633<br>.0589 | .050<br>.040 | .8902<br>.8900 | .022 | 1/16 x 45° | .6250-18<br>UNJF-3A | .2555<br>.2520 | .240 | .365 | .326<br>.306 | 84,500 | 35,800 | 12,530 |
| 24 | 25/32 | 1.3000 | 1.2516 | .905 | .7802<br>.7792 | .7430<br>.7370 | .012 | .215 | .0776<br>.0716 | .050<br>.040 | 1.1124<br>1.1122 | .022 | 1/16 x 45° | .7500-16<br>UNJF-3A | .3185<br>.3150 | .300 | .440 | .398<br>.378 | 120,000 | 55,500 | 19,400 |
| 28 | 29/32 | 1.5091 | 1.4606 | 1,010 | .9052<br>.9042 | .8680<br>.8610 | .014 | .240 | .0694<br>.0622 | .050<br>.040 | 1.3440<br>1.3438 | .022 | 5/64 x 45° | .8750-14<br>UNJF-3A | .3820<br>.3780 | .370 | .608 | .471<br>.451 | 161,000 | 75,000 | 26,500 |
| 32 | 1-1/32 | 1.7201 | 1.6716 | 1,170 | 1.0302<br>1.0292 | .9930<br>.9860 | .014 | .285 | .0617<br>.0536 | .050<br>.040 | 1.5732<br>1.5730 | .022 | 5/64 x 45° | 1.0000-12<br>UNJF-3A | .5100<br>.5040 | .490 | .770 | .618<br>.598 | 209,000 | 98,000 | 34,300 |

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




**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 |
|---|---|
| J.H.R. | 1998-09-09 |
| APPROVED | DATE |
| MC | 1998-09-24 |
| REVISION | DATE |
| ① | K. TRAN 2017-11-30 |

TITLE
HI-LITE™ PIN
100° FLUSH SPECIAL SHEAR HEAD
NICKEL BASE ALLOY (INCONEL 718)
1/16 GRIP VARIATION ,1/32 OVERSIZE

DRAWING NUMBER
**HST769**





HST769

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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 FIR.
3. "H" is dimensioned from maximum "D" diameter.
① 4. Dimensions are in inches and to be met after finish.
① 5. Surface texture per ASME B46.1.
6. Hole preparation per NAS618.
[7] Fatigue test pins having grip equal two diameters or longer using these loads at R =0.1.
[8] Curved or flat edge manufacturer's option.
9. Oversize replacement for HST765 and HST767.
[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 (210,000 psi tensile minimum).

**FINISH:** ① [10] HST769AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

**SPECIFICATION:** HI-LITE™ Product Specification 380, except as noted [7].

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HST769 pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

**HOW TO ORDER**
**① EXAMPLE:**

Pin Part Number
HST769AP-8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

HST769

DRAWING NUMBER
**HST769**