

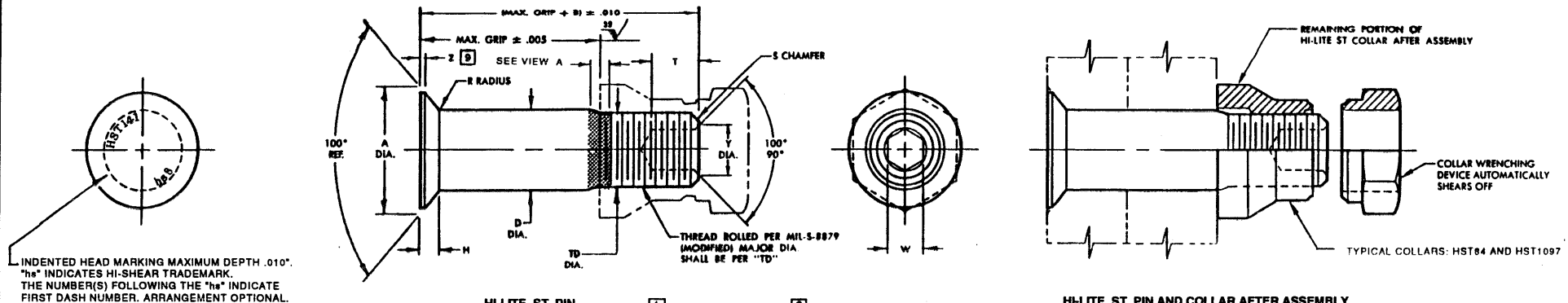
hi-shear
CORPORATION

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"CAGE" = Commercial And Government Entity

HI-SHEAR CORPORATION, U.S.A.(Patent Holder).....CAGE No. 73197
A Subsidiary of GFI Industries, France
AIR INDUSTRIES CO., INC. (Licensee-U.S.A. & Canada).....CAGE No. 06725
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A Subsidiary of GFI Industries, France

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TOKYO SCREW COMPANY, Japan.....(Licensee-Japan)



HI-LITE ST PIN

1

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HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			** DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM LUBE	AFTER COATING OR SOLID FILM LUBE								W HEX.	T DEPTH	Y DIA.		
5	3/16					NOTE: USE HST41-6-()											
6	13/64	.3016 .2966	.300	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0415 .0394	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	2,000
8	17/64	.3948 .3898	.330	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0544 .0523	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	3,700
10	21/64	.4739 .4689	.390	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0614 .0593	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	5,000
12	25/64	.5604 .5554	.430	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0714 .0693	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	7,200
14	29/64	.6680 .6620	.495	.4526 .4521	.4526 .4516	.4310 .4260	.009	.0904 .0879	.050 .040	.022	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	10,000
16	33/64	.7540 .7480	.535	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1002 .0977	.050 .040	.022	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	39,600	13,500

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.

GENERAL NOTES:

- Head edge out of roundness shall not exceed "F".
- Concentricity: Conical surface of head to "D" diameter within .005 FIM.
- "H" is dimensioned from maximum "D" diameter.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Oversize replacement for HST41 and HST141 pins.
- Non-lubed pins must be used with lubed collars.
- Curved or flat edge manufacturer's option.

MATERIAL: A-286 high temperature alloy per Spec. AMS5737 or AMS5731.

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HST141-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HST141DU()-() = Solid film lube per AS5272, Type I.
HST141GU()-() = Silver plate per AMS2410.
HST141PY()-() = Passivate per Hi-Shear Spec. 258.
HST141TF()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
HST141V()-() = Solid film lube per "Lubeco" 2123, Type II.
HST141YV()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 on threads only with color code orange 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 of the pin which HST141 oversize pin replaces.
Second dash number Indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER
EXAMPLES:

Pin Part Number Only
HST141-8-8
8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HST14184-8-8

Size and Grip Length,
See Above Example
Collar Part Number
Pin Part Number

** The Double Shear Values shown are based on cross section area for nominal pin diameter.

U.S. Patents 4,326,825; 4,485,510 and 4,957,401. Other U.S. and international patents pending. "Hi-Lite" and "HST" are registered trademarks, and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.	
DRAWN DATE J.Henderson 1-21-98	TITLE HI-LITE[®]ST[™] PIN 100° FLUSH SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION, 1/64" OVERSIZE
APPROVED DATE MC 2-2-98	DRAWING NUMBER HST141
REVISION DATE	

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STD/HSTPIN

HST141