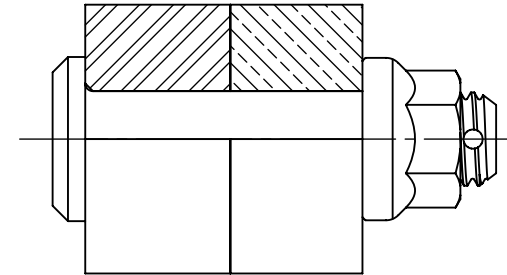
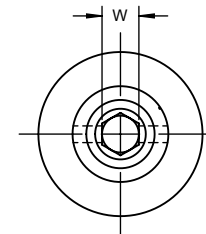


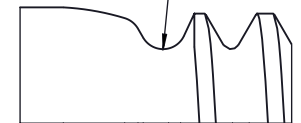
HI-LITE™ PIN



HI-LITE™ PIN AND NUT AFTER ASSEMBLY

SEE COLLAR/NUT STANDARDS  
 FOR COLLAR/NUT STRENGTHS.  
 LOWER STRENGTH (PIN OR  
 COLLAR/NUT) 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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	M DIA	P	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM	WITH COATING OR SOLID FILM									W HEX	T DEPTH	Y DIA		
16	1/2	.770 .735	.685	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.086 .082	.130 .110	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	49,100	20,000

- 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 After February, 21st of 2015. HI-KOTE™ 1 pigmented coating 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:** HST144-( )-( ) = Cetyl alcohol lube per Hi-Shear Spec. 305.

⑤ HST144AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST144TB( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST144YW( )-( ) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 on threads only, with color code white on thread end, and cetyl alcohol lube per Hi-Shear Spec.305.

HST144HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

**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  
 HST144AP8-8

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

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

DRAWN BY J.F.OBISPO	DATE 2009-10-13	TITLE <b>HI-LITE™ PIN</b> PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION
APPROVED J. HAYES	DATE 2009-10-13	
REVISION ②	DATE F.CARINGELLA 2019-01-10	DRAWING NUMBER <b>HST144</b>