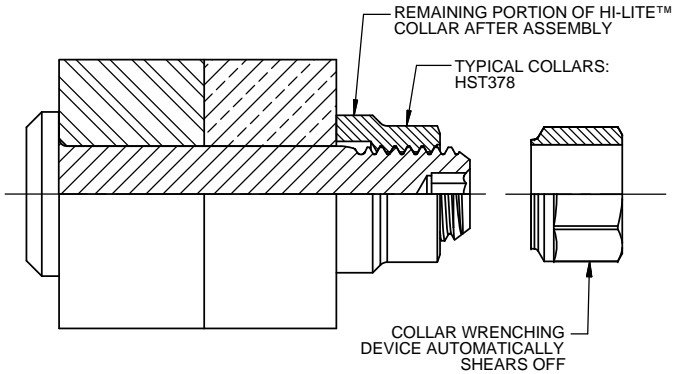


HI-LITE™ PIN



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

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
											W HEX	T DEPTH	Y DIA		
5				NOTE: USE HST120-6(-)											
6	7/32	.390 .370	.300	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,100	3,180
8	9/32	.460 .435	.330	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	11,800	5,820
10	11/32	.520 .490	.390	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	17,600	9,200
12	13/32	.620 .590	.430	.4057 .4047	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	24,600	14,000
14	15/32	.695 .660	.510	.4682 .4672	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	32,700	18,900
16	17/32	.790 .755	.610	.5307 .5297	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	42,000	25,600

- GENERAL NOTES:**
- 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.
 - Hole preparation per NAS618.
 - ⑤ Non-lubed pins must be used with wet sealant or with lubed collar.
 - Oversize replacement pin for HST20 and HST120.

MATERIAL: Alloy steel per AMS6415, AMS6349, or AMS-S-6049.

HEAT TREAT: 160,000 - 180,000 psi tensile per AMS-H-6875.

FINISH: HST220(-)(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST220CG(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST220PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

- ⑤ HST220PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
HST220TF(-)(-) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.

SPECIFICATION: HI-LITE™ Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds.
of the pin which HST220 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

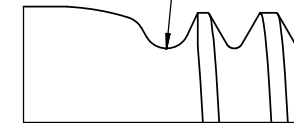
HOW TO ORDER

① **EXAMPLE:**

Pin Part Number
HST220PB8-8

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

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 J.F.OBISPO	DATE 2012-07-23	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED C.WRIGHT	DATE 2012-07-23	DRAWING NUMBER HST220	
REVISION ①	DATE M.BEARD 2017-04-25	1 OF 1	