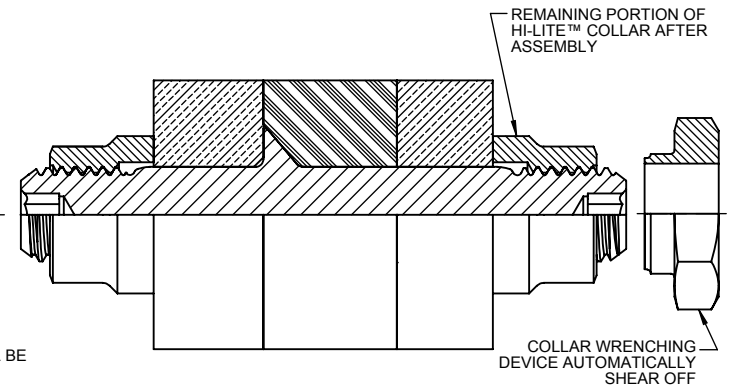


HI-LITE™ THREADED STUD PIN



HI-LITE™ THREADED PIN AND COLLAR AFTER ASSEMBLY

| FIRST DASH NO. | PIN NOM DIA | A DIA | B REF | C DIA | | D DIA | | TD DIA | F | H | R RAD | Z MAX | S CHAMFER REF | THREAD MODIFIED | SOCKET | | | DOUBLE SHEAR POUNDS MINIMUM | TENSION POUNDS MINIMUM |
|----------------|-------------|----------------|-------|-------------------------------|----------------|-------------------------------|----------------|----------------|------|----------------|--------------|-------|---------------|---------------------|----------------|--------------|--------------|-----------------------------|------------------------|
| | | | | WITHOUT COATING OR SOLID FILM | WITH COATING | WITHOUT COATING OR SOLID FILM | WITH COATING | | | | | | | | W HEX | T DEPTH | Y DIA | | |
| 6 | 3/16 | .3536 .3486 | .290 | .1895 .1890 | .1895 .1885 | .2026 .2021 | .2026 .2016 | .1840 .1810 | .005 | .0633 .0612 | .030 .020 | .015 | 1/32 x 45° | .1900-32 UNJF-3A | .0806 .0791 | .100 .080 | .119 .104 | 6,130 | 2,590 |
| 8 | 1/4 | .4732 .4682 | .320 | .2495 .2490 | .2495 .2485 | .2651 .2646 | .2651 .2641 | .2440 .2410 | .006 | .0873 .0852 | .030 .020 | .015 | 1/32 x 45° | .2500-28 UNJF-3A | .0967 .0947 | .110 .090 | .142 .122 | 10,490 | 4,760 |
| 10 | 5/16 | .5619 .5569 | .380 | .3120 .3115 | .3120 .3110 | .3276 .3271 | .3276 .3266 | .3060 .3020 | .007 | .0983 .0962 | .040 .030 | .015 | 3/64 x 45° | .3125-24 UNJF-3A | .1295 .1270 | .130 .110 | .180 .160 | 16,000 | 7,100 |
| 12 | 3/8 | .6912 .6862 | .420 | .3745 .3740 | .3745 .3735 | .3901 .3896 | .3901 .3891 | .3680 .3640 | .008 | .1263 .1243 | .040 .030 | .015 | 3/64 x 45° | .3750-24 UNJF-3A | .1617 .1582 | .160 .140 | .217 .197 | 22,700 | 10,600 |

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. Threaded stud side to pin side within .010 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions are in inches and to be met after finish and before application of lubricant.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Maximum "D" diameter may be increased by .0002 to allow for aluminum coating application.
 - "D" diameter may increase by .0005 inch after application of solid film lube.
 - 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.

SPECIFICATION: HI-LITE™ Product Specification 380.

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

HOW TO ORDER

EXAMPLE: Stud Pin Part Number
HST245AG8-8-8

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

MATERIAL: 6Al-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

- FINISH:**
- HST245-(-)(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST245AG(-)(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, color orange on both ends, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST245AP(-)(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST245DL(-)(-)(-) = KALGARD FA or EM620C solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.

| "HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION | | |
|--|------------------------------------|---|
| DRAWN BY D.P.S. | DATE 1989-07-20 | TITLE HI-LITE™ THREADED STUD PIN 100° FLUSH MS20426 SHEAR HEAD TITANIUM 1/16 GRIP VARIATION - 1/64 OVERSIZE |
| APPROVED D.A.W. | DATE 1989-07-20 | |
| REVISION 3 | DATE F.CARINGELLA 2019-01-08 | DRAWING NUMBER HST245 |