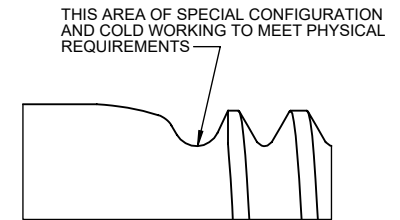


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

[5]

| 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 |
|----------------|-------------|----------------|-------|-------------------------------|-----------------------------|----------------|-------|--------------|--------------|---------------|---------------------|----------------|--------------|--------------|-----------------------------|------------------------|
| | | | | WITHOUT COATING OR SOLID FILM | AFTER COATING OR SOLID FILM | | | | | | | W HEX | T DEPTH | Y DIA | | |
| 5 | 5/32 | .262 .242 | .280 | .1635 .1630 | .1635 .1625 | .1595 .1570 | .020 | .047 .037 | .025 .015 | 1/32 x 45° | .1640-32 UNJC-3A | .0801 .0791 | .100 .080 | [6] | 5,280 | 2,200 |
| 6 | 3/16 | .315 .295 | .290 | .1895 .1890 | .1895 .1885 | .1840 .1810 | .025 | .055 .045 | .025 .015 | 1/32 x 45° | .1900-32 UNJF-3A | .0806 .0791 | .100 .080 | .119 .104 | 7,060 | 3,000 |
| 8 | 1/4 | .412 .387 | .320 | .2495 .2490 | .2495 .2485 | .2440 .2410 | .030 | .069 .059 | .025 .015 | 1/32 x 45° | .2500-28 UNJF-3A | .0967 .0947 | .110 .090 | .142 .122 | 12,260 | 5,100 |
| 10 | 5/16 | .505 .475 | .380 | .3120 .3115 | .3120 .3110 | .3060 .3020 | .035 | .078 .068 | .030 .020 | 3/64 x 45° | .3125-24 UNJF-3A | .1295 .1270 | .130 .110 | .180 .160 | 19,160 | 8,000 |
| 12 | 3/8 | .600 .565 | .420 | .3745 .3740 | .3745 .3735 | .3680 .3640 | .040 | .088 .078 | .030 .020 | 3/64 x 45° | .3750-24 UNJF-3A | .1617 .1582 | .160 .140 | .217 .197 | 27,600 | 11,300 |
| 14 | 7/16 | .676 .641 | .485 | .4370 .4365 | .4370 .4360 | .4310 .4260 | .045 | .105 .093 | .030 .020 | 3/64 x 45° | .4375-20 UNJF-3A | .1930 .1895 | .190 .170 | .253 .233 | 37,500 | 15,500 |
| 16 | 1/2 | .770 .735 | .525 | .4995 .4990 | .4995 .4985 | .4930 .4880 | .050 | .115 .103 | .030 .020 | 3/64 x 45° | .5000-20 UNJF-3A | .2242 .2207 | .220 .200 | .289 .269 | 49,100 | 20,000 |
| 18 | 9/16 | .864 .829 | .600 | .5615 .5610 | .5615 .5605 | .5550 .5500 | .055 | .127 .112 | .040 .025 | 1/16 x 45° | .5625-18 UNJF-3A | .2555 .2520 | .260 .240 | .326 .306 | 62,100 | 25,000 |
| 20 | 5/8 | .953 .918 | .660 | .6240 .6235 | .6240 .6230 | .6180 .6120 | .060 | .137 .122 | .040 .025 | 1/16 x 45° | .6250-18 UNJF-3A | .2555 .2520 | .260 .240 | .326 .306 | 76,700 | 30,200 |
| 24 | 3/4 | 1.108 1.066 | .895 | .7490 .7485 | .7490 .7480 | .7430 .7370 | .070 | .151 .136 | .045 .030 | 1/16 x 45° | .7500-16 UNJF-3A | .3185 .3150 | .330 .300 | .398 .378 | 110,400 | 40,200 |
| 28 | 7/8 | 1.285 1.241 | 1.000 | .8740 .8735 | .8740 .8730 | .8680 .8610 | .090 | .187 .172 | .050 .035 | 5/64 x 45° | .8750-14 UNJF-3A | .3820 .3780 | .400 .370 | .471 .451 | 150,300 | 59,100 |

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 J.F.OBISPO D.P.S. | DATE 2014-12-23 1983-03-18 | TITLE HI-LITE™ PIN PROTRUDING SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION |
| | | |
| APPROVED R.TING | DATE 1983-03-18 | DRAWING NUMBER HST644 |
| | | |
| REVISION (12) | DATE B.CHAN 2021-11-02 | |

- GENERAL NOTES:**
1. Concentricity: "A" diameter 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. Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
 6. Evidence of broken edge across points.
 7. Use HST744 for oversize replacement.
 8. After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in UK & European Union. ⑫

MATERIAL: PH13-8Mo stainless steel per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

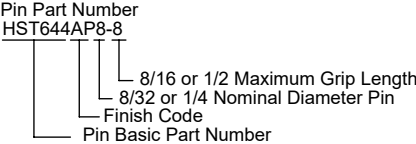
- FINISH:**
- HST644-()-() = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 8 HST644AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST644DU()-() = Solid film lube per AS5272, Type I.
 - HST644TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST644TP()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST644HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
 - ⑫ HST644NAP()-() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 (0.0002 to 0.0005 Thickness) 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.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER

EXAMPLE:



HST644

DRAWING NUMBER

HST644

2 OF 2