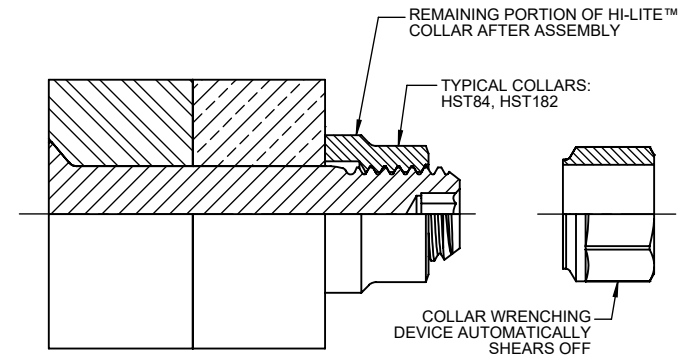


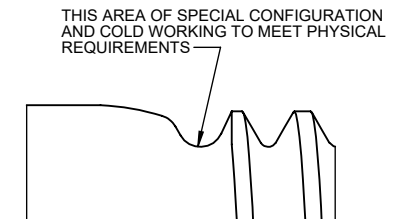
HI-LITE™ PIN



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

71																	
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	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	AFTER COATING OR SOLID FILM								W HEX	T DEPTH	Y DIA		
5	3/16					NOTE: USE HST645( )6-( )											
6	13/64	.3016 .2966	.300	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0415 .0394	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,100	2,600
8	17/64	.3948 .3898	.330	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0544 .0523	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,800	4,400
10	21/64	.4739 .4689	.390	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0614 .0593	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	21,100	7,000
12	25/64	.5604 .5554	.430	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0714 .0693	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	30,000	10,000
14	29/64	.6680 .6620	.495	.4526 .4521	.4526 .4516	.4310 .4260	.009	.0904 .0879	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	40,300	13,500
16	33/64	.7540 .7480	.535	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1002 .0977	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	52,500	18,000
18	37/64	.8380 .8310	.610	.5771 .5766	.5771 .5761	.5550 .5500	.010	.1094 .1065	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	65,600	22,500
20	41/64	.9250 .9180	.670	.6396 .6391	.6396 .6386	.6180 .6120	.010	.1197 .1168	.050 .040	.022	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	80,600	27,000
24	49/64	1.0970 1.0850	.905	.7646 .7641	.7646 .7636	.7430 .7370	.012	.1394 .1344	.050 .040	.022	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	115,000	37,300

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. Obispo	DATE 1988-01-20	TITLE HI-LITE™ PIN 100° FLUSH SHEAR HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED E. E. Beeles	DATE 1988-01-25	
REVISION [8]	DATE A. CHAE 2021-12-14	DRAWING NUMBER <b>HST745</b>

- GENERAL NOTES:**
- [1] Head edge out of roundness shall not exceed "F".
  - 2. Concentricity: Conical surface of head to "D" diameter within .003 FIM.
  - 3. "H" is dimensioned from maximum "D" diameter.
  - 4. Dimensions are in inches and to be met after finish.
  - 5. Surface texture per ASME B46.1.
  - 6. Hole preparation per NAS618.
  - [7] Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
  - [8] Curved or flat edge manufacturer's option.
  - 9. Use HST845 for oversize replacement.
  - ⑧ [10] 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 the UK and European Union.

**MATERIAL:** PH13-8Mo stainless steel per AMS5629.

**HEAT TREAT:** 125,000 psi shear minimum.

- FINISH:**
- HST745-( )-( ) = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.
  - [10] HST745AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST745TB( )-( ) = HI-KOTE™ 2 solid film lube per per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST745DU( )-( ) = Solid film lube per AS5272, Type I.
  - HST745TP( )-( ) = 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.
  - HST745HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
  - ⑧ HST745NAP( )-( ) = 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 of the pin which HST745 oversize pin replaces.  
 Second dash number indicates maximum grip in 1/16ths.  
 See Finish note for explanation of code letters.

**HOW TO ORDER**

**EXAMPLE:**

Pin Part Number  
 HST745AP8-8

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

**HST745**

DRAWING NUMBER

**HST745**

2 OF 2