

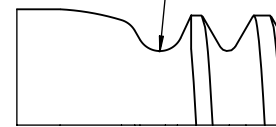
HI-LITE™ PIN

HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

1							8							①							7		
FIRST DASH NO.	PIN NOM DIA	A DIA MAX	A' DIA MIN	B REF	D DIA	TD DIA	F	H REF	M GAGE PROT.	R RAD Cold- Worked	V GAGE DIA	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION TENSION FATIGUE POUNDS MAXIMUM		
															W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA					
5	3/16				NOTE: Use HST765-6																		
6	13/64	.3277	.2963	.300	.2026 .2016	.1840 .1810	.005	.052	.0295 .0263	.030 .020	.2560 .2558	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.080	.135	.119 .104	8,100	3,000	1,050		
8	17/64	.4283	.3969	.330	.2651 .2641	.2440 .2410	.006	.068	.0227 .0195	.030 .020	.3732 .3730	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.090	.160	.142 .122	13,800	5,780	2,020		
10	21/64	.5361	.5047	.390	.3276 .3266	.3060 .3020	.007	.087	.0234 .0198	.040 .030	.4791 .4789	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.110	.200	.180 .160	21,100	8,680	3,030		
12	25/64	.6415	.6101	.430	.3901 .3891	.3680 .3640	.008	.105	.0295 .0259	.040 .030	.5698 .5696	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.140	.235	.217 .197	30,000	12,700	4,440		
14	29/64	.7425	.6941	.495	.4526 .4516	.4310 .4260	.009	.121	.0347 .0307	.050 .040	.6582 .6580	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.170	.275	.253 .233	40,300	16,550	5,790		
16	33/64	.8423	.7939	.535	.5151 .5141	.4930 .4880	.010	.137	.0504 .0464	.050 .040	.7200 .7198	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.200	.315	.289 .269	52,500	22,900	8,010		
18	37/64	.9300	.8816	.610	.5771 .5761	.5550 .5500	.010	.147	.0533 .0485	.050 .040	.8012 .8010	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	65,600	28,400	9,940		
20	41/64	1.0440	.9956	.650	.6396 .6386	.6180 .6120	.010	.168	.0633 .0589	.050 .040	.8902 .8900	.022	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	80,600	35,800	12,530		
24	49/64	1.3000	1.2516	.905	.7646 .7636	.7430 .7370	.012	.122	.0776 .0716	.050 .040	1.1124 1.1122	.022	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.300	.440	.398 .378	115,000	55,500	19,400		
28	57/64	1.5091	1.4606	1.010	.8896 .8886	.8680 .8610	.014	.257	.0694 .0622	.050 .040	1.3440 1.3438	.022	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.370	.608	.471 .451	156,000	75,000	26,500		
32	1-1/64	1.7201	1.6716	1.170	1.0146 1.0136	.9930 .9860	.014	.292	.0617 .0536	.050 .040	1.5732 1.5730	.022	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.490	.770	.618 .598	202,000	98,000	34,300		

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

<b>"HI-LITE", "HST", AND "HI-KOTE",          ARE TRADEMARKS OF HI-SHEAR CORPORATION</b>	
DRAWN BY J.H.R.	DATE 1998-09-09
APPROVED MC	DATE 1998-09-24
REVISION ①	DATE 2017-11-30
TITLE <b>HI-LITE™ PIN</b> 100° FLUSH SPECIAL SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/64 OVERSIZE	
DRAWING NUMBER <b>HST767</b>	

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
  2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
  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 Fatigue test pins having grip equal two diameters or longer using these loads at R =0.1.
  - 8 Curved or flat edge manufacturer's option.
  9. Use HST769 for oversize replacement.
  - 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 European Union.

**MATERIAL:** Nickel Base alloy per AMS5662.

**HEAT TREAT:** 125,000 psi shear minimum (210,000 psi tensile minimum).

**FINISH:** 10 HST767AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec.294, and cetyl alcohol lube per Hi-Shear Spec. 305.

**SPECIFICATION:** HI-LITE™ Product Specification 380, except as noted 7.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HST767 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  
 HST767AP-8-8  
 └─ 8/16 or 1/2 Maximum Grip Length  
 └─ 8/32 or 1/4 Nominal Diameter Pin  
 └─ Finish Code  
 └─ Pin Basic Part Number

DRAWING NUMBER

**HST767**

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