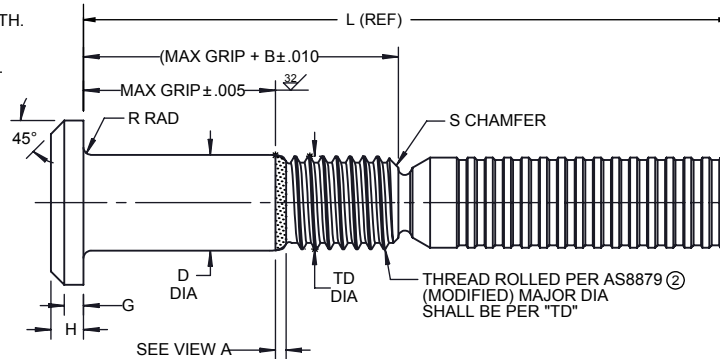
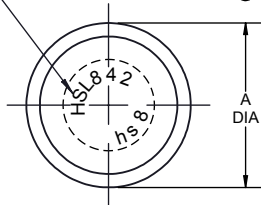


INDENTED HEAD MARKING .010 MAX DEPTH.
MANUFACTURER'S TRADEMARK "hs" PER
SPEC. 363. THE NUMBER(S) FOLLOWING
TRADEMARK INDICATES FIRST DASH. NO.
ARRANGEMENT OPTIONAL. ②



HI-LITE™ PIN

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5					NOTE: USE HSL822-6 ()							
6	7/32	.390 .370	.325	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	9,400	4,350
8	9/32	.460 .435	.395	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	15,500	7,750
10	11/32	.520 .490	.500	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	23,200	12,300
12	13/32	.620 .550	.545	.4057 .4047	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	32,400	19,100
14	15/32	.695 .615	.635	.4682 .4672	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	43,100	25,800
16	17/32	.790 .740	.685	.5307 .5297	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	55,400	34,300

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIM.
 - Dimensions are in inches and to be met after finish.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Lead radius must be tangent to "D" diameter at max grip.
 - Oversize replacement for HSL822 and HSL832.
 - Shorter or longer grip than those listed may be available as specials.
 - 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.

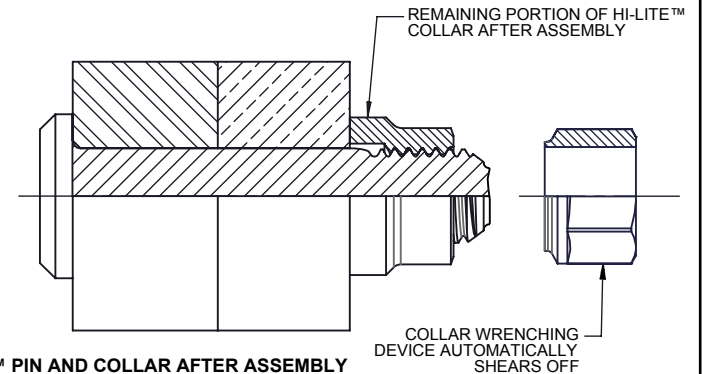
MATERIAL: Nickel Base alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

- FINISH:**
- HSL842DL-()-() = Kalgard FA or EM620C solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-shear Spec. 305.
 - HSL842AP-()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HSL842TB-()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HSL842HK-()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

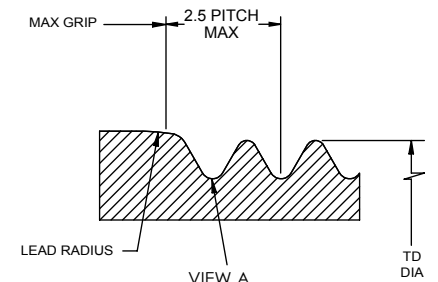
SPECIFICATION: HI-LITE™ Product Specification 380-2.

②



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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



VIEW A
HI-LITE THREAD TRANSITION AREA. THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS. SEE SPECIFICATION FOR INSPECTION.

CODE: First dash number indicates nominal diameter in 1/32nds. pin which HSL842 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER

② **EXAMPLE:**

Pin Part Number
HSL842DL-8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F. OBISPO	DATE 1995-08-08	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD BREAK STEM, INTERFERENCE FIT NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED J. RAUSCH	DATE 1995-08-09		
REVISION ②	DATE K. TRAN 2017-10-31	DRAWING NUMBER HSL842	

TABLE 1

SECOND DASH NUMBER	L REF 7						
		-6 DIA.	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.
1		-	-	-	-	-	-
2		1.000	1.000	-	-	-	-
3		1.125	1.125	1.250	-	-	-
4		1.250	1.250	1.375	1.375	-	-
5		1.375	1.375	1.500	1.500	1.625	-
6		1.500	1.500	1.625	1.625	1.750	1.750
7		1.625	1.625	1.750	1.750	1.875	1.875
8		1.750	1.750	1.875	1.875	2.000	2.000
9		1.875	1.875	2.000	2.000	2.125	2.125
10		2.000	2.000	2.125	2.125	2.250	2.250
11		2.125	2.125	2.250	2.250	2.375	2.375
12		2.250	2.250	2.375	2.375	2.500	2.500
13		2.375	2.375	2.500	2.500	2.625	2.625
14		2.500	2.500	2.625	2.625	2.750	2.750
15		2.625	2.625	2.750	2.750	2.875	2.875
16		2.750	2.750	2.875	2.875	3.000	3.000
17		2.875	2.875	3.000	3.000	3.125	3.125
18		3.000	3.000	3.125	3.125	3.250	3.250
19		3.125	3.125	3.250	3.250	3.375	3.375
20		3.250	3.250	3.375	3.375	3.500	3.500
21		3.375	3.375	3.500	3.500	3.625	3.625
22		3.500	3.500	3.625	3.625	3.750	3.750
23		3.625	3.625	3.750	3.750	3.875	3.875
24		3.750	3.750	3.875	3.875	4.000	4.000
25		-	-	4.000	4.000	4.125	4.125
26		-	-	4.125	4.125	4.250	4.250
27		-	-	4.250	4.250	4.375	4.375
28		-	-	4.375	4.375	4.500	4.500
29		-	-	-	4.500	4.625	4.625
30		-	-	-	4.625	4.750	4.750
31		-	-	-	4.750	4.875	4.875
32		-	-	-	4.875	5.000	5.000
33		-	-	-	5.000	5.125	5.125
34		-	-	-	5.125	5.250	5.250
35		-	-	-	5.250	5.375	5.375
36		-	-	-	5.375	5.500	5.500
37		-	-	-	5.500	5.625	5.625
38		-	-	-	5.625	5.750	5.750
39		-	-	-	5.750	5.875	5.875
40		-	-	-	5.875	6.000	6.000
41		-	-	-	6.000	6.125	6.125
42		-	-	-	6.125	6.250	6.250
43		-	-	-	6.250	6.375	6.375
44		-	-	-	6.375	6.500	6.500

DRAWING NUMBER

HSL842

HSL842