HI-SHEAR Corporation, USA
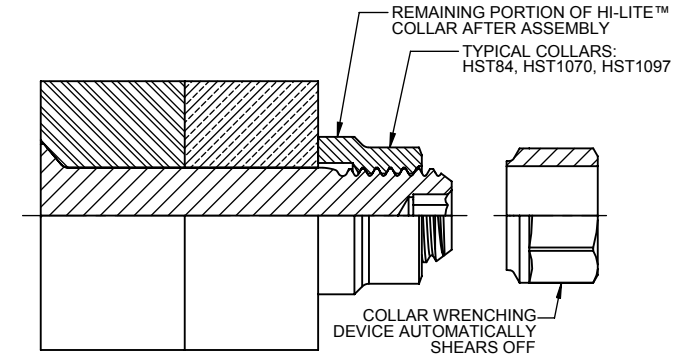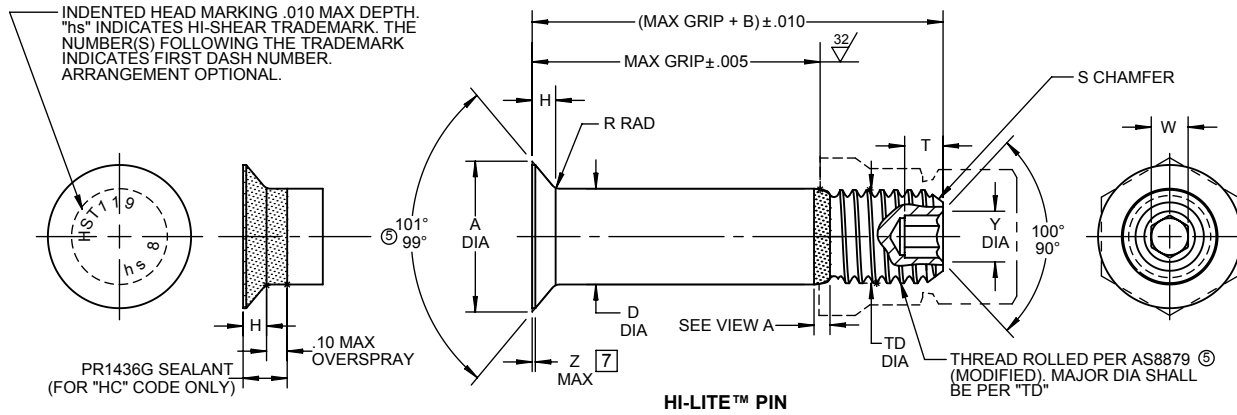a LISI AEROSPACE Company

Design Holder

CAGE No. 73197

⑤ For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES

INDENTED HEAD MARKING .010 MAX DEPTH. "hs" INDICATES HI-SHEAR TRADEMARK. THE NUMBER(S) FOLLOWING THE TRADEMARK INDICATES FIRST DASH NUMBER. ARRANGEMENT OPTIONAL.

HST119
hs 8

(MAX GRIP + B) ±.010
MAX GRIP ±.005

H
R RAD
A DIA
D DIA
Z MAX
101°/99°
⑤

S CHAMFER
T
W
Y DIA
100°/90°
TD DIA

THREAD ROLLED PER AS8879 ⑤ (MODIFIED). MAJOR DIA SHALL BE PER "TD"

SEE VIEW A

PR1436G SEALANT (FOR "HC" CODE ONLY)
.10 MAX OVERSPRAY
H

HI-LITE™ PIN

REMAINING PORTION OF HI-LITE™ COLLAR AFTER ASSEMBLY

TYPICAL COLLARS: HST84, HST1070, HST1097

COLLAR WRENCHING DEVICE AUTOMATICALLY SHEARS OFF

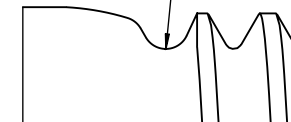**HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY**

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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F REF	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5		NOTE: USE HST19-6-( )														
6	13/64	.3016 .2966	.300	.2026 .2016	.1840 .1810	.005	.0415 .0394	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,130	2,000
8	17/64	.3948 .3898	.330	.2651 .2641	.2440 .2410	.006	.0544 .0523	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	10,490	3,700
10	21/64	.4739 .4689	.390	.3276 .3266	.3060 .3020	.007	.0614 .0593	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	16,000	5,000
12	25/64	.5604 .5554	.430	.3901 .3891	.3680 .3640	.008	.0714 .0693	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	22,700	7,200
14	29/64	.6680 .6620	.510	.4526 .4516	.4310 .4260	.009	.0904 .0879	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	30,600	10,000
16	33/64	.7540 .7480	.610	.5151 .5141	.4930 .4880	.010	.1002 .0977	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	39,600	13,500

HST119

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY	DATE	TITLE
D.P.S.	1990-08-03	HI-LITE™ PIN
APPROVED	DATE	100° FLUSH SHEAR HEAD
JGWILCOX	1990-08-03	ALLOY STEEL
REVISION	DATE	1/16 GRIP VARIATION, 1/64 OVERSIZE
⑤	M.BEARD 2017-04-27	DRAWING NUMBER **HST119** 1 OF 2

LISI AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

GENERAL NOTES:
- [1] Head edge out of roundness shall not exceed "F".
- 2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
- 3. "H" is dimensioned from maximum "D" diameter.
- [5] 4. Dimensions are in inches and to be met after finish.
- [5] 5. Surface texture per ASME B46.1.
- 6. Hole preparation per NAS618.
- [7] Curved or flat edge manufacturer's option.
- [8] Non-lubed pins must be used with wet sealant or with lubed collars.
- 9. Use HST219 for oversize replacement.

MATERIAL: Alloy Steel per AMS6415, AMS6349, AMS6322, AMS6327 or AMS6325.[5]

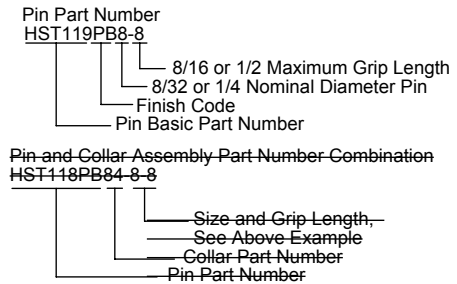**HEAT TREAT:** 95,000 psi shear minimum (160,000 psi tensile per AMS-H-6875).

FINISH:
HST119-( )-( )	= Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST119PB( )-( )	= Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST119HC( )-( )	= Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and apply Precoat No. PR1436G sealant (.002-.005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
[8] HST119PN( )-( )	= Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
HST119RZ( )-( )	= Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST119TF( )-( )	= Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
HST119TP( )-( )	= Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, color orange on thread end, 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 HST119 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See finish note for explanation of code letters.

HOW TO ORDER
[5] **EXAMPLE:** Pin Part Number

HST119PB8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HST118PB84-8-8
- ~~Size and Grip Length,~~
- ~~See Above Example~~
- ~~Collar Part Number~~
- ~~Pin Part Number~~