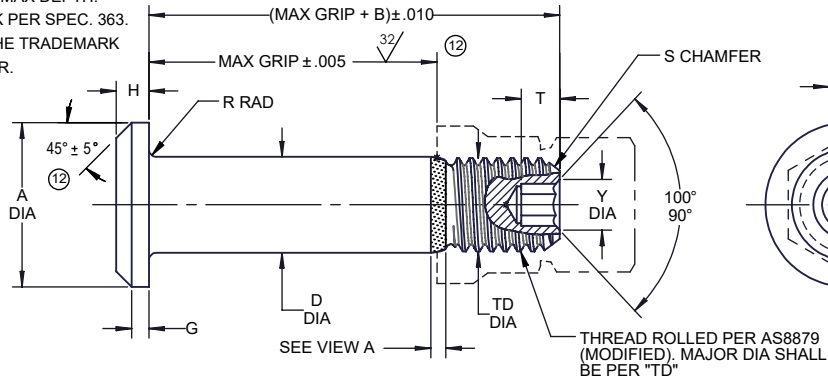
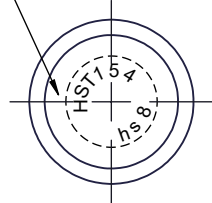
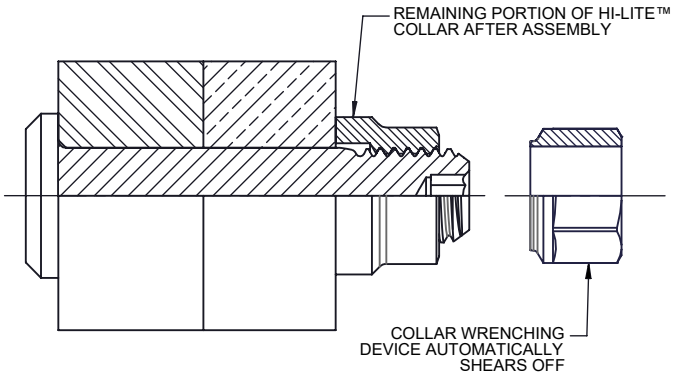


⑫ INDENTED HEAD MARKING .010 MAX DEPTH.
 MANUFACTURER'S TRADEMARK PER SPEC. 363.
 THE NUMBER(S) FOLLOWING THE TRADEMARK
 INDICATES FIRST DASH NUMBER.
 ARRANGEMENT OPTIONAL.



HI-LITE™ PIN

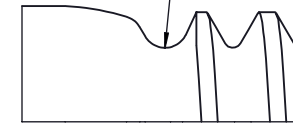


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

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	WITH COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
				NOTE: USE HST54-6-()												
6	13/64	.377 .357	.300	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	8,100	4,350
8	17/64	.440 .415	.330	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	13,800	7,750
10	21/64	.505 .475	.390	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	21,100	12,300
12	25/64	.600 .565	.430	.3901 .3896	.3901 .3891	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	30,000	19,100
14	29/64	.676 .641	.510	.4526 .4521	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	40,300	25,800
16	33/64	.770 .735	.610	.5151 .5146	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	52,500	34,300
18	37/64	.877 .842	.710	.5771 .5766	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	65,600	43,500

THIS AREA OF SPECIAL CONFIGURATION
 AND COLD WORKING TO MEET PHYSICAL
 REQUIREMENTS



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	DATE 1995-03-23	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED E.E.B.	DATE 1995-03-23	
REVISION ⑫	DATE A.CHAE 2022-09-29	DRAWING NUMBER HST154

- GENERAL NOTES:**
1. Concentricity: "A" 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. Use HST254 for oversize replacement.
 - ⑫ ⑥ 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: Nickel base alloy per AMS5662.

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

- ⑫ **FINISH:** HST154-()-() = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑫ ⑥ HST154AC()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color code green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑫ ⑥ HST154AG()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑫ ⑥ HST154AP()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑫ ⑥ HST154AZ()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST154CT()-() = Color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST154CZ()-() = Color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑫ ⑥ HST154GD()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST154RP()-() = Phosphate fluoride treat with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST154RS()-() = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color code orange thread end.
- HST154RV()-() = Phosphate fluoride treat, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST154TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST154NKJ()-() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST154NKL()-() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST154HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
- ⑫ HST154NAP()-() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, 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 HST154 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER
EXAMPLE:**

