



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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						NOTE: USE HST57()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	45/64	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
28	49/64	1.3197 1.3030	1.010	.8896 .8891	.8896 .8886	.8680 .8610	.014	.1804 .1734	.050 .040	.022	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	TBD	TBD

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

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

DRAWN BY J.F.OBISPO	DATE 1996-05-22	TITLE HI-LITE™ PIN 100° FLUSH SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED MC	DATE 1996-05-28	DRAWING NUMBER HST157	
REVISION 10	DATE A.CHAE 2022-10-10	1 OF 2	

- 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 HST257 for oversize replacement.
 - 10 Broach petals removed.
 - 11 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating 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 steel per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

- 10 **FINISH:** HST157-()-() = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 10 11 HST157AC()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 10 11 HST157AG()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 10 11 HST157AP()-() = 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.
- HST157DU()-() = Solid film lube per AS5272, Type I.
- 10 11 HST157GM()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads (no overspray on the shank allowed) and top of head only (.005 max overspray on the head bearing surface permissible) with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 10 HST157MA()-() = Solid film lube per "KalGard™ RA". "KALGARD" is a trademark of Metal Improvement Company.
- HST157TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST157TP()-() = 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.
- HST157NKJ()-() = 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.
- HST157NKL()-() = 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.
- HST157HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
- 10 HST157NAP()-() = 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 HST157 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
 HST157AP8-8

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

HST157

DRAWING NUMBER

HST157

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