

#### 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
											W HEX	T DEPTH	Y DIA		
5	5/32	.262 .242	.280	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	5	4,010	1,940
6	3/16	.315 .295	.290	.1895 .1885	.1840 .1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,380	2,500
8	1/4	.412 .387	.320	.2495 .2485	.2440 .2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,300	4,300
10	5/16	.505 .475	.380	.3120 .3110	.3060 .3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,600	6,300
12	3/8	.600 .565	.420	.3745 .3735	.3680 .3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,000	8,700
14	7/16	.676 .641	.485	.4370 .4360	.4310 .4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	28,600	12,100
16	1/2	.770 .735	.525	.4995 .4985	.4930 .4880	.050	.115 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	37,300	15,300
18	9/16	.864 .829	.600	.5615 .5605	.5550 .5500	.055	.127 .112	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	47,200	19,000
20	5/8	.953 .918	.660	.6240 .6230	.6180 .6120	.060	.137 .122	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	58,300	23,000

- GENERAL NOTES:**
1. Concentricity: "A" diameter to "D" diameter within .010 FIM.
  - (10) 2. Dimensions are in inches and to be met after finish.
  - (10) 3. Surface texture per ASME B46.1.
  4. Hole preparation per NAS618.
  - (5) Evidence of broken edge across points.
  - (6) Non-lubed pins must be used with wet sealant or with lubed collars.
  7. Use HST118 for oversize replacement.

**MATERIAL:** Alloy steel per AMS6415, AMS6349, AMS6322, AMS6327 or AMS6325. (10)

**HEAT TREAT:** 95,000 psi minimum (160,000 - 180,000 psi tensile per AMS-H-6875).

- FINISH:**
- HST18(-)(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST18PA(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST18PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - (6) HST18PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
  - HST18TF(-)(-) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
  - HST18TP(-)(-) = 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™ Specification 380.

**CODE:** First dash number indicates nominal diameter in 1/32nds. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

#### HOW TO ORDER

(10) **EXAMPLE:**

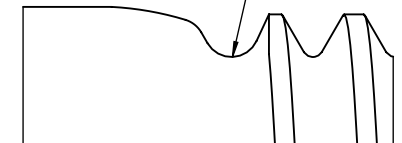
Pin Part Number  
 HST18PB8-8

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

(10) **Pin and Collar Assembly Part Number Combination**  
 HST18PB1094-8-8

- Size and Grip Length
- See Above Example
- Collar Part Number
- Pin Finish
- Pin Part Number

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 D.P.S.		DATE 1982-09-10		TITLE HI-LITE™ PIN PROTRUDING SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION	
APPROVED E.E.BEELES		DATE 1982-09-13			
REVISION ⑩		DATE F.CARINGELLA 2017-03-27		DRAWING NUMBER HST18	