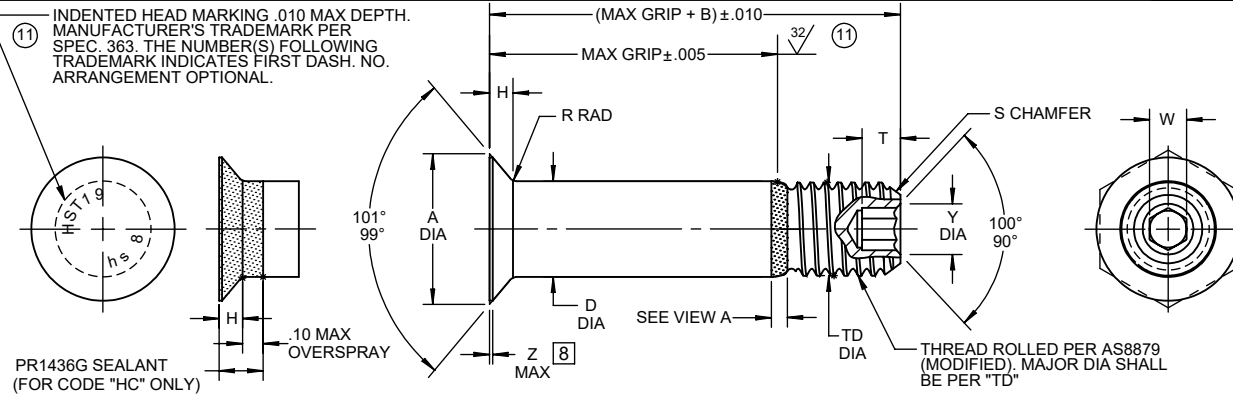
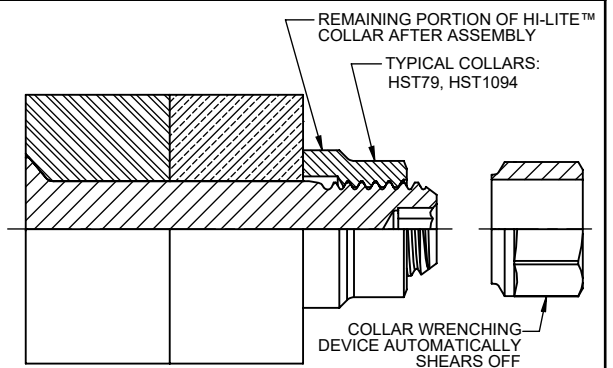


⑪ INDENTED HEAD MARKING .010 MAX DEPTH.  
MANUFACTURER'S TRADEMARK PER  
SPEC. 363. THE NUMBER(S) FOLLOWING  
TRADEMARK INDICATES FIRST DASH. NO.  
ARRANGEMENT OPTIONAL.



HI-LITE™ PIN

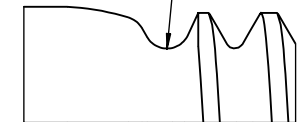


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
5	5/32	.2612 .2564	.280	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.012	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	⑪	4,010	1,290
6	3/16	.3016 .2966	.290	.1895 .1885	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,380	2,000
8	1/4	.3948 .3898	.320	.2495 .2485	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,300	3,700
10	5/16	.4739 .4689	.380	.3120 .3110	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,600	5,000
12	3/8	.5604 .5554	.420	.3745 .3735	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,000	7,200
14	7/16	.6680 .6620	.485	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	28,600	10,000
16	1/2	.7540 .7480	.525	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	37,300	13,500

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 D.P.S.	DATE 1982-09-10	TITLE HI-LITE™ PIN 100° FLUSH SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION
APPROVED E.E.BEELS	DATE 1982-09-19	
REVISION ⑪	DATE A.CHAE 2022-05-04	DRAWING NUMBER <b>HST19</b>

**GENERAL NOTES:**

- 1 Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
3. "H" is dimensioned from maximum "D" diameter.
4. Dimensions are in inches and to be met after plating.
5. Surface texture per ASME B46.1.
6. Hole preparation per NAS618.
- 7 Evidence of broken edge across points.
- 8 Curved or flat edge manufacturer's option.
- 9 Non-lubed pins must be used with wet sealant or with lubed collars.
10. Use HST119 for oversize replacement.

**MATERIAL:**

Alloy steel per AMS6415, AMS6484, AMS6349, AMS6382, AMS6322, AMS6325 or AMS6327.

**HEAT TREAT:**

95,000 psi shear minimum (160,000-180,000 psi tensile) per AMS2759.

**FINISH:**

- HST19-( )-( ) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST19HC( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and apply precoat No. PR1436G sealant (.002-.005 thick) plus cetyl alcohol lube per Hi-Shear Spec. 305.
- HST19PA( )-( ) = 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.
- HST19PB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color bronze, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 9 HST19PN( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
- HST19TF( )-( ) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
- HST19TP( )-( ) = 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.
- HST19HK( )-( ) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

**SPECIFICATION:**

HI-LITE™ Product 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  
EXAMPLE:**

Pin Part Number

HST19PB8-8

8/16 or 1/2 Minimum Grip length

8/32 or 1/4 Nominal Diameter Pin

Finish Code

Pin Basic Part Number

Pin and Collar Assembly Part Number Combination

HST19PB79-8-8

Size and grip length, see above example

Collar Part Number

Pin Finish

Pin Part Number