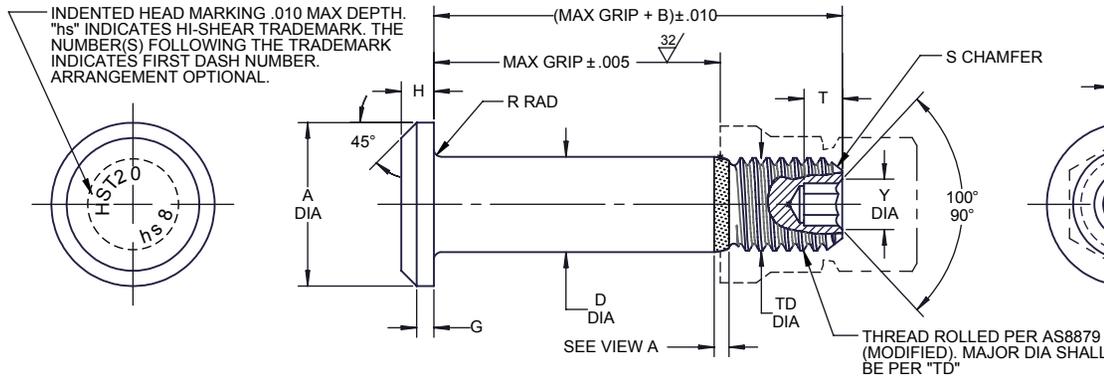
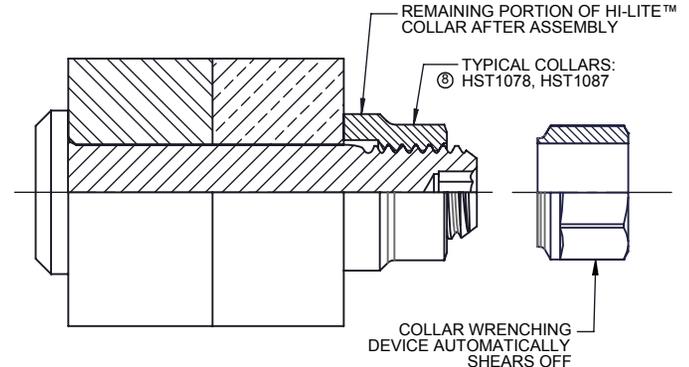


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HI-LITE™ PIN



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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	.322 .306	.280	.1635 .1625	.1595 .1570	.030	.065 .055	.025 .015	1/32 x 45°	.1640-12 UNJC-3A	.0801 .0791	.100 .080	5	4,010	2,180
6	3/16	.377 .357	.290	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,380	3,180
8	1/4	.440 .415	.320	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,300	5,820
10	5/16	.505 .475	.380	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,600	9,200
12	3/8	.600 .565	.420	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,000	14,000
14	7/16	.676 .641	.500	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	28,600	18,900
16	1/2	.770 .735	.600	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	37,300	25,600

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

- 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. Evidence of broken edge across points.
 6. Non-lubed pins must be used with wet sealant or with lubed collar.
 7. Use HST120 for oversize replacement.

MATERIAL: Alloy steel per AMS6415, AMS6349, AMS6322, AMS6327 or AMS6325.

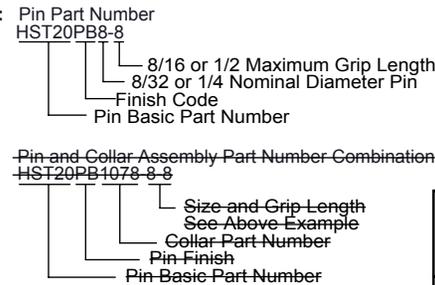
HEAT TREAT: 160,000 - 180,000 psi tensile per AMS-H-6875.

- FINISH:**
- HST20(-)(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST20CG(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST20PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 6 HST20PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 - HST20TF(-)(-) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.

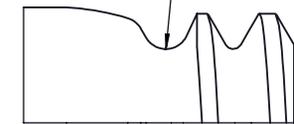
SPECIFICATION: HI-LITE™ Product Specification 380.

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:



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 1983-03-18
APPROVED R.TING	DATE 1983-03-18
REVISION 8	DATE F.CARINGELLA 2019-06-27
TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION	
DRAWING NUMBER HST20	