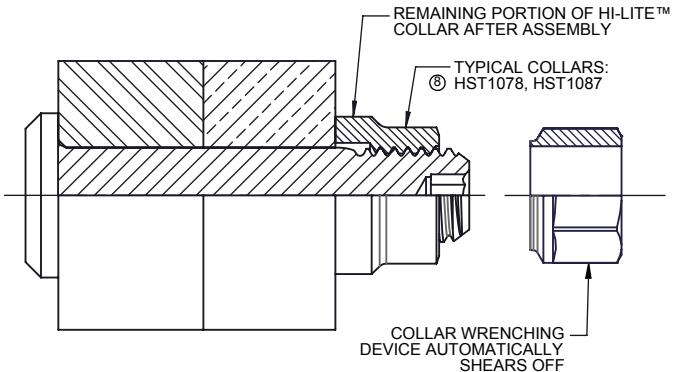


HI-LITE™ PIN



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

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIM.
 - Dimensions are in inches and to be met after finish.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Evidence of broken edge across points.
 - Non-lubed pins must be used with wet sealant or with lubed collar.
 - 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.

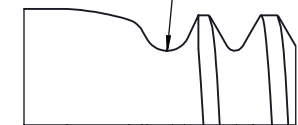
CODE: First dash number indicates nominal diameter in 1/32nds.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

**HOW TO ORDER
 EXAMPLE:**

Pin Part Number
 HST20PB8-8
 8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number
 Pin and Collar Assembly Part Number Combination
 HST20PB1078-8-8
 Size and Grip Length
 See Above Example
 Collar Part Number
 Pin Finish
 Pin Basic Part Number

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