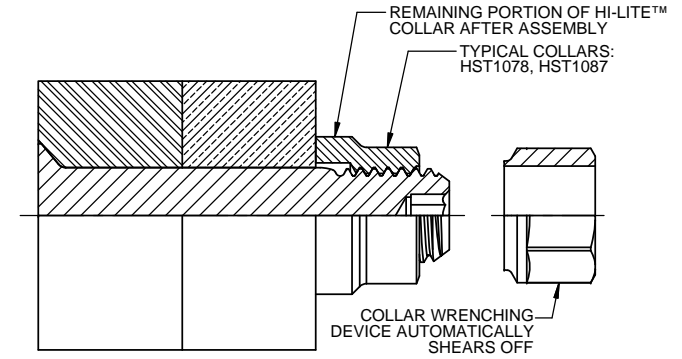
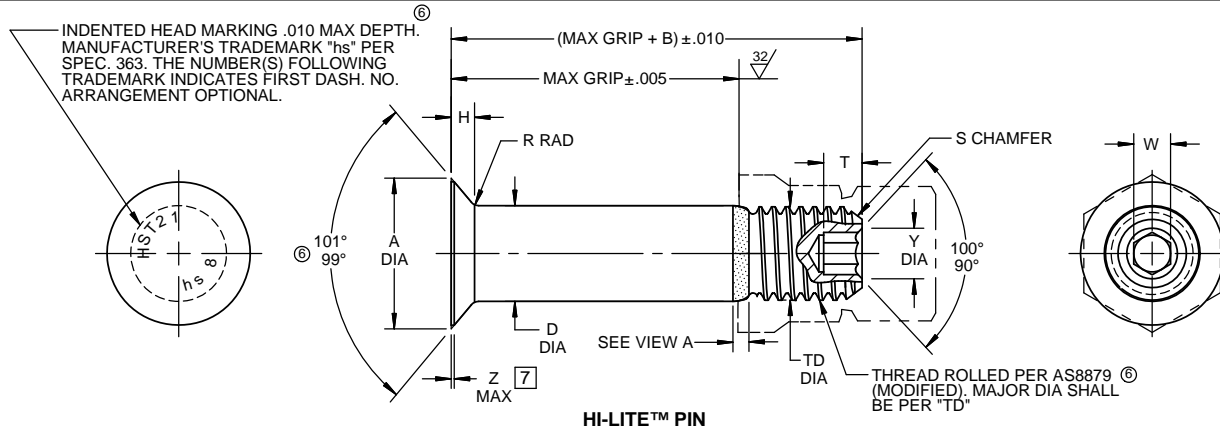


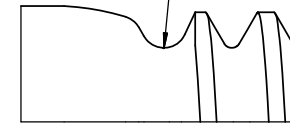
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SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	F REF	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	.3304 .3256	.280	.1635 .1625	.1595 .1570	.004	.0700 .0680	.025 .015	.012	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	8	4,010	2,180
6	3/16	.3813 .3765	.290	.1895 .1885	.1840 .1810	.005	.0805 .0785	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	5,380	3,180
8	1/4	.5066 .5018	.320	.2495 .2485	.2440 .2410	.006	.1080 .1060	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	9,300	5,820
10	5/16	.6335 .6287	.380	.3120 .3110	.3060 .3020	.007	.1350 .1330	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	14,600	9,200
12	3/8	.7604 .7556	.420	.3745 .3735	.3680 .3640	.008	.1620 .1600	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	21,000	14,000
14	7/16	.8884 .8812	.500	.4370 .4360	.4310 .4260	.009	.1895 .1865	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	28,600	18,900
16	1/2	1.0139 1.0068	.600	.4995 .4985	.4930 .4880	.010	.2160 .2130	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	37,300	25,600

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS



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

DRAWN BY D.P.S.	DATE 1983-03-16	TITLE HI-LITE™ PIN 100° FLUSH MS24694 TENSION HEAD ALLOY STEEL 1/16 GRIP VARIATION
APPROVED JGWILCOX	DATE 1983-03-18	
REVISION 6	DATE M.BEARD 2017-05-01	DRAWING NUMBER HST21

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 - 2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - 3. "H" is dimensioned from maximum "D" diameter.
 - ⑥ 4. Dimensions are in inches and to be met after finish.
 - ⑥ 5. Surface texture per ASME B46.1.
 - 6. Hole preparation per NAS618.
 - 7 Curved or flat edge manufacturer's option.
 - 8 Evidence of broken edge across points.
 - 9 Non-lubed pins must be used with wet sealant or with lubed collars.
 - 10. Use HST121 for oversize replacement.

MATERIAL: ⑥ Alloy steel per AMS6415, AMS6349, AMS6322, AMS6327 or AMS6325.

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

- FINISH:**
- HST21(-)(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST21CG(-)(-) = 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.
 - HST21PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 9 HST21PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 - HST21TF(-)(-) = 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
⑥ **EXAMPLE:**

