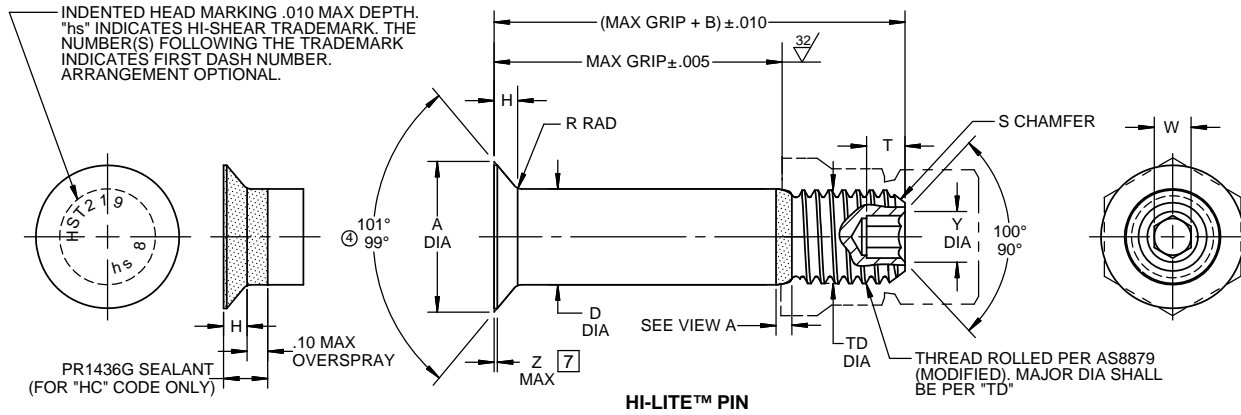
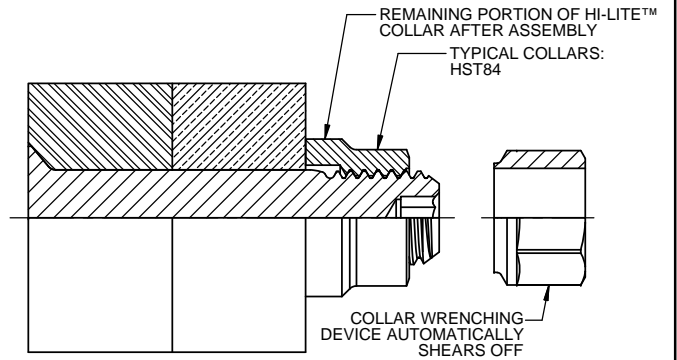


④ For the current list of licensed manufacturers, please visit the  
 LISI AEROSPACE website at:  
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)



HI-LITE™ PIN

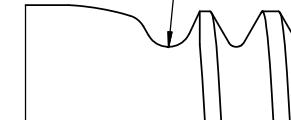


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

①																	⑦																	④																
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	13/64				NOTE: USE HST119-6-()																																													
6	7/32	.3303 .3253	.300	.2182 .2177	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,100	2,000																																		
8	9/32	.4260 .4210	.330	.2807 .2802	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.150 .130	.142 .122	11,800	3,700																																		
10	11/32	.5051 .5001	.390	.3432 .3427	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.170 .150	.180 .160	17,600	5,000																																		
12	13/32	.5916 .5866	.430	.4057 .4052	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.200 .180	.217 .197	24,600	7,200																																		
14	15/32	.6992 .6932	.495	.4682 .4677	.4310 .4260	.009	.0989 .0944	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.230 .210	.253 .233	32,700	10,000																																		
16	17/32	.7852 .7792	.535	.5307 .5302	.4930 .4880	.010	.1069 .1043	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.260 .240	.289 .269	42,000	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 1990-08-30	TITLE HI-LITE™ PIN 100° FLUSH SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED JGWILCOX	DATE 1990-08-30	
REVISION ④	DATE M.BEARD 2017-05-01	DRAWING NUMBER <b>HST219</b>

- 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.
  - ④ 4. Dimensions are in inches and to be met after finish.
  - ④ 5. Surface texture per ASME B46.1.
  - 6. Hole preparation per NAS618.
  - 7 Curved or flat edge manufacturer's option.
  - 8 Non-lubed pins must be used with wet sealant or with lubed collars.

**MATERIAL:** Alloy steel per AMS6415, AMS6349, or AMS-S-6049.

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

- FINISH:**
- HST219(-)(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST219PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST219HC(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and apply Precoat No. PR1436G sealant (.002-.005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
  - 8 HST219PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
  - HST219RZ(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST219TF(-)(-) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
  - HST219TP(-)(-) = 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™ Product Specification 380.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HST219 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See finish note for explanation of code letters.

**HOW TO ORDER**  
 ④ **EXAMPLE:**

