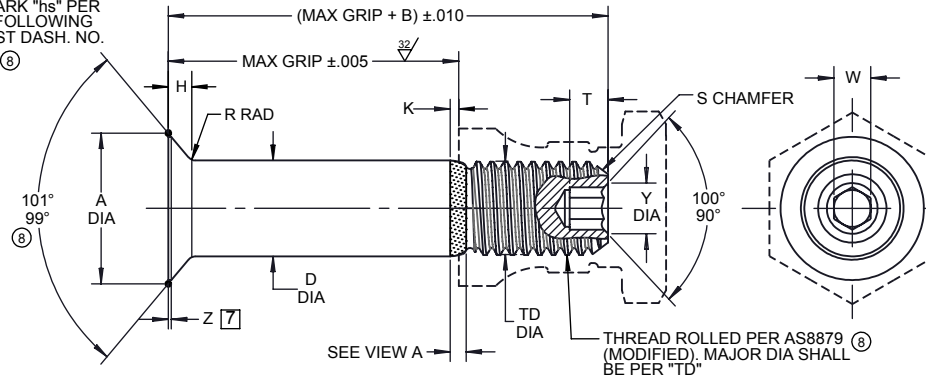
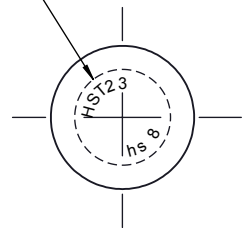
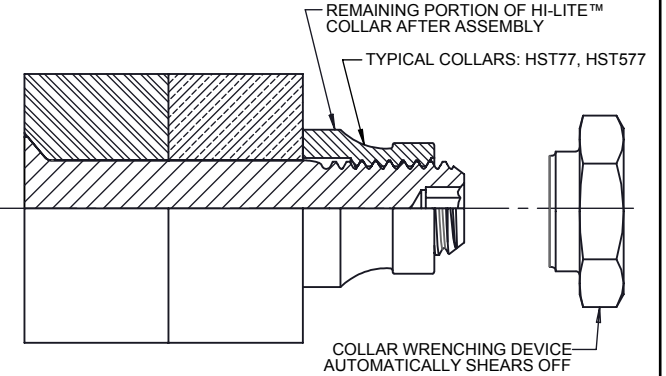


INDENTED HEAD MARKING .010 MAX DEPTH.
 MANUFACTURER'S TRADEMARK "hs" PER
 SPEC. 363. THE NUMBER(S) FOLLOWING
 TRADEMARK INDICATES FIRST DASH. NO.
 ARRANGEMENT OPTIONAL.



HI-LITE™ PIN



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

| 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 | .2922 .2874 | .280 | .1635 .1625 | .1595 .1570 | .004 | .0540 .0520 | .025 .015 | .010 | 1/32 x 45° | .1640-32 UNJC-3A | .0645 .0635 | .090 .070 | .090 .075 | 1,760 | 880 |
| 6 | 3/16 | .3536 .3486 | .290 | .1895 .1885 | .1840 .1810 | .005 | .0688 .0667 | .030 .020 | .015 | 1/32 x 45° | .1900-32 UNJF-3A | .0806 .0791 | .100 .080 | .119 .104 | 2,540 | 1,150 |
| 8 | 1/4 | .4732 .4682 | .320 | .2495 .2485 | .2440 .2410 | .006 | .0939 .0918 | .030 .020 | .015 | 1/32 x 45° | .2500-28 UNJF-3A | .0967 .0947 | .110 .090 | .142 .122 | 4,500 | 2,000 |
| 10 | 5/16 | .5619 .5569 | .380 | .3120 .3110 | .3060 .3020 | .007 | .1048 .1027 | .040 .030 | .015 | 3/64 x 45° | .3125-24 UNJF-3A | .1295 .1270 | .130 .110 | .180 .160 | 7,050 | 2,800 |
| 12 | 3/8 | .6912 .6862 | .420 | .3745 .3735 | .3680 .3640 | .008 | .1329 .1308 | .040 .030 | .015 | 3/64 x 45° | .3750-24 UNJF-3A | .1617 .1582 | .160 .140 | .217 .197 | 10,100 | 3,900 |
| 14 | 7/16 | .8041 .7969 | .485 | .4370 .4360 | .4310 .4260 | .009 | .1540 .1510 | .050 .040 | .022 | 3/64 x 45° | .4375-20 UNJF-3A | .1930 .1895 | .190 .170 | .253 .233 | 13,800 | 6,000 |
| 16 | 1/2 | .9166 .9095 | .525 | .4995 .4985 | .4930 .4880 | .010 | .1750 .1720 | .050 .040 | .022 | 3/64 x 45° | .5000-20 UNJF-3A | .2242 .2207 | .220 .200 | .289 .269 | 18,000 | 7,600 |

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

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" dimensioned from maximum "D" diameter.
 - Dimensions are in inches and to be met after finish.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Curved of flat edge manufacturer's option.
 - Use HST123 for oversize replacement.

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
 HST23DU8-8
 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
 HST23DU778-8
 Size and Grip Length,
 See Above Example
 Collar Part Number
 Pin Part Number

MATERIAL: 7075 aluminum alloy per AMS-QQ-A-225/9 or QQ-A-430.

HEAT TREAT: Age to T6 condition per MIL-H-6088.

FINISH: HST23(-)(-) = Anodized per MIL-A-8625, dye color natural,
 and cetyl alcohol lube per Hi-Shear Spec. 305.

HST23DU(-)(-) = Anodized per MIL-A-8625, and solid film lube per
 AS5272, Type I.

HST23EY(-)(-) = Anodized per MIL-A-8625, dye color yellow, and cetyl
 alcohol lube per Hi-Shear Spec. 305.

HST23TT(-)(-) = Anodized per MIL-A-8625, dye color natural, and
 TRANSLUBE.

SPECIFICATION: HI-LITE™ Product Specification 380.

| | |
|---|-------------------------------|
| "HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION | |
| DRAWN BY S. GRAPHICS | DATE 1983-09-29 |
| APPROVED E. E. B. | DATE 1983-10-04 |
| REVISION 8 | DATE K. TRAN 2017-12-04 |
| TITLE HI-LITE™ PIN 100° FLUSH MS20426 SHEAR HEAD ALUMINUM ALLOY 1/16 GRIP VARIATION | |
| DRAWING NUMBER HST23 | |