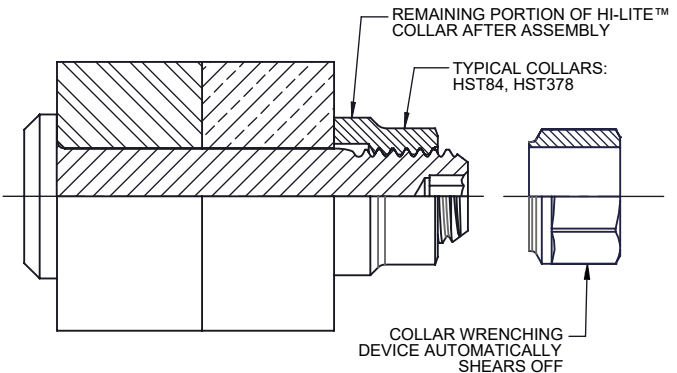


HI-LITE™ PIN



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

6															* *	
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
				WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE							W HEX	T DEPTH	Y DIA		
5	3/16			NOTE: USE HST48-6												
6	13/64	.377 .357	.290	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	6,130	3,180
8	17/64	.440 .415	.320	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .077	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	10,490	5,820
10	21/64	.502 .472	.380	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .098	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	16,000	9,200
12	25/64	.565 .530	.420	.3901 .3896	.3901 .3891	.3680 .3640	.065	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	22,700	14,000
14	29/64	.627 .592	.485	.4526 .4521	.4526 .4516	.4310 .4260	.075	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	30,600	18,900
16	33/64	.752 .717	.525	.5151 .5146	.5151 .5141	.4930 .4880	.085	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	39,600	25,600

- GENERAL NOTES:**
1. Concentricity: Head to "D" diameter within .010 FIR.
 2. Dimensions are in inches and to be met after finish.
 3. Non-lubed pins must be used with lubed collars.
 4. Surface texture per ASME B46.1.
 5. Hole preparation per NAS618.
 6. Maximum "D" diameter may be increased by .0002" to allow for solid film application

CODE: First dash number indicates nominal diameter in 1/32nds which HST248 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

**HOW TO ORDER
EXAMPLE:**

Pin Part Number
HST248DU-8-8
8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Finish Code
Pin Basic Part Number

Pin and Collar Assembly Part Number
HST24884-8-8

Size and Grip Length,
See Above Example
Collar Part Number
Pin Part Number

- ② **MATERIAL:** A-286 high temperature alloy per Spec. AMS5737, AMS5731, AMS5726, or AMS5853
HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum) at 70°F.
- ② **FINISH:** HST248-()-() = Passivate per AMS2700, Method 1, Type 8, Class 1 and cetyl alcohol lube per Hi-Shear Spec. 305.
HST248DU()-() = Solid film lube per AS5272.
HST248NY()-() = Passivate per AMS2700, Method 1, Type 8, Class 1, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST248PY()-() = Passivate per AMS2700, Method 1, Type 8, Class 1
HST248V()-() = Solid film lube per "LUBECO" 2123, Type II.
- SPECIFICATION:** HI-LITE™ Product Specification 380.

* * The Double Shear values shown
are based on cross sectional
area for nominal diameter pin.

"HI-LITE", "HST", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY D.P.S.	DATE 1983-12-23	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED E.E.B.	DATE 1984-02-07	
REVISION 2	DATE C.CARTOS 2023-04-10	DRAWING NUMBER HST248 1 OF 1