

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
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
5	5/32	.322 .306	.280	.1635 .1630	.1635 .1625	.1595 .1570	.030	.065 .055	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.100 .080	.104 .094	5,280	2,940
6	3/16	.377 .357	.290	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	7,060	4,350
8	1/4	.440 .415	.320	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	12,260	7,750
10	5/16	.505 .475	.380	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	19,160	12,300
12	3/8	.600 .565	.420	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	27,600	19,100
14	7/16	.676 .641	.500	.4370 .4365	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	37,500	25,800
16	1/2	.770 .735	.600	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	49,100	34,300
18	9/16	.877 .842	.700	.5615 .5610	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	62,100	43,500
20	5/8	.953 .918	.780	.6240 .6235	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	76,700	54,600
24	3/4	1.150 1.110	1.020	.7490 .7485	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	110,400	79,200
28	7/8	1.330 1.290	1.160	.8740 .8735	.8740 .8730	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.400 .370	.471 .451	150,300	117,000
32	1	1.510 1.470	1.305	.9990 .9985	.9990 .9980	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.520 .490	.618 .598	196,300	143,000

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 J.F.OBISPO	DATE 1989-07-25	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION
APPROVED DAW	DATE 1989-07-25	
REVISION (21)	DATE C.CARTOS 2023-11-21	DRAWING NUMBER HST54

- ② **GENERAL NOTES:**
1. Concentricity: "A" diameter to "D" diameter within .010 FIM.
 2. Dimensions are in inches and to be met after finish.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 - 5 Broach petals removed.
 6. Use HST154 for oversize replacement.

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum (210,000 psi tensile minimum).

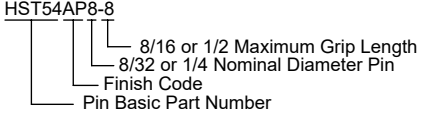
- ② **FINISH:**
- HST54-()-() = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST54AC()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST54AG()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST54AP()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST54AZ()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST54CT()-() = Color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST54CZ()-() = Color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST54GD()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 5 HST54MA()-() = Solid film lube per KalGard RA.
 - HST54RP()-() = Phosphate fluoride treat with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST54RS()-() = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color orange on thread end.
 - HST54RV()-() = Phosphate fluoride treat, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST54TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST54NKJ()-() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST54HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
 - HST54NAP()-() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, 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.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER

EXAMPLE: Pin Part Number



HST54

DRAWING NUMBER

HST54

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