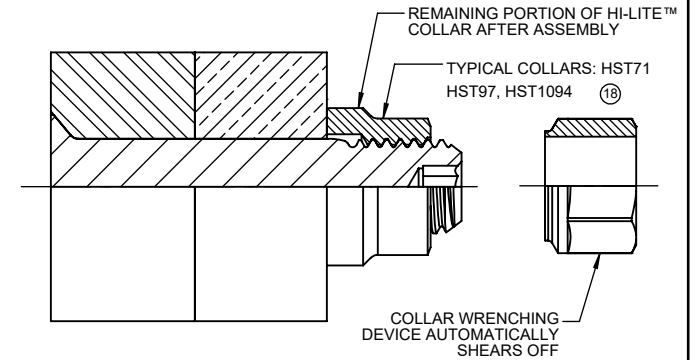


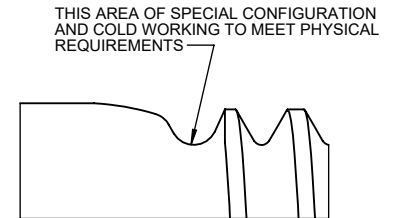
HI-LITE™ PIN



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 |
|----------------|-------------|------------------|-------|-------------------------------|-----------------------------|----------------|------|----------------|--------------|-------|---------------|---------------------|----------------|--------------|--------------|-----------------------------|------------------------|
| | | | | WITHOUT COATING OR SOLID FILM | AFTER COATING OR SOLID FILM | | | | | | | | W HEX | T DEPTH | Y DIA | | |
| 5 | 5/32 | .2612 .2564 | .280 | .1635 .1630 | .1635 .1625 | .1595 .1570 | .004 | .0410 .0390 | .025 .015 | .012 | 1/32 x 45° | .1640-32 UNJC-3A | .0801 .0791 | .100 .080 | [9] | 5,280 | 1,700 |
| 6 | 3/16 | .3016 .2966 | .290 | .1895 .1890 | .1895 .1885 | .1840 .1810 | .005 | .0470 .0450 | .030 .020 | .015 | 1/32 x 45° | .1900-32 UNJF-3A | .0806 .0791 | .100 .080 | .119 .104 | 7,060 | 2,600 |
| 8 | 1/4 | .3948 .3898 | .320 | .2495 .2490 | .2495 .2485 | .2440 .2410 | .006 | .0610 .0590 | .030 .020 | .015 | 1/32 x 45° | .2500-28 UNJF-3A | .0967 .0947 | .110 .090 | .142 .122 | 12,260 | 4,400 |
| 10 | 5/16 | .4739 .4689 | .380 | .3120 .3115 | .3120 .3110 | .3060 .3020 | .007 | .0680 .0660 | .040 .030 | .015 | 3/64 x 45° | .3125-24 UNJF-3A | .1295 .1270 | .130 .110 | .180 .160 | 19,160 | 7,000 |
| 12 | 3/8 | .5604 .5554 | .420 | .3745 .3740 | .3745 .3735 | .3680 .3640 | .008 | .0780 .0760 | .040 .030 | .015 | 3/64 x 45° | .3750-24 UNJF-3A | .1617 .1582 | .160 .140 | .217 .197 | 27,600 | 10,000 |
| 14 | 7/16 | .6680 .6620 | .485 | .4370 .4365 | .4370 .4360 | .4310 .4260 | .009 | .0969 .0944 | .050 .040 | .022 | 3/64 x 45° | .4375-20 UNJF-3A | .1930 .1895 | .190 .170 | .253 .233 | 37,500 | 13,500 |
| 16 | 1/2 | .7540 .7480 | .525 | .4995 .4990 | .4995 .4985 | .4930 .4880 | .010 | .1068 .1043 | .050 .040 | .022 | 3/64 x 45° | .5000-20 UNJF-3A | .2242 .2207 | .220 .200 | .289 .269 | 49,100 | 18,000 |
| 18 | 9/16 | .8380 .8310 | .600 | .5615 .5610 | .5615 .5605 | .5550 .5500 | .010 | .1160 .1131 | .050 .040 | .022 | 1/16 x 45° | .5625-18 UNJF-3A | .2555 .2520 | .260 .240 | .326 .306 | 62,100 | 22,500 |
| 20 | 5/8 | .9250 .9180 | .660 | .6240 .6235 | .6240 .6230 | .6180 .6120 | .010 | .1260 .1230 | .050 .040 | .022 | 1/16 x 45° | .6250-18 UNJF-3A | .2555 .2520 | .260 .240 | .326 .306 | 76,700 | 27,000 |
| 24 | 3/4 | 1.0970 1.0850 | .895 | .7490 .7485 | .7490 .7480 | .7430 .7370 | .012 | .1460 .1410 | .050 .040 | .022 | 1/16 x 45° | .7500-16 UNJF-3A | .3185 .3150 | .330 .300 | .398 .378 | 110,400 | 37,300 |
| 28 | 7/8 | 1.3197 1.3030 | 1.000 | .8740 .8735 | .8740 .8730 | .8680 .8610 | .014 | .1870 .1800 | .050 .040 | .022 | 5/64 x 45° | .8750-14 UNJF-3A | .3820 .3780 | .400 .370 | .471 .451 | 150,300 | 51,800 |

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



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 1994-03-10 | TITLE HI-LITE™ PIN 100° FLUSH SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION |
| APPROVED E.E.B. | DATE 1994-03-10 | |
| REVISION (18) | DATE R. MANZANO 2023-04-06 | DRAWING NUMBER HST57 |

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 - 2 Concentricity: Conical surface of head to "D" diameter within .003 FIM.
 - 3 "H" is dimensioned from maximum "D" diameter.
 - 4 Dimensions are in inches and to be met after finish.
 - 5 Surface texture per ASME B46.1.
 - 6 Hole preparation per NAS618.
 - 7 Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
 - 8 Curved or flat edge manufacturer's option.
 - 9 Evidence of broken edge across points.
 - 10 Broach petals removed.
 - 11 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in the UK and European Union.

MATERIAL: Nickel base alloy steel per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

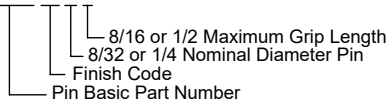
- FINISH:**
- HST57-()-() = Passivate per AMS2700, Method 1, Type 8, Class 1, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 11 HST57AC()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 11 HST57AG()-() = 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.
- 11 HST57AP()-() = 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.
- HST57DU()-() = Solid film lube per AS5272, Type I.
- 11 HST57GM()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads (no overspray on the shank allowed) and top of head only (.005 max overspray on the head bearing surface permissible) with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 10 HST57MA()-() = Solid film lube per "KalGard™ RA". "KALGARD" is a trademark of Metal Improvement Company.
- HST57TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST57TP()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST57NKJ()-() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color silver on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST57NKL()-() = 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.
- HST57HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
- HST57NAP()-() = 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
 HST57AP8-8



DRAWING NUMBER

HST57

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