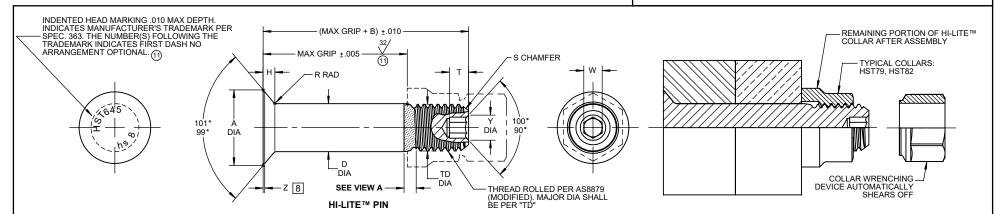
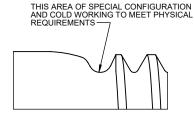
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HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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

					7		1										
FIRST	PIN			D DIA									SOCKET			DOUBLE	TENSION
DASH NO.	NOM DIA	A DIA	B REF	WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM	TD DIA	F	Н	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	W HEX	T DEPTH	Y DIA	SHEAR POUNDS MINIMUM	POUNDS MINIMUM
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	28,000
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	40,200



VIEW A HI-LITE™ THREAD TRANSITION AREA SEE SPECIFICATION FOR INSPECTION

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION						
DATE 2014-12-17	TITLE					
2014-12-17	HI-LITE™ PIN					
1983-03-18	100° FLUSH SHEAR HEAD					
DATE	PH13-8Mo STAINLESS STEEL					
1983-03-18	4/4C CDID VADIATION					
	1/16 GRIP VARIATION					
DATE	DRAWING NUMBER					
B. CHAN 2021-11-09	HST645 1.0F2					
	DATE 2014-12-17 1983-03-18 DATE 1983-03-18 DATE B. CHAN					

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

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. Use HST745 for oversize replacement.
- (1) 11 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in the UK & European Union.

MATERIAL: PH13-8Mo stainless steel per AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HST645-()-() = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305. [] HST645AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl

alcohol lube per Hi-Shear Spec. 305.
HST645TB()-() = HI-KOTE™ 2 solid film lube per per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST645DU()-() = Solid film lube per AS5272, Type I. HST645TP()-() = 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. HST645HK()-() = HI-KOTE™4 NC aluminum coating per Hi-Shear Spec. 397.

HST645NAP()-() = HI-KOTE™1 NC aluminum coating per Hi-Shear Spec. 294 (0.0002 to 0.0005 thickness) 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

HST645AP8-8 └ 8/16 or 1/2 Maximum Grip Length

8/32 or 1/4 Nominal Diameter Pin Finish Code

Pin Basic Part Number

DRAWING NUMBER

2 OF 2