

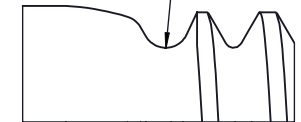
HI-LITE™ PIN

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 PLATING, OR SOLID FILM	WITH PLATING, 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	6	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	.485	.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	.525	.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

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

"HI-LITE", "HST", AND "HI-KOTE"
 ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY D.P.S.	DATE 1983-03-18	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD PH13-8Mo STAINLESS STEEL 1/16 GRIP VARIATION
APPROVED R.TING	DATE 1983-03-18	
REVISION 7	DATE C.Artos 2023-11-13	DRAWING NUMBER HST646

- ⑦ **GENERAL NOTES:**
1. Concentricity: "A" 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 Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
- ⑥ Evidence of broken edge across points.

MATERIAL: PH13-8Mo stainless steel per AMS5629.

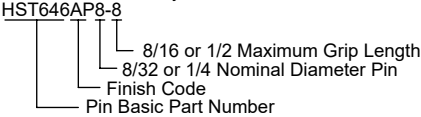
HEAT TREAT: 125,000 psi shear minimum.

- FINISH** ⑦ HST646-()-() = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑦ HST646AP()-() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST646DU()-() = Solid film lube per AS5272, Type I.
- HST646TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST646TP()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST646HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
- HST646NAP()-() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 (0.0002 to 0.0005) 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 Only



HST646