

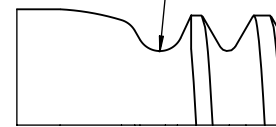
HI-LITE™ PIN

HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA MAX	A' DIA MIN	B REF	D DIA	TD DIA	F	H REF	M GAGE PROT.	R RAD Cold-Worked	V GAGE DIA	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-FATIGUE POUNDS MAXIMUM
															W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA			
5	5/32	.2827	.260	.280	.1635 .1625	.1595 .1570	.004	.049	.0330 .0298	.025 .015	.2028 .2026	.010	1/32 x 45°	.1640-32 UNJC-3A	.0801 .0791	.080	.135	.110	5,280	2,140	650
6	3/16	.3277	.293	.290	.1895 .1885	.1840 .1810	.005	.056	.0295 .0263	.030 .020	.2560 .2558	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.080	.135	.119 .104	7,060	3,000	1,050
8	1/4	.4283	.394	.320	.2495 .2485	.2440 .2410	.006	.074	.0227 .0195	.030 .020	.3732 .3730	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.090	.160	.142 .122	12,260	5,780	2,020
10	5/16	.5361	.501	.380	.3120 .3110	.3060 .3020	.007	.092	.0234 .0198	.040 .030	.4791 .4789	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.110	.200	.180 .160	19,160	8,680	3,030
12	3/8	.6415	.607	.420	.3745 .3735	.3680 .3640	.008	.110	.0295 .0259	.040 .030	.5698 .5696	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.140	.235	.217 .197	27,600	12,700	4,440
14	7/16	.7425	.691	.485	.4370 .4360	.4310 .4260	.009	.126	.0347 .0307	.050 .040	.6582 .6580	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.170	.275	.253 .233	37,500	16,550	5,790
16	1/2	.8423	.791	.525	.4995 .4985	.4930 .4880	.010	.142	.0504 .0464	.050 .040	.7200 .7198	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.200	.315	.289 .269	49,100	22,900	8,010
18	9/16	.9300	.881	.600	.5615 .5605	.5550 .5500	.010	.153	.0533 .0485	.050 .040	.8012 .8010	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	62,100	28,400	9,940
20	5/8	1.0440	.995	.640	.6240 .6230	.6180 .6120	.010	.174	.0633 .0589	.050 .040	.8902 .8900	.022	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	76,700	35,800	12,530
24	3/4	1.3000	1.251	.895	.7490 .7480	.7430 .7370	.012	.229	.0776 .0716	.050 .040	1.1124 1.1122	.022	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.300	.440	.398 .378	110,400	55,500	19,400
28	7/8	1.5091	1.461	1.000	.8740 .8730	.8680 .8610	.014	.263	.0694 .0622	.050 .040	1.3440 1.3438	.022	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.370	.608	.471 .451	150,300	75,000	26,500
32	1	1.7201	1.671	1.160	.9990 .9980	.9930 .9860	.014	.298	.0617 .0536	.050 .040	1.5732 1.5730	.022	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.490	.770	.618 .598	196,300	98,000	34,300

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.H.R.	DATE 1998-09-09	TITLE HI-LITE™ PIN 100° FLUSH SPECIAL SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION
APPROVED MC	DATE 1998-09-24	DRAWING NUMBER HST765
REVISION ①	DATE K. TRAN 2017-11-30	1 OF 2

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 - 2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - 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 Fatigue test pins having grip equal two diameters or longer using these loads at R =0.1.
 - 8 Curved or flat edge manufacturer's option.
 - 9. Use HST767 for oversize replacement.
 - 10 Evidence of broken edge across points.
 - 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 European Union.

MATERIAL: Nickel Base alloy per AMS5662.

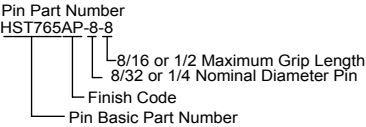
HEAT TREAT: 125,000 psi shear minimum (210,000 psi tensile minimum).

FINISH: 11 HST765AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 380, except as noted 7.

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
 1 **EXAMPLE:**



DRAWING NUMBER

HST765

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