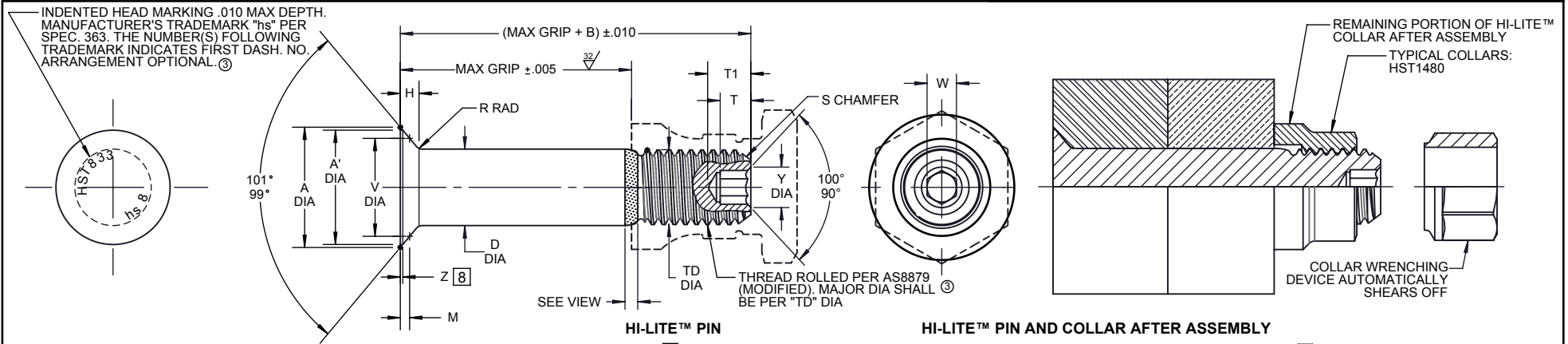
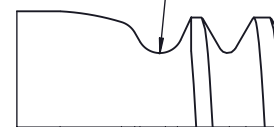




FIRST DASH NO.	NOM DIA	A DIA	A' DIA MIN	B REF	D DIA	TD DIA	F	H REF	M GAGE PROT.	R RAD Cold- Worked	V GAGE DIA	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION FATIGUE POUNDS MAXIMUM
															W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA			
5					NOTE: USE HLT803-6																
6	7/32	.3277	.2963	.300	.2182 .2172	.1840 .1810	.005	.044	.0295 .0263	.030 .020	.2560 .2558	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.080	.135	.119 .104	8,070	2,600	910
8	9/32	.4283	.3969	.330	.2807 .2797	.2440 .2410	.006	.060	.0227 .0195	.030 .020	.3732 .3730	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.090	.160	.142 .122	13,400	5,000	1,750
10	11/32	.5361	.5047	.390	.3432 .3422	.3060 .3020	.007	.079	.0234 .0198	.040 .030	.4791 .4789	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.110	.200	.180 .160	20,000	7,500	2,625
12	13/32	.6415	.6101	.430	.4057 .4047	.3680 .3640	.008	.097	.0295 .0259	.040 .030	.5698 .5696	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.140	.235	.217 .197	28,000	11,000	3,850
14	15/32	.7425	.6941	.495	.4682 .4672	.4310 .4260	.009	.114	.0347 .0307	.050 .040	.6582 .6580	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.170	.275	.253 .233	37,200	14,300	5,000
16	17/32	.8423	.7939	.535	.5307 .5297	.4930 .4880	.010	.128	.0504 .0464	.050 .040	.7200 .7198	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.200	.315	.289 .269	47,700	19,800	6,930
18	19/32	.9300	.8816	.610	.5927 .5917	.5550 .5500	.010	.140	.0533 .0485	.050 .040	.8012 .8010	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	59,600	24,600	8,600
20	21/32	1.0440	.9956	.650	.6552 .6542	.6180 .6120	.010	.161	.0633 .0589	.050 .040	.8902 .8900	.022	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.240	.365	.326 .306	72,900	31,000	10,850
24	25/32	1.3000	1.2516	.905	.7802 .7792	.7430 .7370	.012	.215	.0776 .0716	.050 .040	1.1124 1.1122	.022	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.300	.440	.398 .378	103,000	48,000	16,800
28	29/32	1.5091	1.4606	1.010	.9052 .9042	.8680 .8610	.014	.240	.0694 .0622	.050 .040	1.3440 1.3438	.022	5/64 x 45°	.8750-14 UNJF-3A	.3820 .3780	.370	.608	.471 .451	139,000	65,000	22,750
32	1-1/32	1.7201	1.6716	1.170	1.0302 1.0292	.9930 .9860	.014	.285	.0617 .0536	.050 .040	1.5732 1.5730	.022	5/64 x 45°	1.0000-12 UNJF-3A	.5100 .5040	.490	.770	.618 .598	180,000	85,000	29,750
36	1-5/32	1.9350	1.8870	1.315	1.1552 1.1542	1.1170 1.1100	.015	.327	.0560 .0475	.060 .050	1.8026 1.8024	.022	5/64 x 45°	1.1250-12 UNJF-3A	.5725 .5765	.550	.850	.693 .673	226,000	109,500	38,000

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 D.P.S.	DATE 1992-11-03	TITLE HI-LITE™ PIN 100° FLUSH SPECIAL SHEAR HEAD ALLOY STEEL 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED R. TING	DATE 1992-11-03	DRAWING NUMBER HST833	
REVISION 3	DATE K. TRAN 2017-12-04	1 OF 2	

- 1 Head edge out of roundness shall not exceed ".005".
- 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 Oversize pin for HST803 and HST823.

MATERIAL: ③ Alloy steel per AMS6415, AMS6349 or AMS6322, AMS6325, AMS6327.

HEAT TREAT: ③ 108,000 psi shear minimum (180,000-200,000 psi tensile per AMS-H-6875).

FINISH: ③ HST833- () = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

③ HST833BJ- () = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.

③ HST833CE- () = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick) with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

③ HST833CG- () = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, with color green on thread end, 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 of the pin which HST833 pin replaces.
Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER

③ EXAMPLE:

Pin Part Number

HST833CG 8-8

Diagram illustrating the structure of a pin part number:

- Pin Basic Part Number
- Finish Code
- 8/32 or 1/4 Nominal Diameter Pin
- 8/16 or 1/2 Maximum Grip Length

HST833

DRAWING NUMBER

HST833

2 OF 2