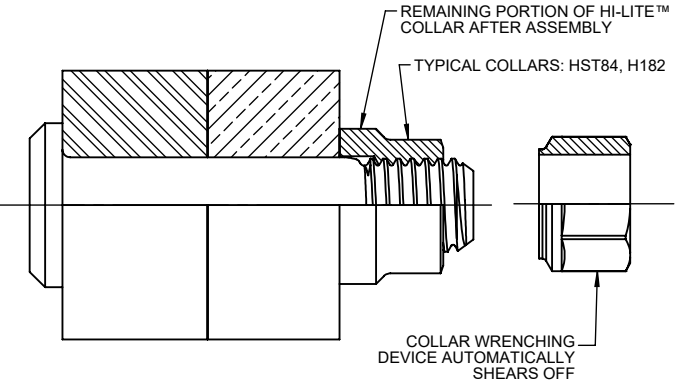


HI-LITE™ PIN



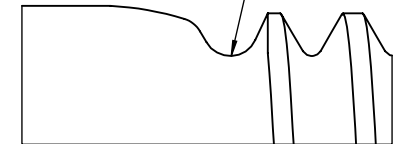
HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

5

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 COATING OR SOLID FILM	AFTER COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
5	5/32						NOTE: USE HST744() 6-()									
6	7/32	.315 295	.300	.2182 2177	.2182 2172	.1840 1810	.025	.055 .045	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,400	3,000
8	9/32	.412 387	.330	.2807 2802	.2807 2797	.2440 2410	.030	.069 .059	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	15,500	5,100
10	11/32	.505 475	.390	.3432 3427	.3432 3422	.3060 3020	.035	.078 .068	.030 .020	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	23,200	8,000
12	13/32	.600 565	.430	.4057 4052	.4057 4047	.3680 3640	.040	.088 .078	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	32,400	11,300
14	15/32	.676 641	.495	.4682 4677	.4682 4672	.4310 4260	.045	.105 .093	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	43,100	15,500
16	17/32	.770 735	.535	.5307 5302	.5307 5297	.4930 4880	.050	.119 .103	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,400	20,000

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

HST844

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

DRAWN BY D.P.S.	DATE 1988-01-20	TITLE HI-LITE™ PIN PROTRUDING SHEAR HEAD PH13-8Mo-STAINLESS STEEL 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED E.E.BEELES	DATE 1988-01-25	
REVISION 5	DATE A.CHAE 2021-12-14	DRAWING NUMBER HST844

- GENERAL NOTES:**
1. Concentricity: "A" diameter 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. Oversize pin replacement for HST644 and HST744.
 - 7 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 and European Union.

MATERIAL: PH13-8Mo stainless steel per Spec. AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

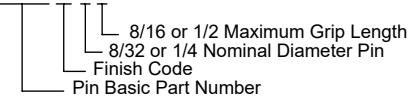
- FINISH:**
- ⑤ HST844-()-() = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑦ HST844AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST844DU()-() = Solid film lube per AS5272, Type I.
 - HST844TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST844TP()-() = 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.
 - HST844HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
 - ⑤ HST844NAP()-() = 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 of the pin which HST844 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER

EXAMPLE: Pin Part Number
 HST844AP8-8



HST844

DRAWING NUMBER

HST844

2 OF 2