



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

[7] [1]																	
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	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							NOTE: USE HST745(6-)										
6	7/32	.3308 .3253	.300	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0472 .0449	.030 .020	.015	1/32 x 45°	.1900-32 UNJF-3A	.0806 .0791	.100 .080	.119 .104	9,400	2,600
8	9/32	.4265 .4210	.330	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0612 .0589	.030 .020	.015	1/32 x 45°	.2500-28 UNJF-3A	.0967 .0947	.110 .090	.142 .122	15,500	4,400
10	11/32	.5056 .5001	.390	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0681 .0658	.040 .030	.015	3/64 x 45°	.3125-24 UNJF-3A	.1295 .1270	.130 .110	.180 .160	23,200	7,000
12	13/32	.5921 .5866	.430	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0782 .0759	.040 .030	.015	3/64 x 45°	.3750-24 UNJF-3A	.1617 .1582	.160 .140	.217 .197	32,400	10,000
14	15/32	.6997 .6932	.495	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0971 .0944	.050 .040	.022	3/64 x 45°	.4375-20 UNJF-3A	.1930 .1895	.190 .170	.253 .233	43,100	13,500
16	17/32	.7857 .7792	.535	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1070 .1043	.050 .040	.022	3/64 x 45°	.5000-20 UNJF-3A	.2242 .2207	.220 .200	.289 .269	55,400	18,000
18	19/32	.8692 .8622	.610	.5927 .5922	.5927 .5917	.5550 .5500	.010	.1160 .1130	.050 .040	.022	1/16 x 45°	.5625-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	69,200	22,500
20	21/32	.9562 .9492	.670	.6552 .6547	.6552 .6542	.6180 .6120	.010	.1260 .1230	.050 .040	.022	1/16 x 45°	.6250-18 UNJF-3A	.2555 .2520	.260 .240	.326 .306	84,500	27,000
24	25/32	1.1282 1.1162	.905	.7802 .7797	.7802 .7792	.7430 .7370	.012	.1460 .1410	.050 .040	.022	1/16 x 45°	.7500-16 UNJF-3A	.3185 .3150	.330 .300	.398 .378	120,000	37,300

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.OBISPO	DATE 1988-01-20	TITLE HI-LITE™ PIN 100° FLUSH 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 HST845

- 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. Oversize pin for HST645 and HST745.
 - ⑤ 10 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 AMS5629.

HEAT TREAT: 125,000 psi shear minimum.

- FINISH:**
- HST845(-)(-) = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - 10 HST845AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST845TB(-)(-) = HI-KOTE™ 2 solid film lube per per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST845DU(-)(-) = Solid film lube per AS5272, Type I.
 - HST845TP(-)(-) = 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.
 - HST845HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.
 - ⑤ HST845NAP(-)(-) = 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 HST845 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
HST845AP8-8

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

HST845

DRAWING NUMBER

HST845

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