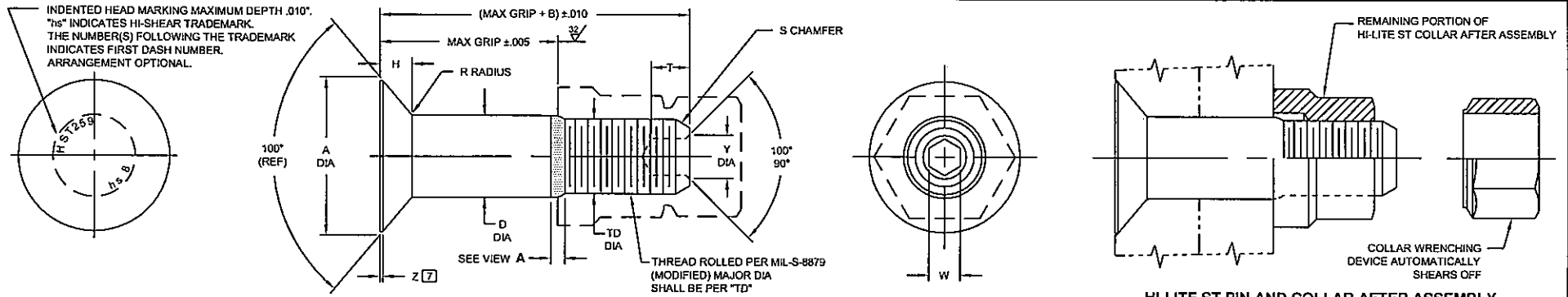


| | |
|--|--|
| 3 HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE Code: 73197 | LISI AEROSPACE FRANCE (Licensee) CAGE Code: F0168 |
| a Lisi Aerospace Company | a Lisi Aerospace Company |
| AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE Code: 06725 | BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE Code: U6300 |
| SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE Code: 56878 | FT BESTAS, France (Licensee) CAGE Code: T0802 |
| MINEBEA CO., LTD. Japan (Licensee-Japan) CAGE Code: S8962 | a Lisi Aerospace Company |
| | LISI AEROSPACE CANADA (Licensee) CAGE Code: L4528 |
| | a Lisi Aerospace Company |



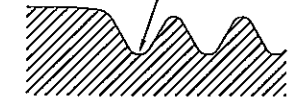
HI-LITE ST PIN

| FIRST DASH NO. | PIN NOM DIA | A DIA | B REF | D DIA | | TD DIA | F REF | H | R RAD | Z MAX | S CHAMFER REF | THREAD | SOCKET | | | DOUBLE SHEAR POUNDS MINIMUM | TENSION POUNDS MINIMUM |
|----------------|-------------|------------------|-------|-------------------------------|----------------------------|----------------|-------|----------------|--------------|-------|---------------|----------------------------|----------------|--------------|--------------|-----------------------------|------------------------|
| | | | | WITHOUT COATING OR SOLID FILM | WITH COATING OR SOLID FILM | | | | | | | | W HEX | T DEPTH | Y DIA | | |
| 5 | | | | NOTE: USE HST59()6-() | | | | | | | | | | | | | |
| 6 | 7/32 | .3813 .3765 | .300 | .2182 .2177 | .2182 .2172 | .1840 .1810 | .005 | .0684 .0664 | .030 .020 | .015 | 1/32" x 45° | 10-32UNJF-3A Modified | .0806 .0791 | .100 .080 | .119 .104 | 9,400 | 4,350 |
| 8 | 9/32 | .5066 .5018 | .330 | .2807 .2802 | .2807 .2797 | .2440 .2410 | .006 | .0948 .0928 | .030 .020 | .015 | 1/32" x 45° | 1/4-28UNJF-3A Modified | .0967 .0947 | .110 .090 | .142 .122 | 15,500 | 7,750 |
| 10 | 11/32 | .6335 .6287 | .390 | .3432 .3427 | .3432 .3422 | .3060 .3020 | .007 | .1218 .1198 | .040 .030 | .015 | 3/64" x 45° | 5/16-24UNJF-3A Modified | .1295 .1270 | .130 .110 | .180 .160 | 23,200 | 12,300 |
| 12 | 13/32 | .7604 .7556 | .430 | .4057 .4052 | .4057 .4047 | .3680 .3640 | .008 | .1488 .1468 | .040 .030 | .015 | 3/64" x 45° | 3/8-24UNJF-3A Modified | .1617 .1582 | .160 .140 | .217 .197 | 32,400 | 19,100 |
| 14 | 15/32 | .8884 .8812 | .510 | .4682 .4677 | .4682 .4672 | .4310 .4260 | .009 | .1763 .1733 | .050 .040 | .022 | 3/64" x 45° | 7/16-20UNJF-3A Modified | .1930 .1895 | .190 .170 | .253 .233 | 43,100 | 25,800 |
| 16 | 17/32 | 1.0139 1.0068 | .610 | .5307 .5302 | .5307 .5297 | .4930 .4880 | .010 | .2027 .1997 | .050 .040 | .022 | 3/64" x 45° | 1/2-20UNJF-3A Modified | .2242 .2207 | .220 .200 | .289 .269 | 55,400 | 34,300 |

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS



VIEW A

HI-LITE THREAD TRANSITION AREA
SEE SPECIFICATION FOR INSPECTION

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Broach petals removed.
 - Oversize replacement for HST59 and HST159.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST259 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 Only
HST259-8-8
└── 8/16 or 1/2 Maximum Grip Length
└── Replaces 8/32 or 1/4 Nominal Diameter Pin
Pin Part Number

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

- FINISH:**
- HST259-()-() = Passivate per Hi-Shear 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST259AC()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 with color code green on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST259AG()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 with color code orange on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST259AP()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST259DU()-() = Solid film lube per AS5272, Type I.
 - HST259MA()-() = Solid film lube per Kalgard RA.
 - HST259TB()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST259TP()-() = 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.

SPECIFICATION: Hi-Lite Product Specification 380.

| | | |
|---|----------------------------------|--|
| U.S. Patents 4,326,825; 4,485,510 and 4,957,401. Other U.S. and international patents pending. "Hi-Lite" and "HST" are registered trademarks and "Hi-Lite ST" is a trademark of Hi-Shear Corporation. | | |
| DRAWN J.F.Obispo | DATE 3-31-97 | TITLE HI-LITE® ST™ PIN |
| APPROVED MC | DATE 4-1-97 | 100° FLUSH MS24694 TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION, 1/32" OVERSIZE |
| REVISION 3 | DATE L.G.Valencia 03-18-08 | DRAWING NUMBER HST259 |