



HI-LITE ST™ PIN

HI-LITE ST™ PIN AND COLLAR AFTER ASSEMBLY

INDENTED HEAD MARKING MAXIMUM DEPTH .010"
"hs" indicates HI-SHEAR trademark.
The number(s) following the "hs" indicate first dash number. Arrangement optional.

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH IPIN OR COLLAR! DETERMINES SYSTEM STRENGTH.

FIRST DASH NO.	NOM. DIA.	A DIA.	A ₁ DIA. MIN.	B REF.	D DIA.		TD DIA.	F	H REF.	M GAGE PROT.	R RAD.	V GAGE DIA.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
					WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE										W HEX.	T DEPTH	T ₁ DEPTH	Y DIA.		
-5	5/32	.2827	.2617	.280	.1635	.1635	.1595	.004	.049	.0330	.025	.2028	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801	.100	.145	.119	4,010	1,500
-6	3/16	.3277	.2963	.290	.1895	.1895	.1840	.005	.056	.0295	.030	.2560	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806	.100	.145	.119	5,380	2,400
-8	1/4	.4283	.3969	.320	.2495	.2495	.2440	.006	.074	.0227	.030	.3732	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967	.110	.160	.142	9,300	4,500
-10	5/16	.5361	.5047	.380	.3120	.3120	.3060	.007	.092	.0284	.040	.4791	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295	.130	.195	.180	14,600	6,850
-12	3/8	.6415	.6101	.420	.3745	.3745	.3680	.008	.110	.0295	.040	.5698	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617	.160	.240	.217	21,000	10,200
-14	7/16	.7425	.6941	.485	.4370	.4370	.4310	.009	.126	.0347	.050	.6582	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930	.190	.280	.253	28,600	13,100
-16	1/2	.8423	.7939	.525	.4995	.4995	.4930	.010	.142	.0504	.050	.7200	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242	.220	.320	.289	37,300	18,000
-18	9/16	.9300	.8816	.600	.5615	.5615	.5550	.010	.153	.0464	.040	.7198	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555	.260	.365	.326	47,200	22,500
-20	5/8	1.0440	.9956	.640	.6240	.6240	.6180	.010	.174	.0633	.050	.8902	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.2555	.260	.365	.326	58,300	29,200

- GENERAL NOTES:
- Head edge out of roundness shall not exceed "F."
 - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions in inches and to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Evidence of broken edge across points.
 - Use HST857 for oversize replacement.

CODE: First dash number indicates nominal diameter in 1/32nds.
Second dash number indicates maximum grip in 1/16ths.

HOW TO ORDER

EXAMPLES:

Pin Part Number Only
HST757-8-8
 —8/16 or 1/2 Maximum Grip Length
 —8/32 or 1/4 Nominal Diameter Pin
 —Pin Part Number

Pin and Collar Assembly Part Number Combination

HST75770-8-8
 —Size and Grip Length, See Above Example
 —Collar Part Number
 —Pin Part Number

MATERIAL: A-286 high temperature alloy per Spec. AMS5731 or AMS5737.

HEAT TREAT: 95,000 psi shear minimum at 70°F.

FINISH: HST757-()-() = Passivate per Hi-Shear Spec. 258 with color black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST757DU-()-() = Solid film lube per MIL-L-8937.

SPECIFICATION: Hi-Lite Product Specification 380.

U.S. Patent 4,326,825. Other U.S. and foreign patents pending. "Hi-Lite" and "Hi-Lite ST" are trademarks of Hi-Shear Corporation.

DRAWN D. P. S.	DATE 11-17-83	TITLE HI-LITE ST™ PIN 100° FLUSH SPECIAL SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION
APPROVED E.E.B.	DATE 11-18-83	
REVISION ①	DATE D. P. S. 1-9-84	DRAWING NUMBER HST757