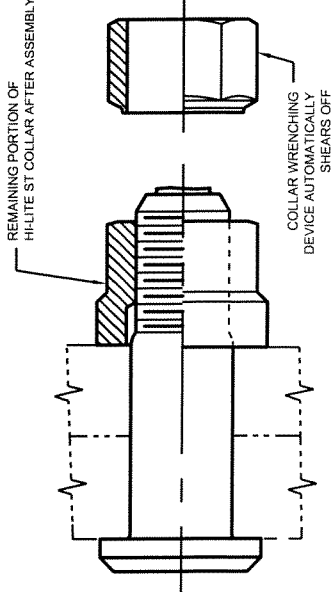
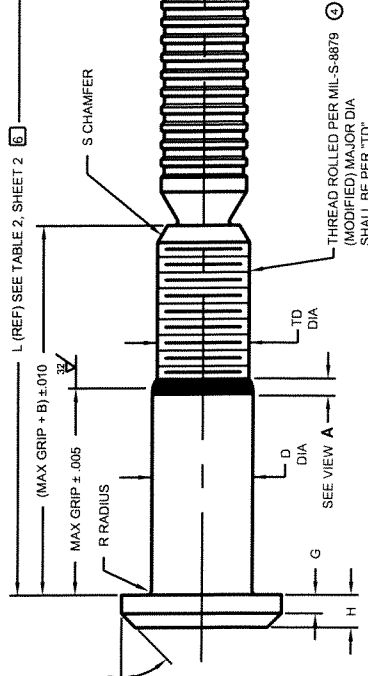
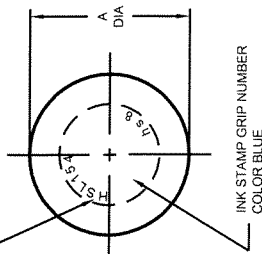


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"HS" INDICATES HI-SHEAR TRADEMARK.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER, ARRANGEMENT
OPTIONAL.



HI-LITE® ST™ PIN

TABLE 1

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF DIA	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
6	13/64	.377 .357	.2026 .2016	.300	.1840 .1810	.035 .064	.074 .064	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	8,100	4,350
8	17/64	.440 .415	.2651 .2641	.330	.2440 .2410	.045 .080	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	13,800	7,750
10	21/64	.505 .475	.3276 .3266	.390	.3060 .3020	.055 .102	.112 .102	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	21,100	12,300
12	25/64	.600 .565	.3901 .3891	.430	.3680 .3640	.075 .130	.140 .130	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	30,000	19,100
14	29/64	.676 .641	.4526 .4516	.510	.4310 .4260	.095 .150	.160 .150	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	40,300	25,800
16	33/64	.770 .735	.5151 .5141	.610	.4930 .4880	.095 .178	.188 .178	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	52,500	34,300

HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

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

GENERAL NOTES:

- Concentricity: "A" to "D", diameter within .010 FILM.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Lead radius must be tangent to "D", diameter at maximum grip.
- Shorter or longer grips than those listed may be available as specials.
- Use HSL254 for oversize replacement.
- Paint or dye pin tail flat end with color: orange for -12 size, green for -14 size, and blue for -16 size. Paint overspray is permissible.

MATERIAL: Nickel base alloy per AMS5662.

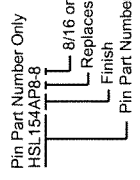
HEAT TREAT: 125,000 psi shear minimum.

FINISH: HSL154AP() () = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HSL154AG() () = 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.
HSL154DL() () = Kalgard FA or EM620C solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 380-2.

First dash number indicates nominal diameter in 1/32nds of the pin which HSL 154 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLE:



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	DATE	TITLE
J.F. Obispo	4-17-96	HI-LITE® ST™ PIN
APPROVED	DATE	
J. Rausch	4-22-96	PROTRUDING TENSION HEAD BREAK STEM, INTERFERENCE FIT NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION, 1/64" OVERSIZE
REVISION	DATE	DRAWING NUMBER
4	JFO 8-20-01	HSL154

TABLE 2

SECOND DASH NUMBER	L REF 6					
	-6 DIA.	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.
1	-	-	-	-	-	-
2	1.000	1.000	-	-	-	-
3	1.125	1.125	1.250	-	-	-
4	1.250	1.250	1.375	1.375	-	-
5	1.375	1.375	1.500	1.500	1.625	-
6	1.500	1.500	1.625	1.625	1.750	1.750
7	1.625	1.625	1.750	1.750	1.875	1.875
8	1.750	1.750	1.875	1.875	2.000	2.000
9	1.875	1.875	2.000	2.000	2.125	2.125
10	2.000	2.000	2.125	2.125	2.250	2.250
11	2.125	2.125	2.250	2.250	2.375	2.375
12	2.250	2.250	2.375	2.375	2.500	2.500
13	2.375	2.375	2.500	2.500	2.625	2.625
14	2.500	2.500	2.625	2.625	2.750	2.750
15	2.625	2.625	2.750	2.750	2.875	2.875
16	2.750	2.750	2.875	2.875	3.000	3.000
17	2.875	2.875	3.000	3.000	3.125	3.125
18	3.000	3.000	3.125	3.125	3.250	3.250
19	3.125	3.125	3.250	3.250	3.375	3.375
20	3.250	3.250	3.375	3.375	3.500	3.500
21	3.375	3.375	3.500	3.500	3.625	3.625
22	3.500	3.500	3.625	3.625	3.750	3.750
23	3.625	3.625	3.750	3.750	3.875	3.875
24	3.750	3.750	3.875	3.875	4.000	4.000
25	-	-	4.000	4.000	4.125	4.125
26	-	-	4.125	4.125	4.250	4.250
27	-	-	4.250	4.250	4.375	4.375
28	-	-	4.375	4.375	4.500	4.500
29	-	-	-	4.500	4.625	4.625
30	-	-	-	4.625	4.750	4.750
31	-	-	-	4.750	4.875	4.875
32	-	-	-	4.875	5.000	5.000
33	-	-	-	5.000	5.125	5.125
34	-	-	-	5.125	5.250	5.250
35	-	-	-	5.250	5.375	5.375
36	-	-	-	5.375	5.500	5.500
37	-	-	-	5.500	5.625	5.625
38	-	-	-	5.625	5.750	5.750
39	-	-	-	5.750	5.875	5.875
40	-	-	-	5.875	6.000	6.000
41	-	-	-	6.000	6.125	6.125
42	-	-	-	6.125	6.250	6.250
43	-	-	-	6.250	6.375	6.375
44	-	-	-	6.375	6.500	6.500