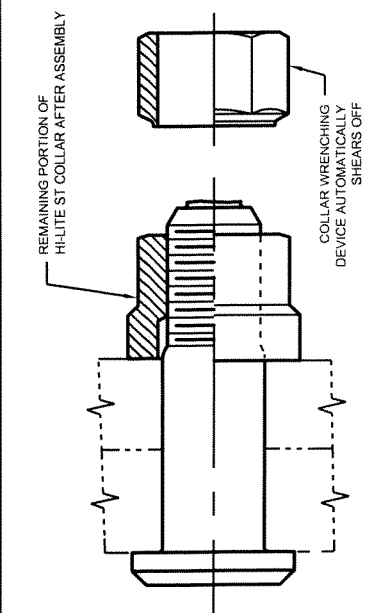
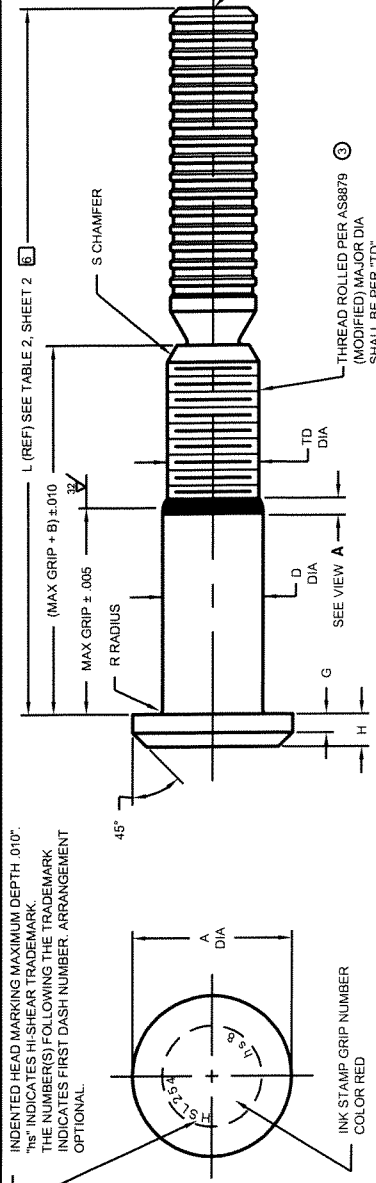


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"HS" INDICATES HI-SHEAR TRADEMARK.
THE NUMBERS FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER. ARRANGEMENT
OPTIONAL.



HI-LITE® ST™ PIN

TABLE 1

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
6	7/32	.390 .370	.300	.2182 .2172	.1840 .1810	.035 .064	.074 .064	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	9,400	4,350
8	9/32	.460 .435	.330	.2807 .2797	.2440 .2410	.045 .080	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	15,500	7,750
10	11/32	.520 .490	.390	.3432 .3422	.3060 .3020	.065 .102	.112 .102	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	23,200	12,300
12	13/32	.620 .585	.430	.4057 .4047	.3680 .3640	.075 .130	.140 .130	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	32,400	19,100
14	15/32	.695 .790	.510	.4682 .4672	.4310 .4260	.095 .150	.160 .150	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	43,100	25,800
16	17/32	.755 .755	.610	.5307 .5297	.4930 .4880	.095 .178	.188 .178	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	55,400	34,300

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

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 F.I.M.
- 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.
- Over-size pin for HSL54 and HSL154.
- Paint or dye pin tail 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: HSL254AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HSL254AG(-)(-) = 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.
HSL254DL(-)(-) = 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.

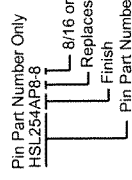
VIEW A

HI-LITE THREAD TRANSITION AREA
SEE SPECIFICATION FOR INSPECTION



First dash number indicates nominal diameter in 1/32nds of the pin which HSL254 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLE:



REVISION

DATE	APPROVED	DATE	REVISION
4-17-96	J.F. Obispo	4-22-96	3
			J-F O
			8-20-01

TITLE
HI-LITE® ST™ PIN
PROTRUDING TENSION HEAD
BREAK STEM, INTERFERENCE FIT
NICKEL BASE ALLOY (INCONEL 718)
1/16" GRIP VARIATION, 1/32" OVERSIZE

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.

U.S. Patents 4,326,825; 4,485,510 and 4,957,401.
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TABLE 2

SECOND DASH NUMBER	L REF [B]					
	-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