

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

| FIRST DASH NO. | NOM. DIA. | A DIA. | B REF. | D DIA. | | TD DIA. | F | H | R RAD. | Z MAX. | S CHAMFER REF. | THREAD | SOCKET | | | ** DOUBLE SHEAR POUNDS MINIMUM | TENSION POUNDS MINIMUM |
|----------------|-----------|----------------|--------|------------------------------------|----------------------------------|----------------|------|----------------|--------------|--------|----------------|----------------------------|----------------|--------------|--------------|--------------------------------|------------------------|
| | | | | WITHOUT COATING OR SOLID FILM LUBE | AFTER COATING OR SOLID FILM LUBE | | | | | | | | W HEX. | T DEPTH | Y DIA. | | |
| | | | | NOTE: USE HST41-6-() | | | | | | | | | | | | | |
| 5 | 3/16 | | | | | | | | | | | | | | | | |
| 6 | 13/64 | .3016 .2966 | .300 | .2026 .2021 | .2026 .2016 | .1840 .1810 | .005 | .0415 .0394 | .030 .020 | .015 | 1/32" x 37° | 10-32UNJF-3A Modified | .0806 .0791 | .100 .080 | .119 .104 | 6,130 | 2,000 |
| 8 | 17/64 | .3948 .3898 | .330 | .2651 .2646 | .2651 .2641 | .2440 .2410 | .006 | .0544 .0523 | .030 .020 | .015 | 1/32" x 37° | 1/4-28UNJF-3A Modified | .0967 .0947 | .110 .090 | .142 .122 | 10,490 | 3,700 |
| 10 | 21/64 | .4739 .4689 | .390 | .3276 .3271 | .3276 .3266 | .3060 .3020 | .007 | .0614 .0593 | .040 .030 | .015 | 3/64" x 37° | 5/16-24UNJF-3A Modified | .1295 .1270 | .130 .110 | .180 .160 | 16,000 | 5,000 |
| 12 | 25/64 | .5604 .5554 | .430 | .3901 .3896 | .3901 .3891 | .3680 .3640 | .008 | .0714 .0693 | .040 .030 | .015 | 3/64" x 37° | 3/8-24UNJF-3A Modified | .1617 .1582 | .160 .140 | .217 .197 | 22,700 | 7,200 |
| 14 | 29/64 | .6680 .6620 | .495 | .4526 .4521 | .4526 .4516 | .4310 .4260 | .009 | .0904 .0879 | .050 .040 | .022 | 3/64" x 37° | 7/16-20UNJF-3A Modified | .1930 .1895 | .190 .170 | .253 .233 | 30,600 | 10,000 |
| 16 | 33/64 | .7540 .7480 | .535 | .5151 .5146 | .5151 .5141 | .4930 .4880 | .010 | .1002 .0977 | .050 .040 | .022 | 3/64" x 37° | 1/2-20UNJF-3A Modified | .2242 .2207 | .220 .200 | .289 .269 | 39,600 | 13,500 |

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:

- 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.
- Oversize replacement for HST41 and HST141 pins.
- Non-lubed pins must be used with lubed collars.
- Curved or flat edge manufacturer's option.

MATERIAL:

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

HEAT TREAT:

95,000 psi shear minimum.

FINISH:

- HST141-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HST141DU()-() = Solid film lube per AS2272, Type I.
 HST141GU()-() = Silver plate per AMS2410.
 HST141PY()-() = Passivate per Hi-Shear Spec. 258.
 HST141TF()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
 HST141V()-() = Solid film lube per "Lubeco" 2123, Type II.
 HST141YV()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 on threads only with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

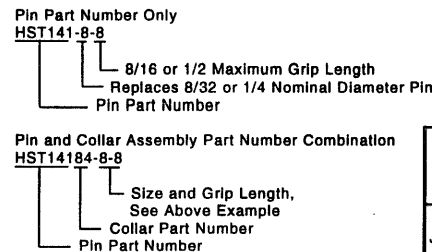
SPECIFICATION:

Hi-Lite Product Specification 380.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HST141 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLES:



** The Double Shear Values shown are based on cross section area for nominal pin diameter.

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| 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 J.Henderson 1-21-98 | TITLE HI-LITE[®]ST[™] PIN 100° FLUSH SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION, 1/64" OVERSIZE |
| APPROVED DATE <i>nc</i> 2-2-98 | DRAWING NUMBER HST141 |
| REVISION DATE | |