

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 SHEARS POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX.	T DEPTH	Y DIA.		
5	5/32	.2922 .2874	.280	.1635 .1625	.1595 .1570	.004	.0540 .0520	.025 .015	.010	1/32" x 45°	8-32UNJC-3A Modified	.0645 .0635	.090 .070	.090 .075	1,760	860
6	3/16	.3536 .3486	.290	.1895 .1885	.1840 .1810	.005	.0688 .0667	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	2,540	1,150
8	1/4	.4732 .4682	.320	.2495 .2485	.2440 .2410	.006	.0939 .0918	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	4,500	2,000
10	5/16	.5619 .5569	.380	.3120 .3110	.3060 .3020	.007	.1048 .1027	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	7,050	2,800
12	3/8	.6912 .6862	.420	.3745 .3735	.3680 .3640	.008	.1329 .1308	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	10,100	3,900
14	7/16	.8041 .7969	.485	.4370 .4360	.4310 .4260	.009	.1540 .1510	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	13,800	6,000
16	1/2	.9166 .9095	.525	.4995 .4985	.4930 .4880	.010	.1750 .1720	.050 .040	.022	3/64" X 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	18,000	7,600

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:

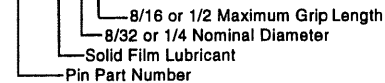
1. Head edge out of roundness shall not exceed "F."
2. Concentricity: Conical surface of head to "D" diameter within .005 FINI.
3. "H" dimensioned from maximum "D" diameter.
4. Dimensions to be met after finish.
5. Surface texture per ANSI B46. 1.
6. Hole preparation per NAS618.
7. Curved or flat edge manufacturer's option.
8. Use HST123 for oversize replacement.

CODE:

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

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HST23DU8-8



Pin and Collar Assembly Part Number Combination
HST23DU778-8



MATERIAL:

7075 aluminum alloy per QQ-A-225/9 or QQ-A-430.

HEAT TREAT:

Age to T6 condition per MIL-H-6088.

FINISH:

- HST23(-)(-) = Anodize per MIL-A-8625, dye color natural, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST23DU(-)(-) = Anodize per MIL-A-8625, and solid film lube per MIL-L-46010, Type I.
- HST23EY(-)(-) = Anodize per MIL-A-8625, dye color yellow, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST23TT(-)(-) = Anodize per MIL-A-8625, dye color natural, and translube.

SPECIFICATION:

Hi-Lite Product Specification 380.

U.S. Patents 4,326,825; 4,485,510 and 4,957,401. Other U.S. and foreign patents pending. "Hi-Lite" is a registered trademark and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.	
DRAWN DATE S.Graphics 9-29-83	TITLE HI-LITE® ST PIN 100° FLUSH MS20426 SHEAR HEAD ALUMINUM ALLOY 1/16" GRIP VARIATION
APPROVED DATE E.E.B. 10-4-83	DRAWING NUMBER HST23
REVISION DATE ⑦ J. R. H. 2-27-97	