



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

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA. [8]		TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	W HEX.	T DEPTH	Y DIA.	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE												
-5	5/32	.3304	.280	.1635	.1635	.1595	.004	.0700	.025	.012	1/32" x 45°	8-32UNJC-3A Modified	.0801	.100	[9]	4,010	2,180
		.3256		.1630	.1625	.1570											
-6	3/16	.3813	.290	.1895	.1895	.1840	.005	.0805	.030	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806	.100	.119	5,380	3,180
		.3765		.1890	.1885	.1810											
-8	1/4	.5066	.320	.2495	.2495	.2440	.006	.1079	.030	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967	.110	.142	9,300	5,820
		.5018		.2490	.2485	.2410											
-10	5/16	.6335	.380	.3120	.3120	.3060	.007	.1349	.040	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295	.130	.180	14,600	9,200
		.6287		.3115	.3110	.3020											
-12	3/8	.7604	.420	.3745	.3745	.3680	.008	.1619	.040	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617	.160	.217	21,000	14,000
		.7556		.3740	.3735	.3640											
-14	7/16	.8884	.485	.4370	.4370	.4310	.009	.1894	.050	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930	.190	.253	28,600	18,900
		.8812		.4365	.4360	.4260											
-16	1/2	1.0139	.525	.4995	.4995	.4930	.010	.2158	.050	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242	.220	.289	37,300	25,600
		1.0068		.4990	.4985	.4880											

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 FIR.
  - "H" dimensioned from maximum "D" diameter.
  - Dimensions to be met after finish.
  - Non-lubed pins must be used with lubed collars.
  - Surface texture per ANSI B46.1.
  - Hole preparation per NAS618.
  - Maximum "D" diameter may be increased by .0002 to allow for solid film or plating application.
  - Evidence of broken edge across points.
  - Curved or flat edge manufacturer's option.

MATERIAL: A-286 high temperature alloy per Spec. AMS5737 or AMS5731.  
HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum) at 70°F.  
FINISH: HST49-( ) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.  
HST49CT-( ) = Passivate per Hi-Shear Spec. 258, with color orange on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.  
HST49DU-( ) = Solid film lube per MIL-L-8937.  
HST49GU-( ) = Silver plate per AMS2410.  
HST49PY-( ) = Passivate per Hi-Shear Spec. 258.  
HST49TF-( ) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.  
HST49V-( ) = Solid film lubricant per "Lubeco" 2125, Type II.  
SPECIFICATION: Hi-Lite Product Specification 380.

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  
HST49-8-8  
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  
HST49V1078-8-8  
Size and Grip Length, See Above Example  
Collar Part Number  
Pin Finish  
Pin Part Number

U.S. Patents 4,326,825 and 4,495,510. 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 D. P. S. 3-18-83	DATE 3-18-83
APPROVED [Signature]	DATE 3-18-83
REVISION [2]	DATE D. P. S. 10-23-86
TITLE <b>HI-LITE ST™ PIN</b> 100° FLUSH MS24694 TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION DRAWING NUMBER <b>HST49</b>	

HST49