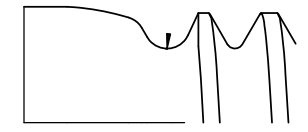


SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

| FIRST DASH NO.       | PIN NOM DIA | A DIA        | B REF | D DIA                         |                            | TD DIA         | G REF | H            | R RAD        | S CHAMFER REF | THREAD MODIFIED     | SOCKET         |              |              | DOUBLE SHEAR POUNDS MINIMUM | TENSION POUNDS MINIMUM |
|----------------------|-------------|--------------|-------|-------------------------------|----------------------------|----------------|-------|--------------|--------------|---------------|---------------------|----------------|--------------|--------------|-----------------------------|------------------------|
|                      |             |              |       | WITHOUT COATING OR SOLID FILM | WITH COATING OR SOLID FILM |                |       |              |              |               |                     | W HEX          | T DEPTH      | Y DIA        |                             |                        |
| NOTE: USE HST54-6(-) |             |              |       |                               |                            |                |       |              |              |               |                     |                |              |              |                             |                        |
| 6                    | 13/64       | .377<br>.357 | .300  | .2026<br>.2021                | .2026<br>.2016             | .1840<br>.1810 | .035  | .074<br>.064 | .025<br>.015 | 1/32 x 45°    | .1900-32<br>UNJF-3A | .0806<br>.0791 | .100<br>.080 | .119<br>.104 | 8,100                       | 4,350                  |
| 8                    | 17/64       | .440<br>.415 | .330  | .2651<br>.2646                | .2651<br>.2641             | .2440<br>.2410 | .045  | .090<br>.080 | .025<br>.015 | 1/32 x 45°    | .2500-28<br>UNJF-3A | .0967<br>.0947 | .110<br>.090 | .142<br>.122 | 13,800                      | 7,750                  |
| 10                   | 21/64       | .505<br>.475 | .390  | .3276<br>.3271                | .3276<br>.3266             | .3060<br>.3020 | .055  | .112<br>.102 | .030<br>.020 | 3/64 x 45°    | .3125-24<br>UNJF-3A | .1295<br>.1270 | .130<br>.110 | .180<br>.160 | 21,100                      | 12,300                 |
| 12                   | 25/64       | .600<br>.565 | .430  | .3901<br>.3896                | .3901<br>.3891             | .3680<br>.3640 | .075  | .140<br>.130 | .030<br>.020 | 3/64 x 45°    | .3750-24<br>UNJF-3A | .1617<br>.1582 | .160<br>.140 | .217<br>.197 | 30,000                      | 19,100                 |
| 14                   | 29/64       | .676<br>.641 | .510  | .4526<br>.4521                | .4526<br>.4516             | .4310<br>.4260 | .095  | .160<br>.150 | .030<br>.020 | 3/64 x 45°    | .4375-20<br>UNJF-3A | .1930<br>.1895 | .190<br>.170 | .253<br>.233 | 40,300                      | 25,800                 |
| 16                   | 33/64       | .770<br>.735 | .610  | .5151<br>.5146                | .5151<br>.5141             | .4930<br>.4880 | .095  | .188<br>.178 | .030<br>.020 | 3/64 x 45°    | .5000-20<br>UNJF-3A | .2242<br>.2207 | .220<br>.200 | .289<br>.269 | 52,500                      | 34,300                 |
| 18                   | 37/64       | .877<br>.842 | .710  | .5771<br>.5766                | .5771<br>.5761             | .5550<br>.5500 | .125  | .210<br>.200 | .040<br>.025 | 1/16 x 45°    | .5625-18<br>UNJF-3A | .2555<br>.2520 | .260<br>.240 | .326<br>.306 | 65,600                      | 43,500                 |

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS



VIEW A  
 HI-LITE™ THREAD TRANSITION AREA  
 SEE SPECIFICATION FOR INSPECTION

"HI-LITE", "HST", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION

|                        |                               |   |
|------------------------|-------------------------------|---|
| DRAWN BY<br>J.F.OBISPO | DATE<br>1995-03-23            | TITLE<br>HI-LITE™ PIN<br>PROTRUDING TENSION HEAD<br>NICKEL BASE ALLOY (INCONEL 718)<br>1/16 GRIP VARIATION, 1/64 OVERSIZE |
| APPROVED<br>E.E.B.     | DATE<br>1995-03-23            |   |
| REVISION<br>11         | DATE<br>M.BEARD<br>2017-04-19 | DRAWING NUMBER<br><b>HST154</b>   |

1 OF 2

HST154



- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
  - ⑪ 2. Dimensions are in inches and to be met after finish.
  - ⑪ 3. Surface texture per ASME B46.1.
  4. Hole preparation per NAS618.
  5. Use HST254 for oversize replacement.
  - ⑥ After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

**MATERIAL:** Nickel base alloy per AMS5662.

**HEAT TREAT:** 125,000 psi shear minimum (210,000 psi tensile minimum).

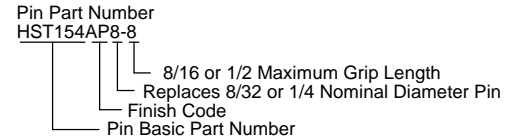
- FINISH:**
- HST154(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
  - ⑥ HST154AC(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 with color code green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - ⑥ HST154AG(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - ⑥ HST154AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - ⑥ HST154AZ(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST154CT(-)(-) = Color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST154CZ(-)(-) = Color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - ⑥ HST154GD(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST154RP(-)(-) = Phosphate fluoride treat with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST154RS(-)(-) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color code orange thread end.
  - HST154RV(-)(-) = Phosphate fluoride treat, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST154TB(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST154NKJ(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST154NKL(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
  - ⑪ HST154HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

**SPECIFICATION:** HI-LITE™ Product Specification 380.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HST154 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER**

⑪ **EXAMPLE:**



HST154

DRAWING NUMBER

**HST154**

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