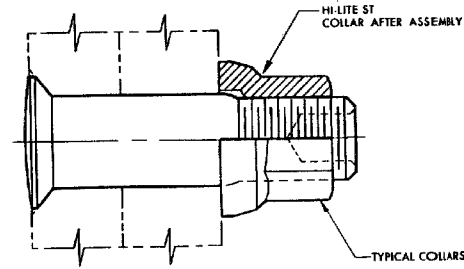
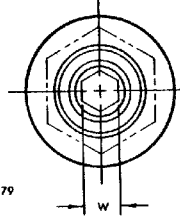
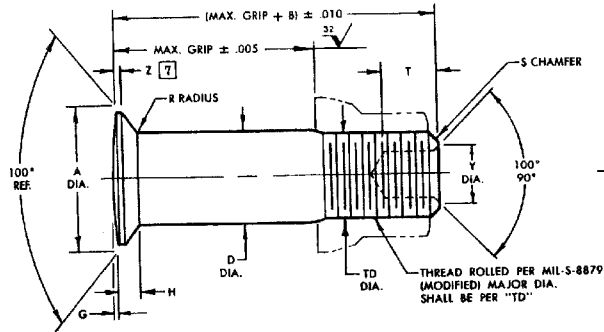


INDENTED HEAD MARKING MAXIMUM DEPTH .010"
"hs" indicates HI-SHEAR trademark.
The number(s) following the "hs" indicate first dash number. Arrangement optional.



HI-LITE ST™ PIN

HI-LITE ST™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	G	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
													W HEX.	T DEPTH	Y DIA.		
-4	1/8	.2219	.260	.1376	.1335	.003	.006	.0364	.020	.010	1/32" x 45°	6-32UNJC-3A Modified	.0645	.090	.090	3,230	1,290
		.2171		.1365	.1310		.0635	.070					.075				
-5	5/32	.2612	.280	.1636	.1595	.004	.008	.0410	.025	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801	.100	.109	4,560	1,750
		.2564		.1625	.1570		.0791	.080					.084				
-6	3/16	.3016	.290	.1895	.1840	.005	.006	.0470	.030	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806	.100	.119	6,100	2,340
		.2966		.1885	.1810		.0791	.080					.104				
-8	1/4	.3948	.320	.2495	.2440	.006	.008	.0610	.030	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967	.110	.142	10,600	4,200
		.3898		.2485	.2410		.0947	.090					.122				
-10	5/16	.4739	.380	.3120	.3060	.007	.006	.0679	.040	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295	.130	.180	16,600	6,500
		.4689		.3110	.3020		.1270	.110					.160				
-12	3/8	.5604	.420	.3745	.3680	.008	.006	.0780	.040	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617	.160	.217	23,900	9,230
		.5554		.3735	.3640		.1582	.140					.197				

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

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 plating.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Curved or flat edge manufacturer's option.

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626, or MIL-S-6049.

HEAT TREAT: 108,000 psi shear minimum (180,000-200,000 psi tensile per Spec. MIL-H-6875).

FINISH: HST135-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, 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.
Second dash number indicates maximum grip in 1/16ths.

HOW TO ORDER
EXAMPLES:

Pin Part Number Only
HST135-8-8
 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
HST1351081-8-8
 Size and Grip Length,
 See Above Example
 Collar Part Number
 Pin Part Number

U. S. Patent 4,326,825. Other U. S. and foreign patents pending. "Hi-Lite" and "Hi-Lite ST" are trademarks of Hi-Shear Corporation.	
DRAWN DATE D. P. S. 6-17-83	TITLE HI-LITE ST™ PIN
APPROVED DATE <i>E. E. Beckler 6-17-83</i>	100° FLUSH CROWN HEAD ALLOY STEEL 1/16" GRIP VARIATION
REVISION DATE	DRAWING NUMBER HST135