

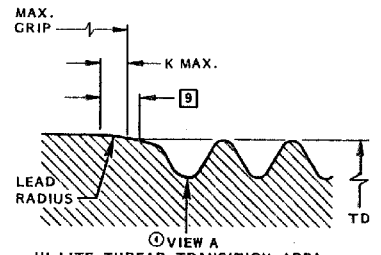
FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	HEAD					S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
						F	H	K MAX.	R RAD.	Z MAX.			W HEX.	T DEPTH	Y DIA.		
-5	5/32	.3393 .3308	.312	.1640 .1635	.1595 .1570	.004	.0410 .0390	.013	.025 .015	.012	1/32" x 37°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	.090 .074	4,010	1,650
-6	3/16	.3911 .3825	.325	.1895 .1890	.1840 .1810	.005	.0470 .0450	.016	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,380	2,000
-8	1/4	.5111 .5026	.395	.2495 .2490	.2440 .2410	.006	.0610 .0590	.021	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0907 .0947	.110 .090	.142 .122	9,300	3,700
-10	5/16	.6377 .5951	.500	.3120 .3115	.3060 .3020	.007	.0680 .0660	.026	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	.1285 .1270	.130 .110	.180 .160	14,600	5,000
-12	3/8	.7090 .7005	.645	.3745 .3740	.3680 .3640	.008	.0780 .0760	.030	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	21,000	7,200

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

- ① GENERAL NOTES:
- Head edge out of roundness shall not exceed "P".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Use HST631 for oversize replacement.
 - Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.

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
EXAMPLE: Pin Part Number Only
HST531-8-8
8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Pin Part Number



HI-LITE THREAD TRANSITION AREA. THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS. SEE SPECIFICATION FOR INSPECTION.

MATERIAL: 6Al-4V titanium alloy per Spec. AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HST531CW-()-() = Phosphate fluoride treat, color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST531RF-()-() = Phosphate fluoride treat and cetyl alcohol lube per Hi-Shear Spec. 305.

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 Dept. 104 5-11-88 APPROVED DATE E. B. S. 5-11-88 REVISION DATE 4 D.P.S. 1-31-91	TITLE HI-LITE ST™ PIN 130° FLUSH CROWN SHEAR HEAD TITANIUM SPECIAL THREAD 1/16" GRIP VARIATION DRAWING NUMBER HST531

HST531