



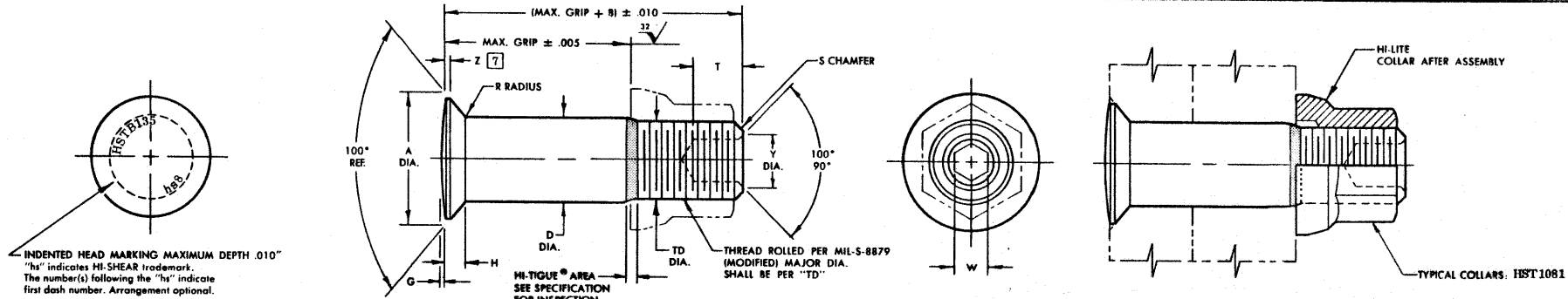
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"CAGE" = Commercial And Government Entity

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197  
Division of Hi-Shear Industries, Inc., U.S.A.  
AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) CAGE No. 06725  
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878  
HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee) CAGE No. 0LB68  
Division of Hi-Shear Industries, Inc., U.S.A.

HUCK INTERNATIONAL GmbH & Co. Germany (Licensee-EEC Countries)  
SIMMONDS S.A. France (Licensee-EEC Countries-Collars)  
St.-CHAMOND GRANAT S.A. France (Licensee-EEC Countries)  
TOKYO SCREW COMPANY, Japan (Licensee-Japan)

941103



HI-LITE ST™ / HI-TIGUE® PIN

HI-LITE ST™ / HI-TIGUE® PIN AND COLLAR 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 .2171	.260	.1375 .1365	.1335 .1310	.003	.006 .002	.0354 .0334	.020 .010	.010	1/32" x 45°	6-32UNJC-3A Modified	.0645 .0635	.090 .070	.090 .075	3,230	1,290
5	5/32	.2612 .2564	.280	.1835 .1825	.1595 .1570	.004	.006 .002	.0410 .0390	.025 .015	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	.109 .094	4,560	1,750
6	3/16	.3018 .2966	.290	.1895 .1885	.1840 .1810	.005	.006 .002	.0470 .0449	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,100	2,340
8	1/4	.3948 .3898	.320	.2495 .2485	.2440 .2410	.006	.006 .002	.0610 .0589	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,600	4,200
10	5/16	.4739 .4689	.380	.3120 .3110	.3060 .3020	.007	.006 .002	.0679 .0658	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,600	6,500
12	3/8	.5604 .5554	.420	.3745 .3735	.3680 .3640	.008	.006 .002	.0780 .0759	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	23,900	9,230

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

GENERAL NOTES:

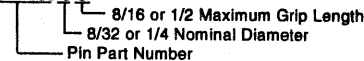
- Head edge out of roundness shall not exceed "F."
- Concentricity: Conical surface of head to "D" diameter within .005 FIR.
- "H" dimensioned from maximum "D" diameter.
- Dimensions of solid film lubed parts to be met after lube.
- Surface texture per ANSI B46. 1.
- Hole preparation per NAS618.
- Curved or flat edge manufacturer's option.
- Use HSTB235 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

HSTB135-8-8



Pin and Collar Assembly Part Number Combination

HSTB1351081-8-8



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

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

FINISH: HSTB135-( )-( ) = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

③ SPECIFICATION: Hi-Lite Product Specification 380.

U.S. Patents 3,578,367; 4,326,825 and 4,485,510. Other U.S. and foreign patents pending. "Hi-Lite" and "Hi-Tigue" are registered trademarks and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.

DRAWN DATE		TITLE	
D.P.S.	12-7-82	HI-LITE ST™ / HI-TIGUE® PIN	
APPROVED R.Ting		100° FLUSH CROWN HEAD	
DATE 12-8-82		ALLOY STEEL	
REVISION ③		1/16" GRIP VARIATION	
DATE J.F.Obispo 10-10-94		DRAWING NUMBER	
		HSTB135	

HSTB135