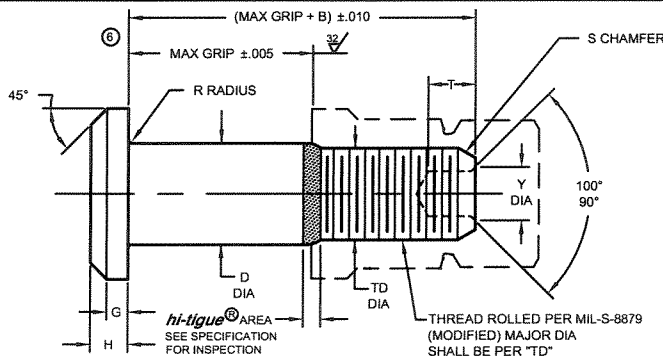
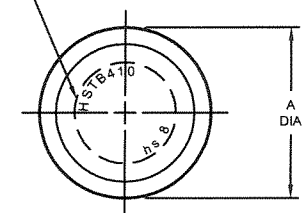
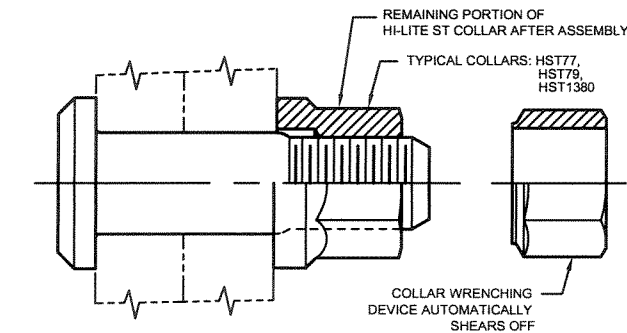
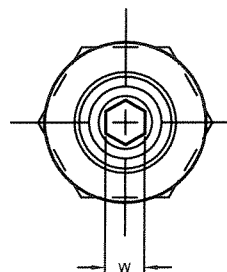


INDENTED HEAD MARKING MAXIMUM DEPTH .010"
"hs" INDICATES HI-SHEAR TRADEMARK.
THE NUMBER(S) FOLLOWING THE "hs" INDICATES
FIRST DASH NUMBER. ARRANGEMENT OPTIONAL.



HI - LITE® ST™ / HI - TIGUE® PIN



HI - LITE® ST™ / HI - TIGUE® PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING	WITH COATING							W HEX	T DEPTH	Y DIA		
5	5/32	.262	.280	.1635	.1635	.1595	.020	.047	.025	1/32" x 37°	8-32UNJC-3A Modified	.0801	.100	.104	4,010	1,940
		.242		.1630	.1625	.1570						.0791	.080	.094		
6	3/16	.315	.290	.1895	.1895	.1840	.025	.055	.025	1/32" x 37°	10-32UNJF-3A Modified	.0806	.100	.119	5,380	2,500
		.295		.1890	.1885	.1810						.0791	.080	.104		
8	1/4	.412	.320	.2495	.2495	.2440	.030	.069	.025	1/32" x 37°	1/4-28UNJF-3A Modified	.0967	.110	.142	9,300	4,300
		.387		.2490	.2485	.2410						.0947	.090	.122		
10	5/16	.505	.380	.3120	.3120	.3060	.035	.078	.030	3/64" x 37°	5/16-24UNJF-3A Modified	.1295	.130	.180	14,600	6,300
		.475		.3115	.3110	.3020						.068	.020	.1270		
12	3/8	.600	.420	.3745	.3745	.3680	.040	.088	.030	3/64" x 37°	3/8-24UNJF-3A Modified	.1617	.160	.217	21,000	8,700
		.565		.3740	.3735	.3640						.078	.020	.1582		
14	7/16	.676	.485	.4370	.4370	.4310	.045	.105	.030	3/64" x 37°	7/16-20UNJF-3A Modified	.1930	.190	.253	28,600	12,100
		.641		.4365	.4360	.4260						.093	.020	.1895		
16	1/2	.770	.525	.4995	.4995	.4930	.050	.115	.030	3/64" x 37°	1/2-20UNJF-3A Modified	.2242	.220	.289	37,300	15,300
		.735		.4990	.4985	.4880						.103	.020	.2207		

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions to be met after finish.
 3. Surface texture per ANSI B46.1.
 4. Hole preparation per NAS618.
 5. Use HSTB110 for oversize replacement.

CODE: First dash number indicates nominal diameter in 1/32nds.
Second dash number indicates maximum grip in 1/16ths.

HOW TO ORDER EXAMPLE:

Pin Part Number Only
HSTB410-8-8

8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter
Pin Part Number

Pin and Collar Assembly Part Number Combination
HSTB41077-8-8

Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

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

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HSTB410(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
HSTB410AG(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HSTB410AZ(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color code black on thread end, 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 international patents pending. "Hi-Lite" and "HST" are registered trademarks and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.		TITLE HI-LITE® ST™ / HI-TIGUE® PIN	
DRAWN D.P.S.	DATE 11-10-83	PROTRUDING SHEAR HEAD TITANIUM 1/16" GRIP VARIATION	
APPROVED E.E.B.	DATE 11-10-83	DRAWING NUMBER HSTB410	
REVISION 6	DATE J.F. Obispo 03-04-03		