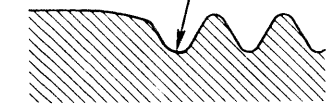


FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	H REF.	R RAD. COLD-WORKED	Z MAX.	S CHAMFER REF.	THREAD	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
-5	5/32	.2612 .2569	.280	.1635 .1625	.1505 .1570	.004	.0410 .0390	.025 .015	.010	1/32" x 37°	8-32UNJC-3A Modified	4,010	1,650
-6	3/16	.3016 .2966	.290	.1895 .1885	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	5,380	2,000
-8	1/4	.3948 .3898	.320	.2495 .2485	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	9,300	3,700
-10	5/16	.4739 .4689	.380	.3120 .3110	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	14,600	5,000
-12	3/8	.5604 .5554	.420	.3745 .3735	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	21,000	7,200
-14	7/16	.6680 .6620	.495	.4370 .4360	.4310 .4260	.009	.0960 .0944	.050 .040	.022	3/64" x 37°	7/16-20UNJF-3A Modified	28,600	10,000
-16	1/2	.7540 .7480	.545	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64" x 37°	1/2-20UNJF-3A Modified	37,300	13,500

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



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

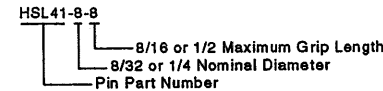
GENERAL NOTES:

- Head edge out of roundness shall not exceed "F".
- Concentricity: Conical surface of head to "D" diameter within .005 FIR.
- "H" is dimensioned from maximum "D" diameter.
- Dimensions in inches and to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Curved or flat edge manufacturer's option.
- This Hi-Lite ST pin is to be used in combination with a Hi-Lite ST collar.
- This Hi-Lite ST pin is to be used in interference fit holes only.

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:



MATERIAL:

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

HEAT TREAT:

95,000 psi shear minimum.

FINISH:

- HSL11VAP-(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HSL11TB-(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, 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 T.Craune	DATE 10-18-93	TITLE HI-LITE® ST™ PIN 100° FLUSH SHEAR HEAD BREAK STEM - INTERFERENCE FIT TITANIUM 1/16" GRIP VARIATION
APPROVED E.E.B.	DATE 11-15-93	DRAWING NUMBER HSL11
REVISION	DATE	Sheet 1 of 2

SECOND DASH NO.	L REFERENCE						
	-5	-6	-8	-10	-12	-14	-16
1	----	----	----	----	----	----	----
2	.935	.945	.927	----	----	----	----
3	1.060	1.070	1.052	1.160	----	----	----
4	1.185	1.195	1.177	1.285	1.285	----	----
5	1.310	1.320	1.302	1.410	1.390	1.500	----
6	1.435	1.445	1.427	1.535	1.515	1.625	1.610
7	1.560	1.570	1.552	1.660	1.640	1.750	1.735
8	1.685	1.695	1.677	1.785	1.765	1.875	1.860
9	1.810	1.820	1.802	1.910	1.890	2.000	1.985
10	1.935	1.945	1.927	2.035	2.015	2.125	2.110
11	2.060	2.070	2.052	2.160	2.140	2.250	2.235
12	2.185	2.195	2.177	2.285	2.265	2.375	2.360
13	2.310	2.320	2.302	2.410	2.390	2.500	2.485
14	2.435	2.445	2.427	2.535	2.515	2.625	2.610
15	2.560	2.570	2.552	2.660	2.640	2.750	2.735
16	2.685	2.695	2.677	2.785	2.765	2.875	2.860
17	2.810	2.820	2.802	2.910	2.890	3.000	2.985
18	2.935	2.945	2.927	3.035	3.015	3.125	3.110
19	3.060	3.070	3.052	3.160	3.140	3.250	3.235
20	3.185	3.195	3.177	3.285	3.265	3.375	3.360
21	----	3.320	3.302	3.410	3.390	3.500	3.485
22	----	3.445	3.427	3.535	3.515	3.625	3.610
23	----	3.570	3.552	3.660	3.640	3.750	3.735
24	----	3.695	3.677	3.785	3.765	3.875	3.860
25	----	----	----	3.910	3.890	4.000	3.985
26	----	----	----	4.035	4.015	4.125	4.110
27	----	----	----	4.160	4.140	4.250	4.235
28	----	----	----	4.285	4.265	4.375	4.360
29	----	----	----	----	----	4.500	4.485
30	----	----	----	----	----	4.625	4.610
31	----	----	----	----	----	4.750	4.735
32	----	----	----	----	----	4.875	4.860

DRAWING NUMBER

HSL11

SHEET 2 OF 2

HSL11