

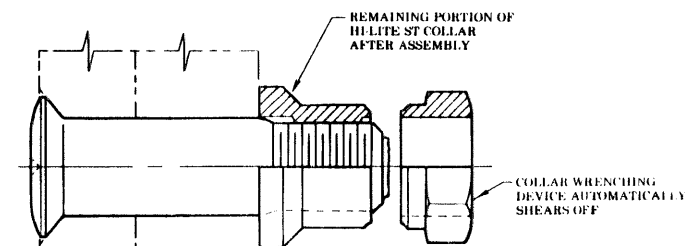
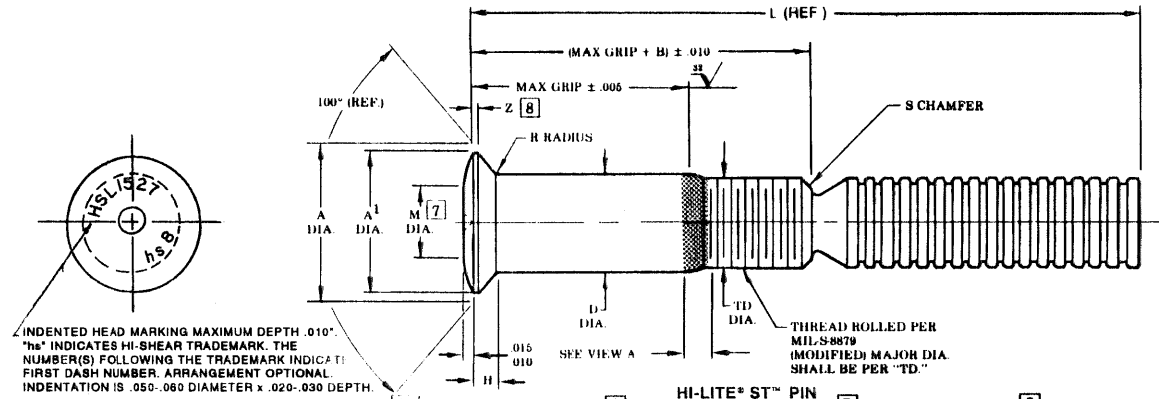
hi-shear
CORPORATION

2600 Skypark Drive
Torrance, California 90509 U.S.A.
Telephone (310) 326-8110
FAX (310) 784-4144

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. CL368
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

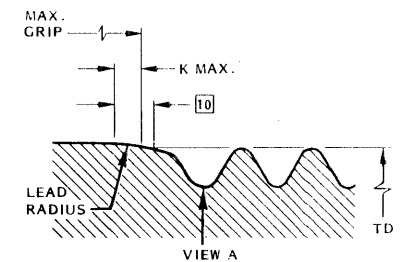


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK. THE NUMBER(S) FOLLOWING THE TRADEMARK INDICATE FIRST DASH NUMBER. ARRANGEMENT OPTIONAL. INDENTATION IS .050-.060 DIAMETER x .020-.030 DEPTH.

FIRST DASH NO.	NOM. DIA.	A DIA.	A' DIA.	B REF.	D DIA BEFORE SOLID FILM LUBE	TD DIA.	F	H	K MAX.	M DIA. FLAT	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
5	5/32	.2612 .2564	.254 .242	.312	.1694 .1690	.1595 .1570	.004	.0385 .0365	.013	.140 .120	.025 .015	.010	1/32" x 37°	8-32UNJC-3A Modified	4,125	1,650
6	3/16	.3016 .2966	.294 .282	.325	.1954 .1950	.1840 .1810	.005	.0446 .0425	.016	.155 .135	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	5,525	2,000
8	1/4	.3948 .3898	.387 .375	.395	.2554 .2550	.2440 .2410	.006	.0584 .0563	.021	.200 .180	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	9,500	3,700
10	5/16	.4739 .4689	.466 .454	.500	.3179 .3175	.3060 .3020	.007	.0654 .0633	.026	.265 .245	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	14,800	5,000
12	3/8	.5604 .5554	.553 .541	.545	.3804 .3800	.3680 .3640	.008	.0755 .0734	.030	.325 .300	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	21,250	7,200
14	7/16	.6680 .6620	.660 .636	.635	.4429 .4425	.4310 .4260	.009	.0944 .0919	.035	.380 .355	.050 .040	.022	3/64" x 37°	7/16-20UNJF-3A Modified	28,875	10,000
16	1/2	.7540 .7480	.746 .722	.685	.5054 .5050	.4930 .4880	.010	.1043 .1017	.039	.445 .415	.050 .040	.022	3/64" x 37°	1/2-20UNJF-3A Modified	37,650	13,500

HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

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



VIEW A
HI LITE THREAD TRANSITION AREA. THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS. 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 to be met after finish, except as noted.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Flat permissible within "M" diameter.
- Curved or flat edge manufacturer's option.
- Use HSL627 for oversize replacement.
- Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
- "D" diameter may increase by .0005 after application of solid film lube.
- Shorter or longer grips than those listed may be available as specials.

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
HSL1527DL-8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ 8/32 or 1/4 Nominal Diameter Pin
Pin Part Number

MATERIAL:

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

HEAT TREAT:

95,000 psi shear minimum.

FINISH:

HSL1527DL-(-)- = Kalgard FA or EM620C solid film lube per MIL-L-46010, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.
HSL1527AP-(-)- = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

Hi-Lite Product Specification 380-2.

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	TITLE
J.F.Obispo	1-19-95	HI-LITE® ST™ PIN 100° FLUSH SHEAR CROWN HEAD TITANIUM SPECIAL THREAD AND SHANK 1/16" GRIP VARIATION
APPROVED	DATE	DRAWING NUMBER
J.Rausch	1-21-95	HSL1527 Sheet 1 of 2
REVISION	DATE	
②	J.F.Obispo 3-19-96	

HSL1527



2600 Skypark Drive
Torrance, California 90509 U.S.A.
Telephone (310) 326-8110
FAX (310) 784-4144

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

12

SECOND DASH NO.	L REF.						
	-5	-6	-8	-10	-12	-14	-16
1	-	-	-	-	-	-	-
2	.835	.955	.940	-	-	-	-
3	.960	1.080	1.065	1.185	-	-	-
4	1.085	1.205	1.190	1.310	1.300	-	-
5	1.210	1.330	1.315	1.435	1.425	1.530	-
6	1.335	1.455	1.440	1.560	1.550	1.655	1.645
7	1.460	1.580	1.565	1.685	1.675	1.780	1.770
8	1.585	1.705	1.690	1.810	1.800	1.905	1.895
9	1.710	1.830	1.815	1.935	1.925	2.030	2.020
10	1.835	1.955	1.940	2.060	2.050	2.155	2.145
11	1.960	2.080	2.065	2.185	2.175	2.280	2.270
12	2.085	2.205	2.190	2.310	2.300	2.405	2.395
13	2.210	2.330	2.315	2.435	2.425	2.530	2.520
14	2.335	2.455	2.440	2.560	2.550	2.655	2.645
15	2.460	2.580	2.565	2.685	2.675	2.780	2.770
16	2.585	2.705	2.690	2.810	2.800	2.905	2.895
17	2.710	2.830	2.815	2.935	2.925	3.030	3.020
18	2.835	2.955	2.940	3.060	3.050	3.155	3.145
19	2.960	3.080	3.065	3.185	3.175	3.280	3.270
20	3.085	3.205	3.190	3.310	3.300	3.405	3.395
21	-	3.330	3.315	3.435	3.425	3.530	3.520
22	-	3.455	3.440	3.560	3.550	3.655	3.645
23	-	3.580	3.565	3.685	3.675	3.780	3.770
24	-	3.705	3.690	3.810	3.800	3.905	3.895
25	-	-	-	3.935	3.925	4.030	4.020
26	-	-	-	4.060	4.050	4.155	4.145
27	-	-	-	4.185	4.175	4.280	4.270
28	-	-	-	4.310	4.300	4.405	4.395
29	-	-	-	-	-	4.530	4.520
30	-	-	-	-	-	4.655	4.645
31	-	-	-	-	-	4.780	4.770
32	-	-	-	-	-	4.905	4.895

DRAWING NUMBER

HSL1527

Sheet 2 of 2

HSL1527