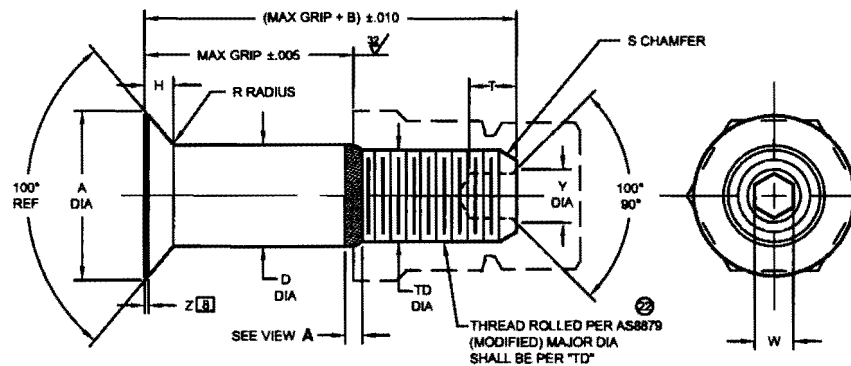
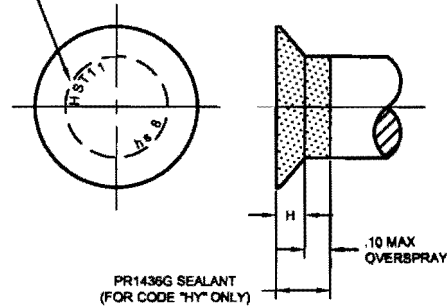
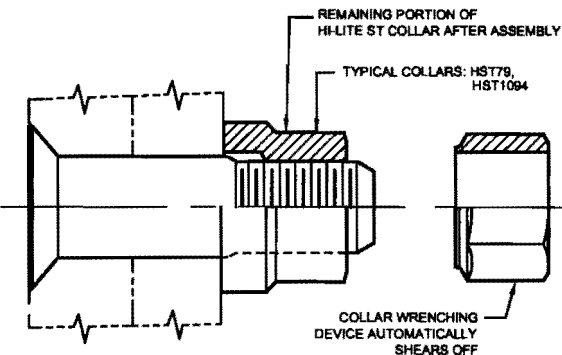


HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE Code 73197	LISI AEROSPACE FRANCE (Licensee) CAGE Code F0188
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	a Lisit Aerospace Company

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



HI-LITE ST PIN



HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM	WITH COATING OR SOLID FILM								W HEX	T DEPTH	Y DIA		
5	5/32	.2612 .2564	.280	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.012	1/32" x 37"	8-32UNJC-3A Modified	.0645 .0635	.135 .115	.090 .075	4,010	1,650
6	3/16	.3016 .2966	.290	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32" x 37"	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,380	2,000
8	1/4	.3948 .3898	.320	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32" x 37"	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	9,300	3,700
10	5/16	.4739 .4689	.380	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64" x 37"	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	14,600	5,000
12	3/8	.5604 .5554	.420	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64" x 37"	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	21,000	7,200
14	7/16	.6680 .6620	.485	.4370 .4365	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64" x 37"	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	28,600	10,000
16	1/2	.7540 .7480	.525	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64" x 37"	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	37,300	13,500
18	9/16	.8380 .8310	.600	.5615 .5610	.5615 .5605	.5550 .5500	.010	.1160 .1131	.050 .040	.025	1/16" x 37"	9/16-18UNJF-3A Modified	.2555 .2520	.290 .270	.326 .306	47,200	17,000
20	5/8	.9250 .9180	.660	.6240 .6235	.6240 .6230	.6180 .6120	.010	.1260 .1230	.050 .040	.025	1/16" x 37"	5/8-18UNJF-3A Modified	.2555 .2520	.330 .305	.326 .306	58,300	21,000
24	3/4	1.0970 1.0850	.895	.7490 .7485	.7490 .7480	.7430 .7370	.012	.1460 .1410	.050 .040	.025	1/16" x 37"	3/4-16UNJF-3A Modified	.3185 .3150	.395 .365	.398 .378	83,900	30,700
28	7/8	1.3197 1.3030	1.000	.8740 .8735	.8740 .8730	.8680 .8610	.014	.1870 .1800	.050 .040	.025	5/64" x 37"	7/8-14UNJF-3A Modified	.3820 .3780	.455 .425	.471 .451	107,000	42,000
32	1	1.5186 1.4995	1.160	.9990 .9985	.9990 .9980	.9930 .9860	.014	.2180 .2100	.050 .040	.025	5/64" x 37"	1-12UNJF-3A Modified	.5100 .5040	.580 .550	.618 .598	140,000	55,000

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

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



VIEW A

HI-LITE THREAD TRANSITION AREA
SEE SPECIFICATION FOR INSPECTION

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.

DRAWN J. Obispo	DATE 8-4-85	TITLE HI-LITE® ST™ PIN 100° FLUSH SHEAR HEAD TITANIUM 1/16" GRIP VARIATION
APPROVED E.E. Beebe	DATE 8-4-85	
REVISION ②	DATE J.F. Obispo 8-30-2011	DRAWING NUMBER HST11

- GENERAL NOTES:**
1. Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within .003 FIM. ②
 3. "H" is dimensioned from maximum "D" diameter.
 4. Dimensions to be met after finish.
 5. Surface texture per ANSI B46.1.
 6. Hole preparation per NAS618.
 7. Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
 8. Curved or flat edge manufacturer's option.
 9. Broach petals removed.
 10. Use HST111 for oversize replacement.

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

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum for sizes up to 3/4);
90,000 psi shear minimum for 7/8 and larger.

- FINISH:**
- HST11-() = Cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST11AG() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST11AP() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST11AZ() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ② HST11BL() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ② HST11BJ() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑥ HST11CT() = Color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST11HK() = Hi-Kote 4 aluminum coating per Hi-Shear Spec. 397.
 - HST11HY() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color code orange on thread end, and apply Precoat No. PR1436G sealant (.002-.005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST11JB() = I.V.D. aluminum coating per A/DET 0012, and cetyl alcohol lube per A/DET 0013.
 - ⑥ HST11K() = Solid film lube per "Lubeco" 905.
 - HST11KM() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ⑥ HST11MA() = Solid film lube per KalGard RA.
 - HST11RP() = Phosphate fluoride treat with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - ② HST11RS() = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color orange on thread end.
 - HST11TB() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST11TF() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
 - HST11WF() = Surface coating per Hi-Shear Spec. 306, Type I, color blue, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST11YV() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 on threads only, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 380.

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
HST11-8-8
├── 8/16 or 1/2 Maximum Grip Length
├── 8/32 or 1/4 Nominal Diameter Pin
└── Pin Part Number