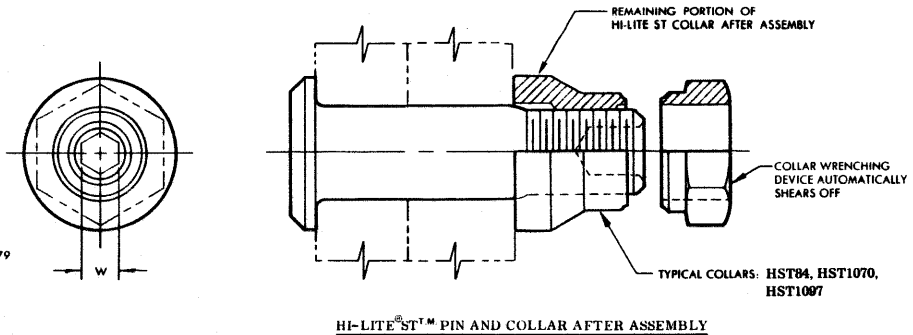
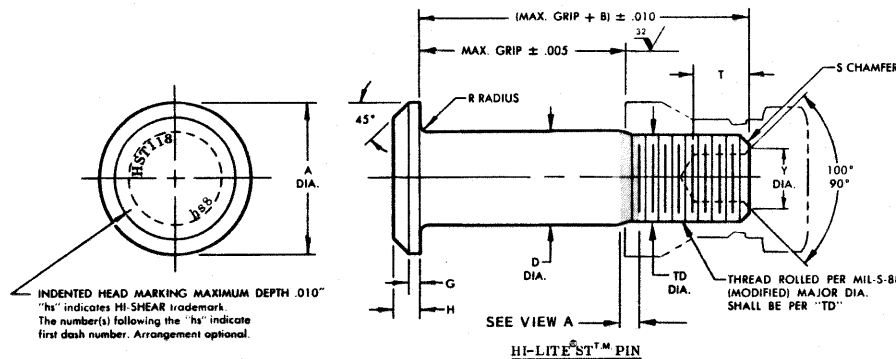


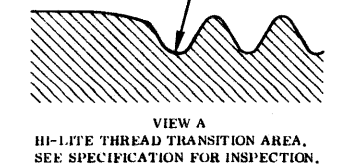
HI-SHEAR CORPORATION, U.S.A. (Patent Holder).....CAGE No. 73197	KAMAX-WERKE Germany (Licensee-EEC Countries)
Division of Hi-Shear Fasteners, Inc., U.S.A.	Edgemoor, Edgemoor GmbH & Co.
AIR INDUSTRIES CO., INC. (Licensee).....CAGE No. 08725	SIMMONDS S.A. France (Licensee-EEC Countries-Collars)
SPS TECHNOLOGIES, U.S.A. (Licensee).....CAGE No. 08070	SI-CHAROND GRANAT S.A. France (Licensee-EEC Countries)
HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee).....CAGE No. 0L808	TOKYO SCREW COMPANY, Japan (Licensee-Japan)



FIRST DASH NO.	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
											W HEX.	T DEPTH	Y DIA.		
-5															
NOTE: USE HST18-6															
-6	13/64	.315 .295	.290	.2026 .2016	.1840 .1810	.025	.055 .045	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	2,500
-8	17/64	.412 .387	.320	.2651 .2641	.2440 .2410	.030	.069 .059	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	4,300
-10	21/64	.505 .475	.380	.3276 .3266	.3060 .3020	.035	.078 .068	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	6,300
-12	25/64	.600 .565	.420	.3901 .3891	.3680 .3640	.040	.088 .078	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	8,700
-14	29/64	.676 .641	.485	.4526 .4516	.4310 .4260	.045	.105 .095	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	12,100
-16	33/64	.770 .735	.525	.5151 .5141	.4930 .4880	.050	.115 .103	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	39,600	15,300

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.

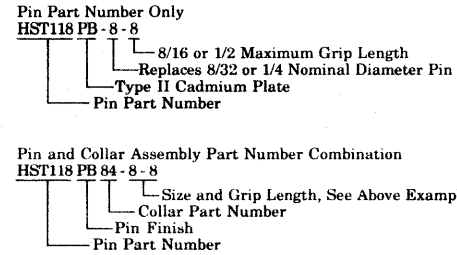


- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIR.
 2. Dimensions to be met after finish.
 3. Surface texture per ANSI B46.1.
 4. Hole preparation per NAS618.
 5. Evidence of broken edge across points.
 6. Non-lubed pins must be used with wet sealant or with lubed collar.
 7. Use HST218 for oversize replacement.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST118 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See finish note for explanation of code letters.

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626, or MIL-S-6049.
HEAT TREAT: 95,000 psi shear minimum (160,000-180,000 psi tensile per Spec. MIL-H-6875).
FINISH: HST118-() = Cadmium plate per QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST118PB-() = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

HOW TO ORDER EXAMPLES:



- ⑥ HST118FN-() = Cadmium plate per QQ-P-416, Type II, Class 2.
HST118RZ-() = Cadmium plate per QQ-P-416, Type II, Class 2, color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST118TF-() = Cadmium plate per QQ-P-416, Type III, Class 2, and Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
HST118TP-() = Cadmium plate per QQ-P-416, Type III, Class 2, Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, color orange 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 foreign patents pending. "Hi-Lite" is a registered trademark, and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.

DRAWN Dept. 104 8-3-90	DATE 8-3-90	TITLE HI-LITE[®]ST[™] PIN PROTRUDING SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION - 1/64" OVERSIZE
APPROVED	DATE 8-25-92	DRAWING NUMBER HST118
REVISION 2	DATE 8-25-92	

HST118