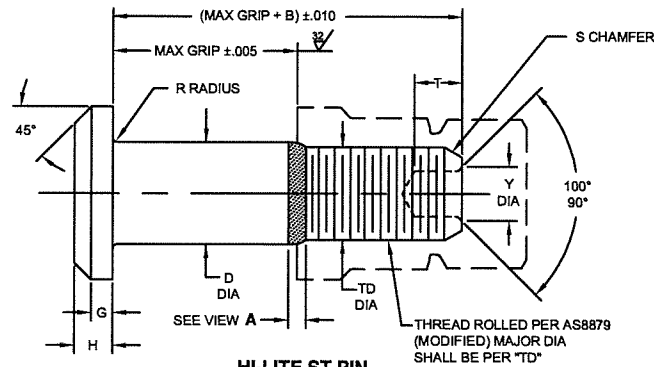
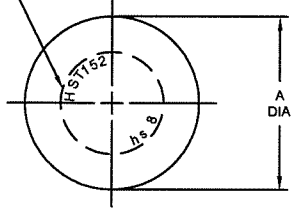
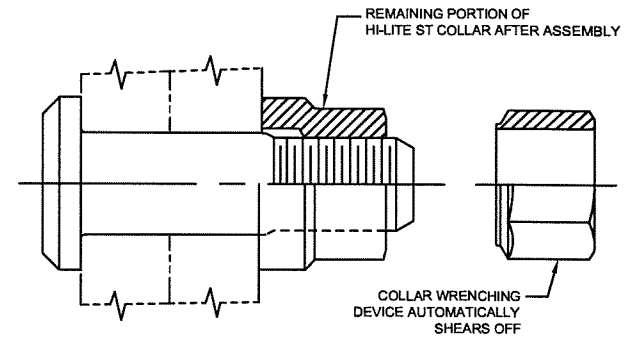


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MINEREA CO. LTO, Japan (Licensee-Japan) CAGE Code. SB962	(Licensee) CAGE Code. L4528
	(Licensee) CAGE Code. U6300
	(Licensee) CAGE Code. T0802
	(Licensee) CAGE Code. L4528

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 PIN**



**HI-LITE ST 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 OR SOLID FILM	WITH COATING OR SOLID FILM							W HEX	T DEPTH	Y DIA		
NOTE: USE HST52-6(-)																
6	13/64	.315 .295	.300	.2026 .2021	.2026 .2016	.1840 .1810	.025	.055 .045	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	8,100	3,000
8	17/64	.412 .387	.330	.2651 .2646	.2651 .2641	.2440 .2410	.030	.069 .059	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	13,800	5,100
10	21/64	.505 .475	.390	.3276 .3271	.3276 .3266	.3060 .3020	.035	.078 .068	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	21,100	8,000
12	25/64	.600 .565	.430	.3901 .3896	.3901 .3891	.3680 .3640	.040	.088 .078	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	30,000	11,300
14	29/64	.676 .641	.495	.4526 .4521	.4526 .4516	.4310 .4260	.045	.105 .093	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	40,300	15,500
16	33/64	.770 .735	.535	.5151 .5146	.5151 .5141	.4930 .4880	.050	.116 .103	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	52,500	20,000

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

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIM.
  - Dimensions to be met after finish.
  - Surface texture per ANSI B46.1.
  - Hole preparation per NAS618.
  - Use HST252 for oversize replacement.

**MATERIAL:** Nickel base alloy per AMS5662.

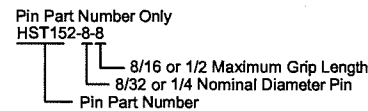
**HEAT TREAT:** 125,000 psi shear minimum.

- FINISH:**
- HST152(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST152AC(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 with color code green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST152AG(-)(-) = 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.
  - HST152AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST152TB(-)(-) = 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.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HST152 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

**HOW TO ORDER EXAMPLE:**



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	DATE	TITLE	
J.F.Obispo	1-20-97	<b>HI-LITE® ST™ PIN</b> ②	
APPROVED	DATE	PROTRUDING SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION, 1/64" OVERSIZE	
MC	1-21-97		
REVISION	DATE	DRAWING NUMBER	
②	J.F.O. 4-22-10	<b>HST152</b>	