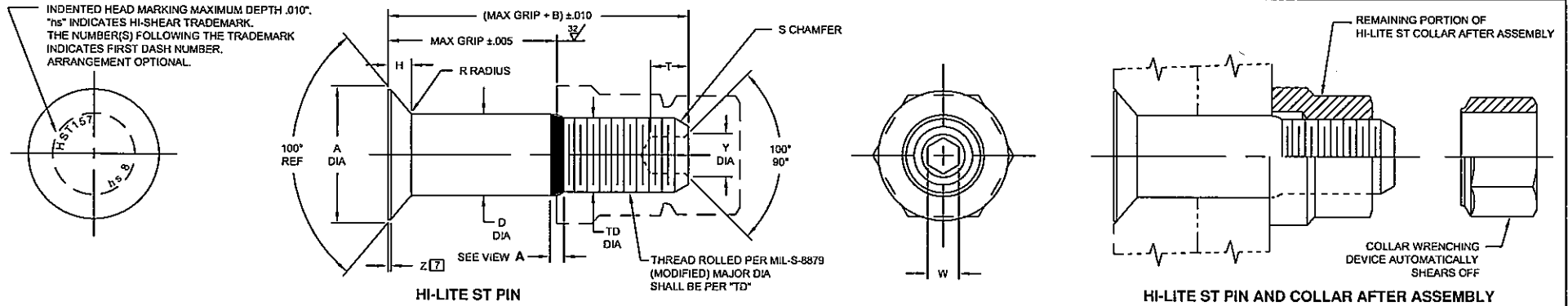
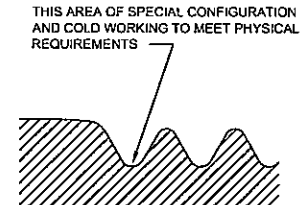


HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE Code. 73197	LISI AEROSPACE FRANCE (Licensee) CAGE Code. F0188
a Lisi Aerospace Company	a Lisi Aerospace Company
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a Lisi Aerospace Company	



FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F REF	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		
NOTE: HST57-6(-)																	
5																	
6	13/64	.3016 .2966	.300	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0415 .0394	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	8,100	2,600
8	17/64	.3948 .3898	.330	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0544 .0523	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	13,800	4,400
10	21/64	.4739 .4689	.390	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0614 .0593	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	21,100	6,800
12	25/64	.5604 .5554	.430	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0714 .0693	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	30,000	9,500
14	29/64	.6680 .6620	.495	.4526 .4521	.4526 .4516	.4310 .4260	.009	.0904 .0879	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	40,300	12,500
16	33/64	.7540 .7480	.535	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1002 .0977	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	52,500	TBD
18	37/64	.8380 .8310	.610	.5771 .5766	.5771 .5761	.5550 .5500	.010	.1094 .1065	.050 .040	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	65,600	TBD

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



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

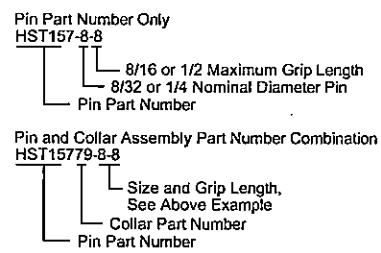
- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hot preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Boach petals removed.
 - Oversize replacement for HST57.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST157 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

MATERIAL: Nickel base alloy per AMS5662.
HEAT TREAT: 125,000 psi shear minimum.

HOW TO ORDER EXAMPLE:

- FINISH:**
- HST157(-)(-) = Passivate per Hi-Shear 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST157AC(-)(-) = 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.
 - HST157AG(-)(-) = 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.
 - HST157AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST157DU(-)(-) = Solid film lube per AS5272, Type I.
 - HST157MA(-)(-) = Solid film lube per KALGARD RA.
 - HST157TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST157TP(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.



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.F.Obispo	DATE 5-22-96	TITLE HI-LITE® ST™ PIN
APPROVED MC	DATE 5-28-96	100° FLUSH SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION, 1/64" OVERSIZE
REVISION 4	DATE L.G.Valencia 03-18-08	DRAWING NUMBER HST157

HST157