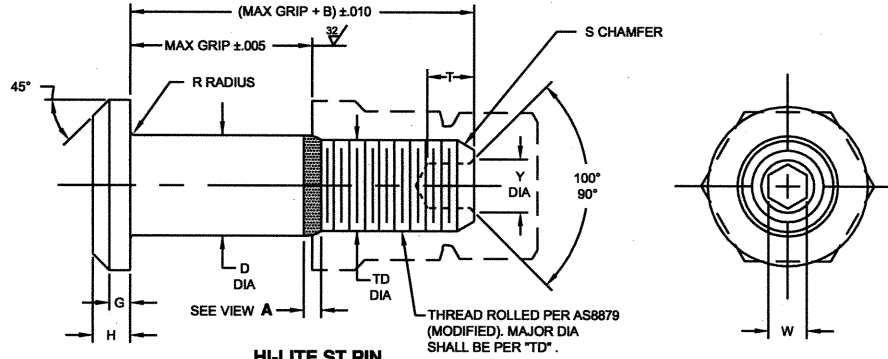
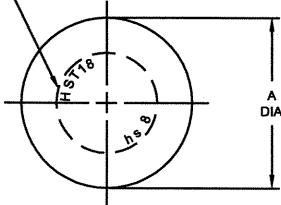
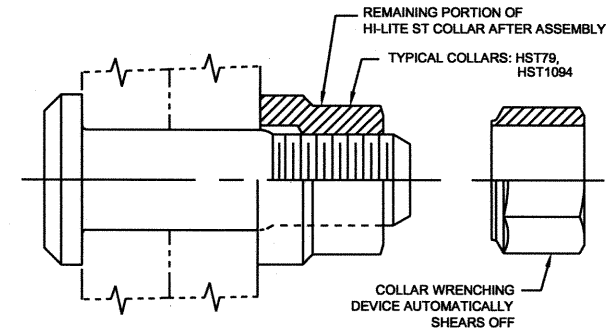


INDENTED HEAD MARKING MAXIMUM DEPTH .010"  
"hs" INDICATES HI-SHEAR TRADEMARK.  
THE NUMBER(S) FOLLOWING THE "hs" INDICATES  
FIRST DASH NUMBER. ARRANGEMENT OPTIONAL.



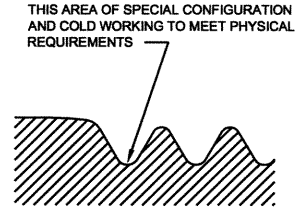
HI-LITE ST PIN



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
											W HEX	T DEPTH	Y DIA		
5	5/32	.262 .242	.280	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	5	4,010	1,940
6	3/16	.315 .295	.290	.1895 .1885	.1840 .1810	.025	.055 .045	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,380	2,500
8	1/4	.412 .387	.320	.2495 .2485	.2440 .2410	.030	.069 .059	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	9,300	4,300
10	5/16	.505 .475	.380	.3120 .3110	.3060 .3020	.035	.078 .068	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	14,600	6,300
12	3/8	.600 .565	.420	.3745 .3735	.3680 .3640	.040	.088 .078	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	21,000	8,700
14	7/16	.676 .641	.485	.4370 .4360	.4310 .4260	.045	.105 .093	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	28,600	12,100
16	1/2	.770 .735	.525	.4995 .4985	.4930 .4880	.050	.115 .103	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	37,300	15,300
18	9/16	.864 .829	.600	.5615 .5605	.5550 .5500	.055	.127 .112	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	47,200	19,000
20	5/8	.953 .918	.660	.6240 .6230	.6180 .6120	.060	.137 .122	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	58,300	23,000

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



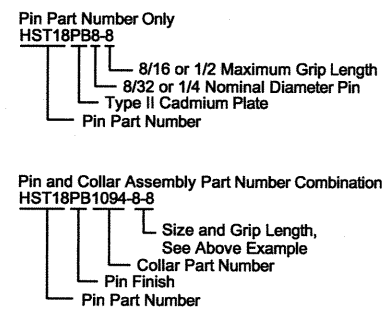
VIEW A  
HI-LITE THREAD TRANSITION AREA  
SEE SPECIFICATION FOR INSPECTION

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIM.
  - Dimensions to be met after finish.
  - Surface texture per ANSI B46.1.
  - Hole preparation per NAS618.
  - Evidence of broken edge across points.
  - Non-lubed pins must be used with wet sealant or with lubed collar.
  - Use HST118 for oversize replacement.

**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.

- MATERIAL:** Alloy steel per AMS6415, AMS6349, or AMS-S-6049.
- HEAT TREAT:** 95,000 psi minimum (160,000 - 180,000 psi tensile per AMS-H-6875).
- FINISH:**
- HST18(-)(-) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST18PA(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST18PB(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST18PN(-)(-) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
  - HST18TF(-)(-) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
  - HST18TP(-)(-) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and 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.

**HOW TO ORDER EXAMPLE:**



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
D.P.S.	9-10-82	<b>HI-LITE® ST™ PIN</b>
APPROVED	DATE	PROTRUDING SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION
E.E. Beeles	9-13-82	DRAWING NUMBER
REVISION	DATE	<b>HST18</b>
9	J.F. Obispo 9-28-06	

**SPECIFICATION:** Hi-Lite Product Specification 380.