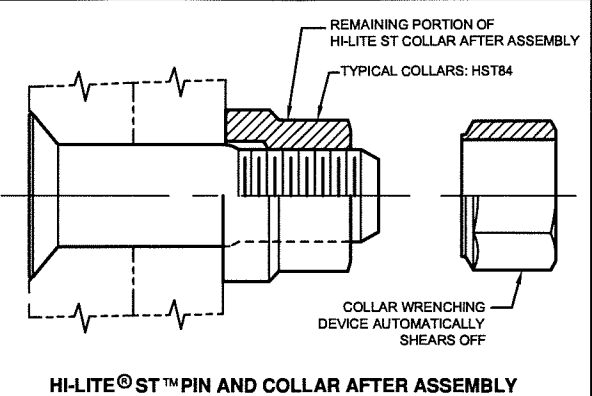
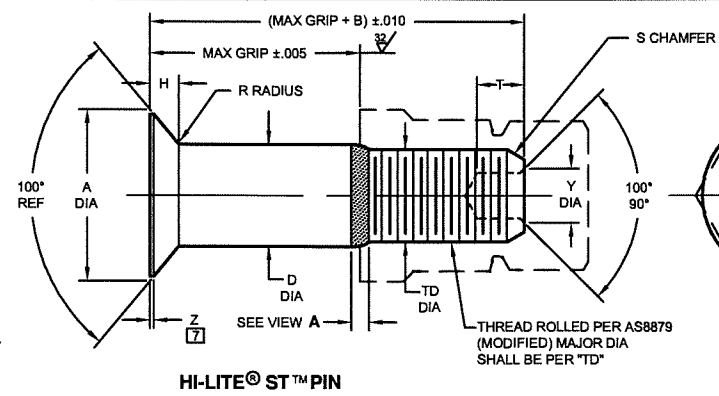
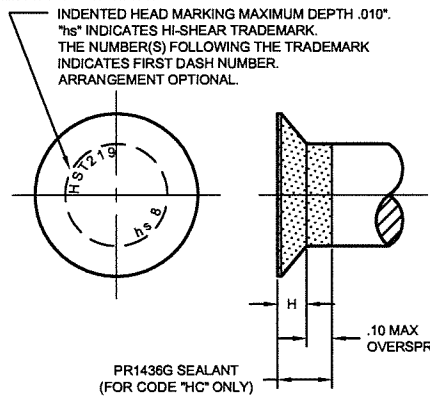


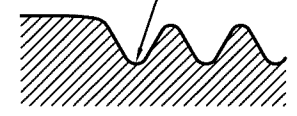
HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. OLB68
a LISI AEROSPACE Company	a LISI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada) CAGE No. 06725	BLANC AERO S.A. France (Licensee - ECC Countries)
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878	a GFI AEROSPACE Company
FAIRCHILD - SIMMONDS S.A. France (Licensee) CAGE No. 92215	TOKYO SCREW COMPANY, Japan (Licensee - Japan)



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
												W HEX	T DEPTH	Y DIA		
5	13/64															
NOTE: USE HST119-6- () Ⓞ																
6	7/32	.3303 .3253	.300	.2182 .2177	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,100	2,000
8	9/32	.4260 .4210	.330	.2807 .2802	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.150 .130	.142 .122	11,800	3,700
10	11/32	.5051 .5001	.390	.3432 .3427	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.170 .150	.180 .160	17,600	5,000
12	13/32	.5916 .5866	.430	.4057 .4052	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.200 .180	.217 .197	24,600	7,200
14	15/32	.6992 .6932	.495	.4682 .4677	.4310 .4260	.009	.0989 .0944	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.230 .210	.253 .233	32,700	10,000
16	17/32	.7852 .7792	.535	.5307 .5302	.4930 .4880	.010	.1069 .1043	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.260 .240	.289 .269	42,000	13,500

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

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

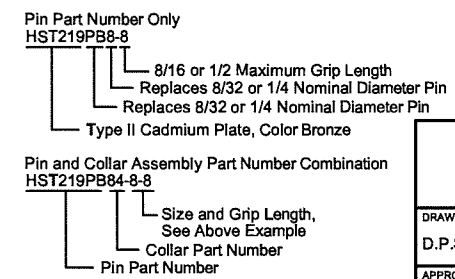


- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Non-lubed pins must be used with wet sealant or with lubed collars.

SPECIFICATION: Hi-Lite Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST219 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See Finish note for explanation of code letters.

**HOW TO ORDER
 EXAMPLE:**



MATERIAL: Alloy steel per AMS6415, AMS6349, or AMS-S-6049. Ⓞ

HEAT TREAT: 95,000 psi shear minimum (160,000 psi tensile per AMS-H-6875). Ⓞ

- FINISH:**
- HST219- () () = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST219PB- () () = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST219HC- () () = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and apply Precoat No. PR1436G sealant (.002-.005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST219PN- () () = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 - HST219RZ- () () = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST219TF- () () = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
 - HST219TP- () () = 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.

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.	8-30-90	HI-LITE® ST™ PIN
APPROVED	DATE	100° FLUSH SHEAR HEAD Ⓞ ALLOY STEEL, 1/32" OVERSIZE 1/16" GRIP VARIATION
JGW/lcox	8-30-90	DRAWING NUMBER
REVISION	DATE	HST219
3	J.F.Obispo 11-4-09	

HST219