

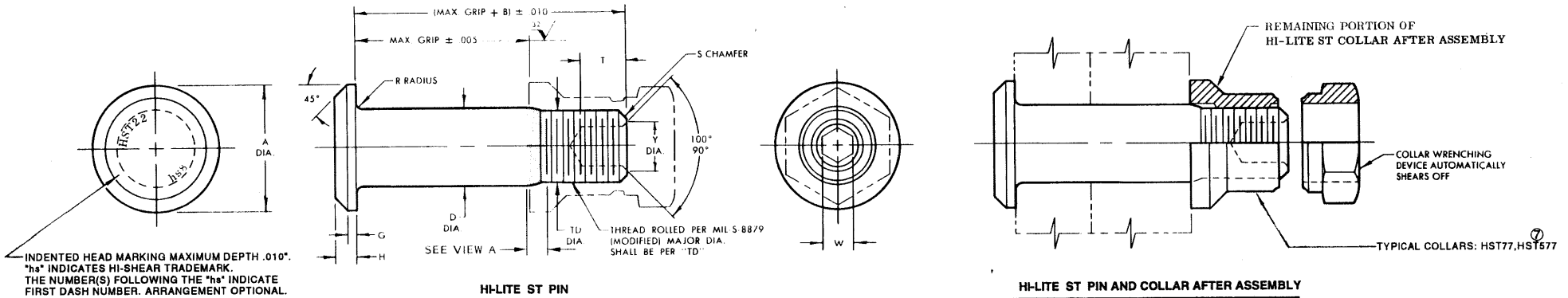


2600 Skypark Drive  
Torrance, California 90509 U.S.A.  
Telephone (310) 326-8110  
FAX (310) 784-4144

\*CAGE\* = Commercial And Government Entity

HI-SHEAR CORPORATION, U.S.A. ....(Patent Holder).....CAGE No. 73197  
A Subsidiary of GFI Industries, France  
AIR INDUSTRIES CO., INC. (Licensee-U.S.A. & Canada)...CAGE No. 06725  
SPS TECHNOLOGIES, U.S.A. (Licensee) .....CAGE No. 56878  
HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee).....CAGE No. OLB86  
A Subsidiary of GFI Industries, France

HUCK INTERNATIONAL Gmbh & Co. Germany.....(Licensee - EEC Countries)  
SIMMONDS S.A. France.....(Licensee - EEC Countries-Collars)  
St.-CHAMOND GRANAT S.A. France.(Licensee - EEC Countries)  
TOKYO SCREW COMPANY, Japan.....(Licensee-Japan)



HI-LITE ST PIN

HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

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	5/32	.262 .242	.280	.1635 .1625	.1595 .1570	.030	.060 .045	.025 .015	1/32" x 45°	8-32UNJC-3A Modified	.0645 .0635	.090 .070	.090 .075	1,760	940
6	3/16	.315 .295	.290	.1895 .1885	.1840 .1810	.035	.074 .055	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	2,540	1,240
8	1/4	.412 .387	.320	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	4,500	2,170
10	5/16	.505 .475	.380	.3120 .3110	.3060 .3020	.055	.110 .100	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	7,050	3,020
12	3/8	.600 .565	.420	.3745 .3735	.3680 .3640	.065	.135 .125	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	10,100	4,370
14	7/16	.676 .641	.485	.4370 .4360	.4310 .4260	.075	.155 .145	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	13,800	6,000
16	1/2	.770 .735	.525	.4995 .4985	.4930 .4880	.085	.180 .170	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	18,000	7,600

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

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions to be met after finish.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS1618.
5. Use HST122 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:

7075 aluminum alloy per QQ-A-225/9 or QQ-A-430.

HEAT TREAT:

Age to T6 condition per MIL-H-6088.

FINISH:

HST22(-)(-) = Anodize per MIL-A-8625, dye color natural, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HST22DU(-)(-) = Anodize per MIL-A-8625, and solid film lube per MIL-L-46010, Type I.  
HST22EY(-)(-) = Anodize per MIL-A-8625, dye color yellow, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HST22TT(-)(-) = Anodize per MIL-A-8625, dye color natural, and translube.

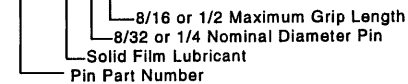
SPECIFICATION:

Hi-Lite Product Specification 380.

HOW TO ORDER EXAMPLES:

Pin Part Number Only

HST22DU8-8



Pin and Collar Assembly Part Number Combination

HST22DU778-8



U.S. Patents 4,326,825; 4,485,510 and 4,957,401. Other U.S. and foreign patents pending. "Hi-Lite" and "HST" are registered trademarks, and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.	
DRAWN DATE S.Graphics 9-29-83	TITLE <b>HI-LITE<sup>®</sup>ST<sup>™</sup> PIN</b> PROTRUDING SHEAR HEAD ALUMINUM ALLOY 1/16" GRIP VARIATION
APPROVED DATE E.E.Beeles 10-4-83	DRAWING NUMBER <b>HST22</b>
REVISION DATE ⑦ J.Henderson 2-26-97	

HST22

STD/HSTPIN