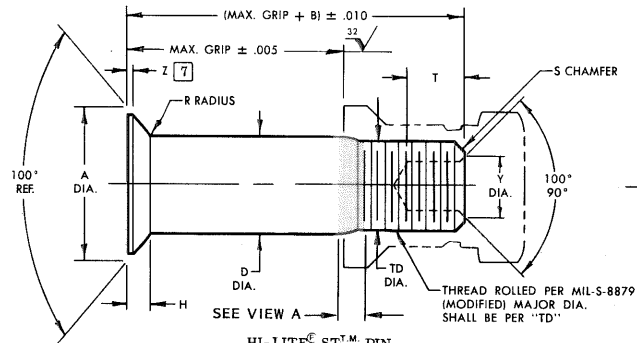
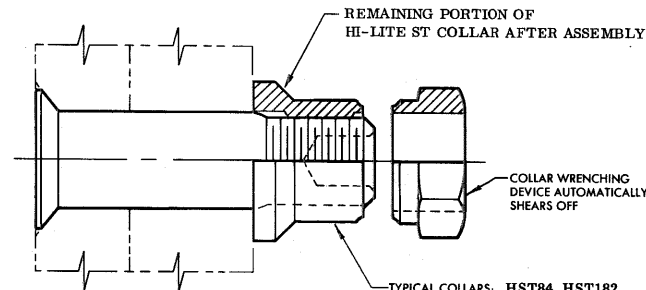


INDENTED HEAD MARKING MAXIMUM DEPTH .010"
"hs" indicates HI-SHEAR trademark.
The number(s) following the "hs" indicate
first dash number. Arrangement optional.



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.	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																
NOTE: USE HST23-6																
-6	7/32	.3536 .3486	.290	.2132 .2172	.1840 .1810	.005	.0568 .0547	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	3,400	1,150
-8	9/32	.4732 .4682	.320	.2807 .2797	.2440 .2410	.006	.0807 .0786	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	5,600	2,000
-10	11/32	.5619 .5569	.380	.3432 .3422	.3060 .3020	.007	.0917 .0896	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	8,300	2,800
-12	13/32	.6912 .6862	.420	.4057 .4047	.3680 .3640	.008	.1198 .1177	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	11,700	3,900
-14	15/32	.8041 .7969	.485	.4682 .4672	.4310 .4260	.009	.1409 .1379	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	15,500	6,000
-16	17/32	.9166 .9095	.525	.5307 .5297	.4930 .4880	.010	.1619 .1589	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	19,900	7,600

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

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS.



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 FIR.
 - "H" 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.

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

HEAT TREAT: Age to T6 condition per MIL-H-6088.

- FINISH:
- HST223-() = Anodize per MIL-A-8625, dye color natural, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST223DU-() = Anodize per MIL-A-8625, and solid film lube per MIL-L-46010, Type I.
 - HST223EY-() = Anodize per MIL-A-8625, dye color yellow, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST223TT-() = Anodize per MIL-A-8625, dye color natural, and translube.

SPECIFICATION: Hi-Lite Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds which HST223 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

HOW TO ORDER

EXAMPLES:

Pin Part Number Only
HST223DU-8-8
8-8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Solid Film Lubricant
Pin Part Number

Pin and Collar Assembly Part Number Combination
HST223DU84-8-8
8-8/16 Size and Grip Length, See Above Example
Collar Part Number
Pin Finish
Pin Part Number

U.S. Patents 4,326,825 and 4,485,510. Other U.S. and foreign patents pending. "Hi-Lite" is a registered trademark, and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.			
DRAWN	DATE	TITLE	
Dept. 104	8-3-90	HI-LITE [®] ST [™] PIN	
APPROVED	DATE	100° FLUSH MS20426 SHEAR HEAD	
[Signature]	8-3-90	ALUMINUM ALLOY	
REVISION	DATE	1/16" GRIP VARIATION, 1/32" OVERSIZE	
		DRAWING NUMBER	
		HST223	

HST223