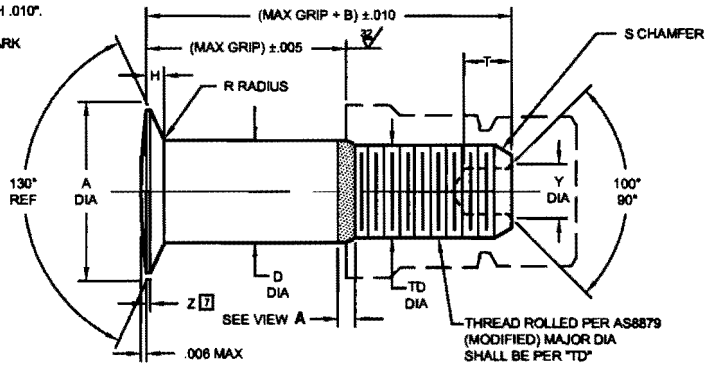
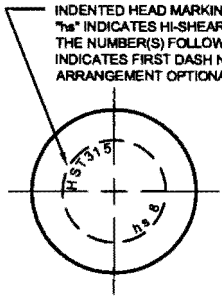
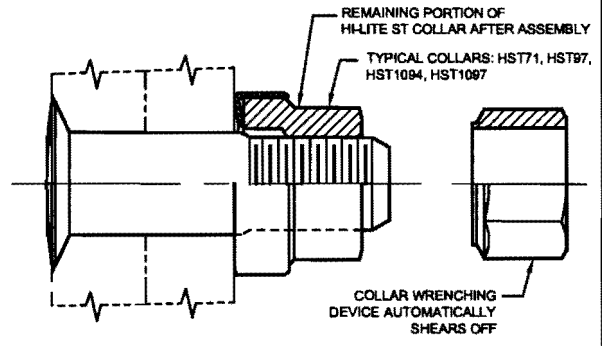
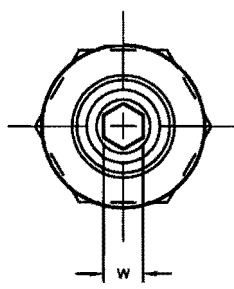


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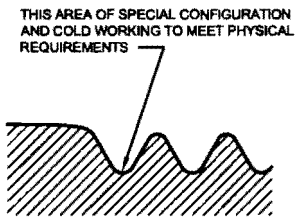
**HI-LITE ST PIN**



**HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY**

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

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		
5	5/32	.3393	.280	.1635	.1635	.1595	.004	.0410	.025	.012	1/32" x 37"	8-32UNJC-3A Modified	.0801	.100	.104	4,010	1,650
		.3308		.1630	.1625	.1570		.0791	.080				.094				
6	3/16	.3911	.290	.1895	.1895	.1840	.005	.0470	.030	.015	1/32" x 37"	10-32UNJF-3A Modified	.0806	.100	.119	5,380	2,000
		.3825		.1890	.1885	.1810		.0791	.080				.104				
7	7/32	.4468	.305	.2182	.2182	.2100	.006	.0535	.030	.015	1/32" x 37"	12-28UNJF-3A Modified	.0806	.100	.119	7,100	2,600
		.4382		.2177	.2172	.2070		.0791	.080				.104				
8	1/4	.5111	.320	.2495	.2495	.2440	.006	.0610	.030	.015	1/32" x 37"	1/4-28UNJF-3A Modified	.0967	.110	.142	9,300	3,700
		.5026		.2490	.2485	.2410		.0947	.090				.122				
10	5/16	.6037	.380	.3120	.3120	.3060	.007	.0680	.040	.015	3/64" x 37"	5/16-24UNJF-3A Modified	.1295	.130	.180	14,600	5,000
		.5951		.3115	.3110	.3020		.1270	.110				.160				
12	3/8	.7090	.420	.3745	.3745	.3680	.008	.0780	.040	.015	3/8-24UNJF-3A Modified	.1617	.160	.217	21,000	7,200	
		.7005		.3740	.3735	.3640		.1582	.140			.197					
14	7/16	.8526	.485	.4370	.4370	.4310	.009	.0969	.050	.020	7/16-20UNJF-3A Modified	.1930	.190	.253	28,600	10,000	
		.8419		.4365	.4360	.4260		.1895	.170			.233					



**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, except "BS" code dimension to be met before solid film lube.
  - Surface texture per ANSI B46.1.
  - Hole preparation per NAS818.
  - Curved or flat edge manufacturer's option.
  - Use HST415 for oversize replacement.
  - Non-lubed pins must be used with lubed collars.
  - Complete solid film lube coverage of threads and HI-Lite transition area required. Overspray on "D" diameter permissible.

**MATERIAL:** 6AL-4V titanium alloy per AMS4928 or AMS4967.  
**HEAT TREAT:** 95,000 psi shear minimum.

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.	11-18-85	<b>HI-LITE® ST™ PIN</b>
APPROVED	DATE	130° FLUSH CROWN SHEAR HEAD TITANIUM 1/16" GRIP VARIATION
E.E.Beeles	11-18-85	
REVISION	DATE	DRAWING NUMBER
(28)	J.F.Obispo 9-8-2011	<b>HST315</b>

**HST315**

- FINISH:**
- HST315(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST315AG(-)(-) = Hi-Kote 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST315AP(-)(-) = Hi-Kote 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST315BJ(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - ☐ HST315BS(-)(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue, with Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, except no solid film lube allowed on the head or "R" radius, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST315CE(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, (.00015-.00045 thick), with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST315CF(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, (.00015-.00045 thick), with color black on thread end.
  - HST315CZ(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305, with color black on thread end.
  - HST315GD(-)(-) = Hi-Kote 1 aluminum pigmented coating on threads only per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - ⊙ HST315GM(-)(-) = Hi-Kote 1 aluminum pigmented coating per Hi-Shear Spec. 294 on threads (no overspray on the shank is allowed) and top of head only (.005 max overspray on the head bearing surface permissible) with color white on thread ends, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - ⊙ HST315HF(-)(-) = Hi-Kote 1 aluminum pigmented coating per Hi-Shear Spec. 294 on threads (no overspray on the shank is allowed) and top of head only (.005 max overspray on the head bearing surface permissible) and cetyl alcohol lube per Hi-Shear Spec. 305.
  - ☐ HST315RN(-)(-) = Phosphate fluoride treat, no lube.
  - HST315RP(-)(-) = Phosphate fluoride treat with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST315SY(-)(-) = Phosphate fluoride treat and solid film lube per AS5272, Type I.
  - HST315TA(-)(-) = Ti-Shield III, Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST315TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST315UT(-)(-) = Ti-Shield III, Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
  - HST315UV(-)(-) = Surface coating per Hi-Shear Spec. 306, Type II, Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST315WF(-)(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST315YV(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 on threads only, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST315KM(-)(-) = Hi-Kote 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
  - HST315KV(-)(-) = Sulphuric acid anodizing per ISO8080 and Hi-Kote 1 aluminum pigmented coating per Hi-Shear Spec. 294 on threads only, and cetyl alcohol lube per Hi-Shear Spec. 305.

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

**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.

**HOW TO ORDER EXAMPLES:**

Pin Part Number Only  
HST315-8-8  
└─ 8/16 or 1/2 Maximum Grip Length  
└─ 8/32 or 1/4 Nominal Diameter Pin  
└─ Pin Part Number