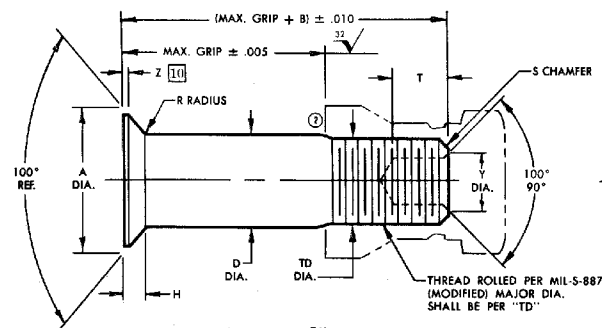
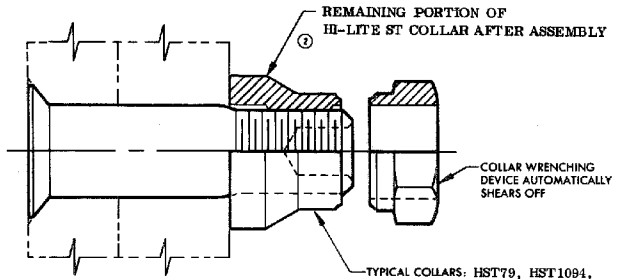
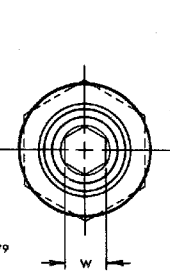


INDENTED HEAD MARKING MAXIMUM DEPTH .010"  
"hs" indicates HI-SHEAR trademark.  
The number(s) following the "hs" indicate first dash number. Arrangement optional.



HI-LITE ST™ PIN



HI-LITE ST™ PIN AND COLLAR AFTER ASSEMBLY

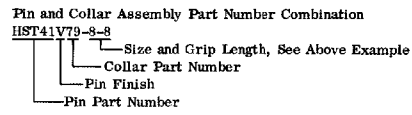
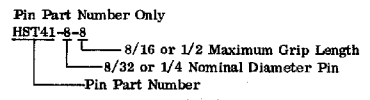
FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT PLATING OR SOLID FILM LUBE	WITH PLATING OR SOLID FILM LUBE								W HEX.	T DEPTH	Y DIA.		
-5	5/32	.2612 .2564	.280	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.012	1/32" x 45°	8-32UNJC-3A Modified	.0901 .0791	.100 .080	[9]	4,010	1,290
-6	3/16	.3016 .2966	.290	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0449	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	5,380	2,000
-8	1/4	.3948 .3898	.320	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0589	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0987 .0947	.110 .090	.142 .122	9,300	3,700
-10	5/16	.4739 .4689	.380	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0679 .0658	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	14,600	5,000
-12	3/8	.5604 .5554	.420	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0759	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	21,000	7,200
-14	7/16	.6680 .6620	.485	.4370 .4365	.4370 .4360	.4310 .4260	.009	.0869 .0844	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1990 .1895	.190 .170	.253 .233	28,600	10,000
-16	1/2	.7540 .7480	.525	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1069 .1043	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	37,300	13,500

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

- 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.
  - Non-lubed pins must be used with lubed collars.
  - Surface texture per ANSI B46.1.
  - Hole preparation per NAS618.
  - Maximum "D" diameter may be increased by .0002 to allow for solid film application.
  - Evidence of broken edge across points.
  - Curved or flat edge manufacturer's option.
- MATERIAL: A-286 high temperature alloy per Spec. AMS5737 or AMS5731.  
HEAT TREAT: 95,000 psi shear minimum at 70°F.  
FINISH: HST41-( )-( ) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST41DU-( )-( ) = Solid film lube per MIL-L-8937.  
HST41GU-( )-( ) = Silver plate per AMS2410.  
HST41PY-( )-( ) = Passivate per Hi-Shear Spec. 258.  
HST41TF-( )-( ) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.  
HST41V-( )-( ) = Solid film lubricant per "Lubeco" 2123, Type II.
- ② 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:



U. S. Patent 4,326,825. Other U. S. & foreign patents pending. "Hi-Lite" and "Hi-Lite ST" are trademarks of Hi-Shear Corporation.		TITLE <b>HI-LITE ST™ PIN</b> 100° FLUSH SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION	
DRAWN	DATE	DRAWING NUMBER	
D. P. S.	9-10-82	<b>HST41</b>	
APPROVED	DATE		
	4-12-83		
REVISION	DATE		
②	4-12-83		

HST41