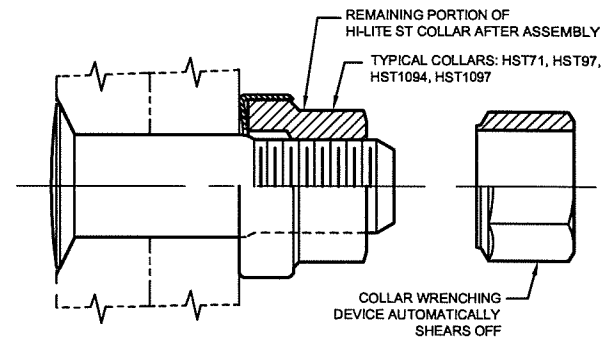
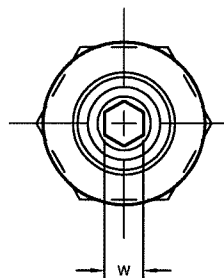
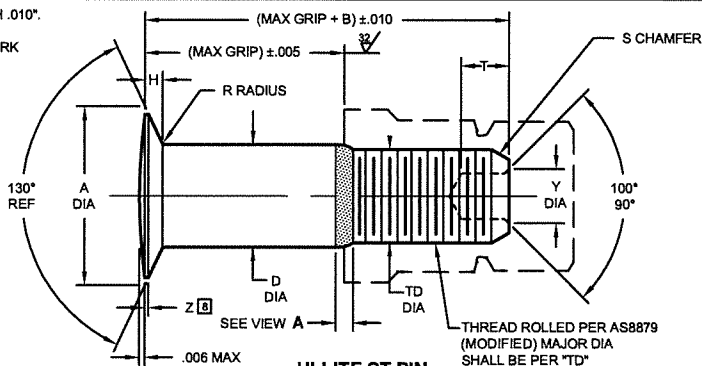
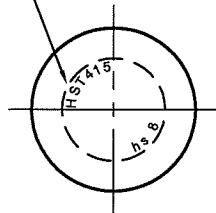


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	a Lisi Aerospace Company

INDENTED HEAD MARKING MAXIMUM DEPTH .010".
 "hs" INDICATES HI-SHEAR TRADEMARK.
 THE NUMBER(S) FOLLOWING THE TRADEMARK
 INDICATES FIRST DASH NUMBER.
 ARRANGEMENT OPTIONAL.



HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

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		
NOTE: USE HST315-6(-)																	
6	13/64	.3911 .3825	.300	.2026 .2021	.2026 .2016	.1840 .1810	.005	.044 .042	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	2,000
8	17/64	.5111 .5026	.330	.2651 .2646	.2651 .2641	.2440 .2410	.006	.058 .056	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	3,700
10	21/64	.6037 .5951	.390	.3276 .3271	.3276 .3266	.3060 .3020	.007	.065 .063	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	5,000
12	25/64	.7090 .7005	.430	.3901 .3896	.3901 .3891	.3680 .3640	.008	.075 .073	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	7,200
14	29/64	.8526 .8419	.495	.4526 .4521	.4526 .4516	.4310 .4260	.009	.093 .091	.050 .040	.020	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	10,000

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 FIM.
- "H" is dimensioned from maximum "D" diameter.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Maximum "D" diameter may be increased by .0002 to allow for solid film or aluminum coating application.
- Curved or flat edge manufacturer's option.
- Use HST1515 for oversize replacement.

MATERIAL:

6AL-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT:

95,000 psi shear minimum.

FINISH:

- HST415(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
- HST415AG(-)(-) = 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.
- HST415AP(-)(-) = Hi-Kote 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST415BJ(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl lube lube per Hi-Shear Spec. 305.
- HST415CE(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, (.00015-.00045 thick), with color black on thread end, & cetyl alcohol lube per Hi-Shear Spec. 305.
- HST415CF(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, (.00015-.00045 thick), with color black on thread end.
- HST415CZ(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305, with color black on thread end.
- HST415RP(-)(-) = Phosphate fluoride treat with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST415SY(-)(-) = Phosphate fluoride treat and solid film lube per AS5272, Type I.
- HST415TA(-)(-) = Ti-Shield III, Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST415TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST415UT(-)(-) = Ti-Shield III, Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
- HST415UV(-)(-) = 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.

- HST415KM(-)(-) = 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.
- HST415WF(-)(-) = 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.
- HST415VV(-)(-) = 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.
- HST415GD(-)(-) = Hi-Kote 1 aluminum pigmented coating on threads only per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST415GM(-)(-) = 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 end, and cetyl alcohol lube per Hi-Shear Spec. 305.

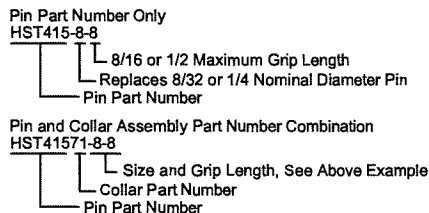
SPECIFICATION:

Hi-Lite Product Specification 380.

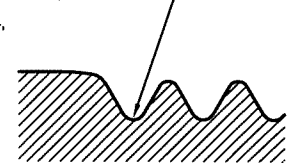
CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which this HST415 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLES:



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



VIEW A

HI-LITE THREAD TRANSITION AREA SEE SPECIFICATION FOR INSPECTION

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.		TITLE HI-LITE® ST™ PIN
DRAWN D.P.S.	DATE 8-1-86	130° FLUSH CROWN SHEAR HEAD TITANIUM 1/16" GRIP VARIATION, 1/64" OVERSIZE
APPROVED E.E. Beeles	DATE 9-9-86	DRAWING NUMBER HST415
REVISION 5	DATE J.F. Obispo 11-10-09	