

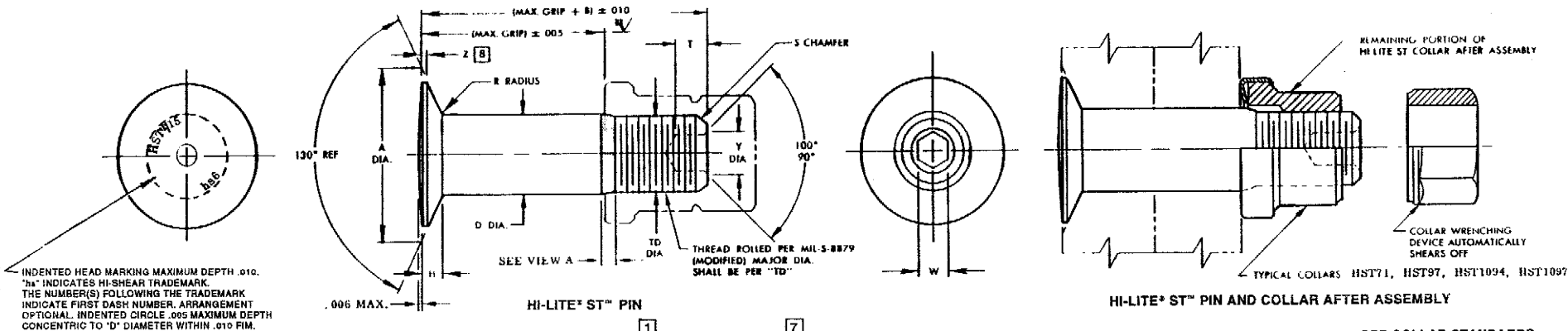
**hi-shear**  
CORPORATION

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\*CAGE\* = Commercial And Government Entity

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197  
A GFI Aerospace Company  
AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) CAGE No. 06725  
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878  
HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee) CAGE No. 0LB68  
A GFI Aerospace Company

HUCK INTERNATIONAL Gmbh & Co. Germany (Licensee-EEC Countries)  
SIMMONDS S.A. France (Licensee-EEC Countries-Collars)  
Blanc Aero S.A. France (Licensee-EEC Countries)  
TOKYO SCREW COMPANY, Japan (Licensee-Japan)  
941103



FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA AFTER FINISH	TD DIA.	F REF.	H REF.	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX.	T DEPTH	Y DIA.		
6	13/64	.3911 .3825	.300	.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 .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 .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 .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 .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

INDENTED HEAD MARKING MAXIMUM DEPTH .010.  
"hi" INDICATES HI-SHEAR TRADEMARK.  
THE NUMBER(S) FOLLOWING THE TRADEMARK  
INDICATE FIRST DASH NUMBER. ARRANGEMENT  
OPTIONAL. INDENTED CIRCLE .005 MAXIMUM DEPTH  
CONCENTRIC TO "D" DIAMETER WITHIN .010 FIM.

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" is 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.

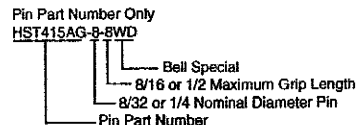
CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST415WD oversize pin replaces.  
Second dash number indicates maximum grip in 1/16ths. See finish notes for explanation of finish code letters.

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



VIEW A  
HI-LITE THREAD TRANSITION AREA.  
SEE SPECIFICATION FOR INSPECTION.

HOW TO ORDER  
EXAMPLES:



MATERIAL: 6Al-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HST415AG-(-)(J)WD = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 380.

U.S. Patents 4,326,825; 4,485,510 and 4,957,401.  
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 J. Henderson 6-23-99	TITLE <b>HI-LITE® ST™ PIN</b> 130° FLUSH CROWN SHEAR HEAD TITANIUM 1/16" GRIP VARIATION 1-64" OVERSIZE
APPROVED DATE <i>[Signature]</i> 6-30-99	DRAWING NUMBER <b>HST415WD</b>
REVISION DATE	

HST415WD