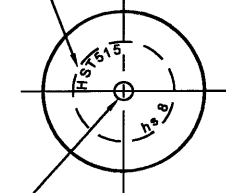


**hi-shear**  
CORPORATION

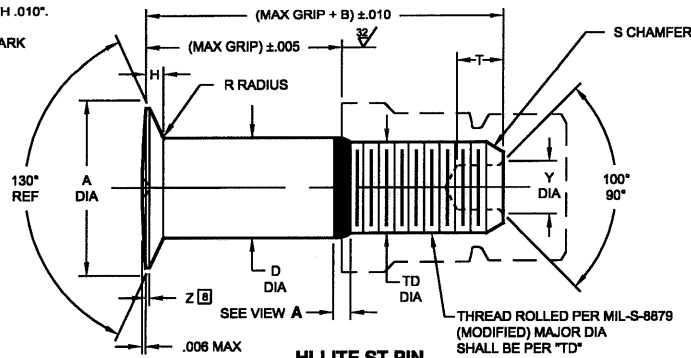
2600 Skypark Drive  
Torrance, California 90509 U.S.A.  
Telephone (310) 326-8110  
FAX (310) 784-4144

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197  
a GFI AEROSPACE Company  
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada) CAGE No. 06725  
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 98678  
FAIRCHILD - SIMMONDS S.A. France (Licensee) CAGE No. 92215  
HI-SHEAR FASTENERS EUROPE, LTD., U.K. (Licensee) CAGE No. 0LB88  
a GFI AEROSPACE Company  
BLANC AERO S.A. France (Licensee - ECC Countries)  
a GFI AEROSPACE Company  
TOKYO SCREW COMPANY, Japan (Licensee - Japan)

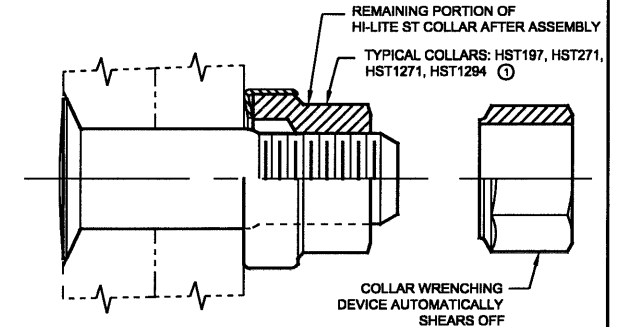
INDENTED HEAD MARKING MAXIMUM DEPTH .010".  
"hs" INDICATES HI-SHEAR TRADEMARK.  
THE NUMBER(S) FOLLOWING THE TRADEMARK  
INDICATES FIRST DASH NUMBER.  
ARRANGEMENT OPTIONAL.



INDENTED CIRCLE .005 MAXIMUM DEPTH.  
CONCENTRIC TO "D" DIAMETER WITHIN  
.010 FIM.



HI-LITE ST PIN



HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

REMAINING PORTION OF  
HI-LITE ST COLLAR AFTER ASSEMBLY  
TYPICAL COLLARS: HST197, HST271,  
HST1271, HST1294 ①

COLLAR WRENCHING  
DEVICE AUTOMATICALLY  
SHEARS OFF

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA AFTER FINISH	TD DIA	F REF	H	R RAD	Z MAX	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												W HEX	T DEPTH	Y DIA		
6	7/32	.4198 .4112	.300	.2182 .2172	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,100	2,000
8	9/32	.5423 .5337	.330	.2807 .2797	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	11,800	3,700
10	11/32	.6349 .6263	.390	.3432 .3422	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	17,800	5,000
12	13/32	.7402 .7316	.430	.4057 .4047	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	24,600	7,200
14	15/32	.8838 .8731	.495	.4682 .4672	.4310 .4260	.009	.0969 .0944	.050 .040	.015	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	32,700	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.
  - Curved or flat edge manufacturer's option.

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

**HEAT TREAT:** 95,000 psi shear minimum.

**FINISH:** HST515AG(-)JWD = 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.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HST515WD 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  
HST515AG8-8WD  
Bell Special  
8/16 or 1/2 Maximum Grip Length  
Replaces 8/32 or 1/4 Nominal Diameter Pin  
Pin Part Number

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.

DRAWN J.R.H.	DATE 6-29-99	TITLE <b>HI-LITE® ST™ PIN</b>
APPROVED M.C.	DATE 7-1-99	130° FLUSH CROWN SHEAR HEAD TITANIUM 1/16" GRIP VARIATION, 1/32" OVERSIZE
REVISION ①	DATE J.F. Obispo 6-26-00	DRAWING NUMBER <b>HST515WD</b>

HST515WD