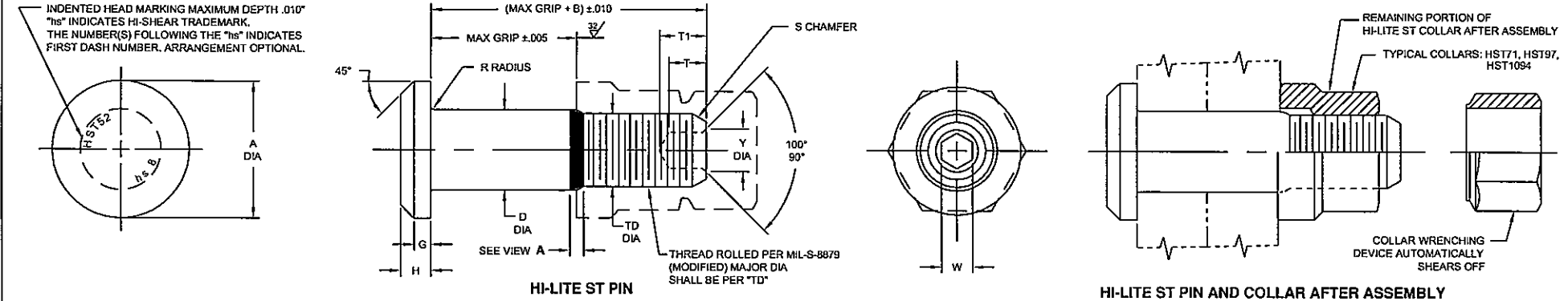


Hi-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE Code. 73187	LISI AEROSPACE FRANCE (Licensee) CAGE Code. F0188
a Lisi Aerospace Company	a Lisi Aerospace Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada) CAGE Code. 06725	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE Code. U6300
a Lisi Aerospace Company	a Lisi Aerospace Company
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE Code. 56876	FT BESTAS, Izmer (Licensee) CAGE Code. T0802
a Lisi Aerospace Company	a Lisi Aerospace Company
MINEBEA CO., LTD. Japan (Licensee-Japan) CAGE Code. 58962	LISI AEROSPACE CANADA (Licensee) CAGE Code. L4528
	a Lisi Aerospace Company

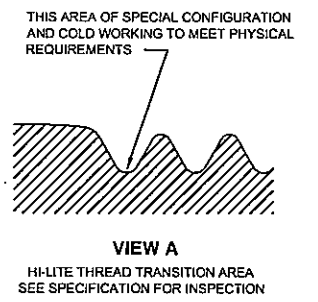


FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA			TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM	WITH COATING OR SOLID FILM								W HEX	T DEPTH	Y DIA		
5	5/32	.262 .242	.280	.1635 .1630	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015		1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	5	5,280	2,200
6	3/16	.315 .295	.290	.1895 .1890	.1895 .1885	.1840 .1810	.025	.055 .045	.025 .015		1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,060	3,000
8	1/4	.412 .387	.320	.2495 .2490	.2495 .2485	.2440 .2410	.030	.069 .059	.025 .015		1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	12,260	5,100
10	5/16	.505 .475	.380	.3120 .3115	.3120 .3110	.3060 .3020	.035	.078 .068	.030 .020		3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	19,160	8,000
12	3/8	.600 .565	.420	.3745 .3740	.3745 .3735	.3680 .3640	.040	.088 .078	.030 .020		3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	27,600	11,300
14	7/16	.676 .641	.485	.4370 .4365	.4370 .4360	.4310 .4260	.045	.105 .093	.030 .020		3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	37,500	15,500
16	1/2	.770 .735	.525	.4995 .4990	.4995 .4985	.4930 .4880	.055	.116 .103	.030 .020		3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	49,100	20,000

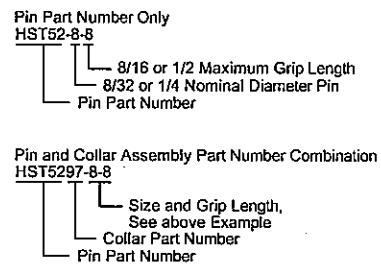
SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIM.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
- [5] Evidence of broken edges across points.

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 EXAMPLE:



MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum (210,000 psi tensile minimum).

- FINISH:**
- HST52(-)(-) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST52AC(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 with color code green on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST52AG(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 with color code orange on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST52AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST52TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 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 international patents pending. "Hi-Lite" and "HST" are registered trademarks and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.		
DRAWN D.P.S.	DATE 5-20-88	TITLE HI-LITE® ST™ PIN
APPROVED E.E.Beeles	DATE 5-23-88	PROTRUDING SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION
REVISION 10	DATE L.G.Valencia 03-18-08	DRAWING NUMBER HST52

HST52