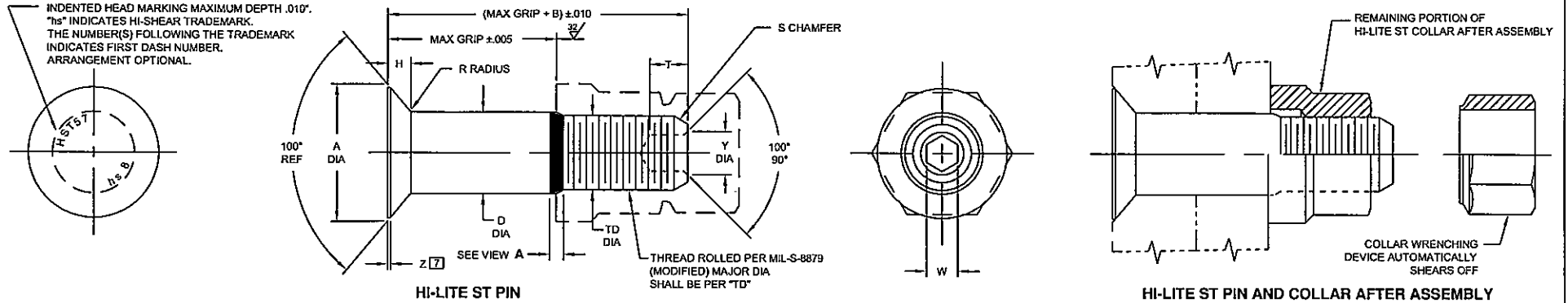


HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE Code. 73197	LISI AEROSPACE FRANCE (Licensee) CAGE Code. F0188
a Lisi Aerospace Company	a Lisi Aerospace Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada) CAGE Code. 06725	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE Code. U6300
a Lisi Aerospace Company	a Lisi Aerospace Company
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE Code. 56878	FT BESTAS, Izmir (Licensee) CAGE Code. T0602
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	a Lisi Aerospace Company

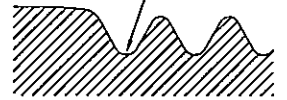
INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER.
ARRANGEMENT OPTIONAL.



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		
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	.0801 .0791	.100 .080	.080	5,280	1,700
6	3/16	.3016 .2966	.290	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,060	2,600
8	1/4	.3948 .3898	.320	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	12,260	4,400
10	5/16	.4739 .4689	.380	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	19,160	6,800
12	3/8	.5604 .5554	.420	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	27,600	9,500
14	7/16	.6680 .6620	.485	.4370 .4365	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	37,500	12,500
16	1/2	.7540 .7480	.525	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	49,100	TBD
18	9/16	.8380 .8310	.600	.5615 .5610	.5615 .5605	.5550 .5500	.010	.1160 .1131	.050 .040	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	62,100	TBD
20	5/8	.9250 .9180	.660	.6240 .6235	.6240 .6230	.6180 .6120	.010	.1260 .1230	.050 .040	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	76,700	TBD
24	3/4	1.0970 1.0850	.895	.7490 .7485	.7490 .7480	.7430 .7370	.012	.1460 .1410	.050 .040	.022	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	110,400	TBD

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

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



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

- 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.
 - Evidence of broken edge across points.
 - Broach petals removed.

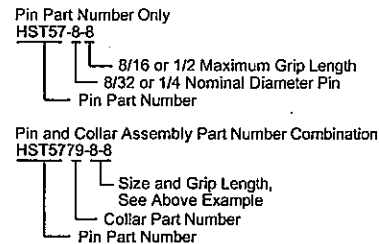
CODE: First dash number indicates nominal diameter in 1/32nds.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

MATERIAL: Nickel base alloy per AMS5662.
HEAT TREAT: 125,000 psi shear minimum.

- FINISH:**
- HST57(-)(-) = Passivate per Hi-Shear 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST57AC(-)(-) = 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.
 - HST57AG(-)(-) = 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.
 - HST57AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST57DU(-)(-) = Solid film lube per AS5272, Type I.
 - HST57MA(-)(-) = Solid film lube per KALGARD RA.
 - HST57TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST57TP(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 380.

HOW TO ORDER EXAMPLE:



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 Dept. 104	DATE 03-10-94
APPROVED E.E.B.	DATE 3-16-94
REVISION 8	DATE L.G.Valencia 03-18-08
TITLE HI-LITE® ST™ PIN 100° FLUSH SHEAR HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION DRAWING NUMBER HST57	