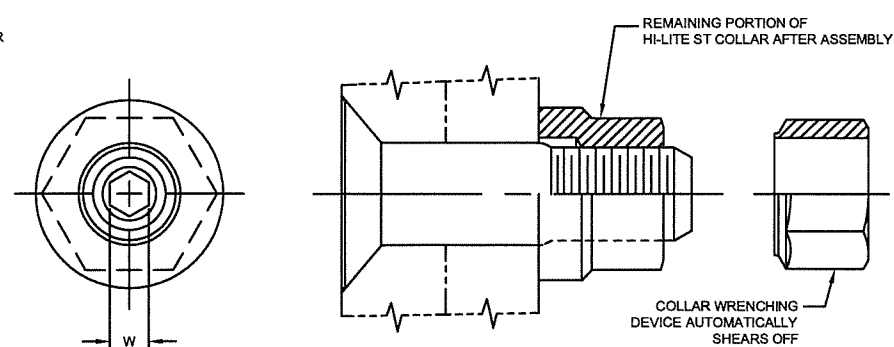
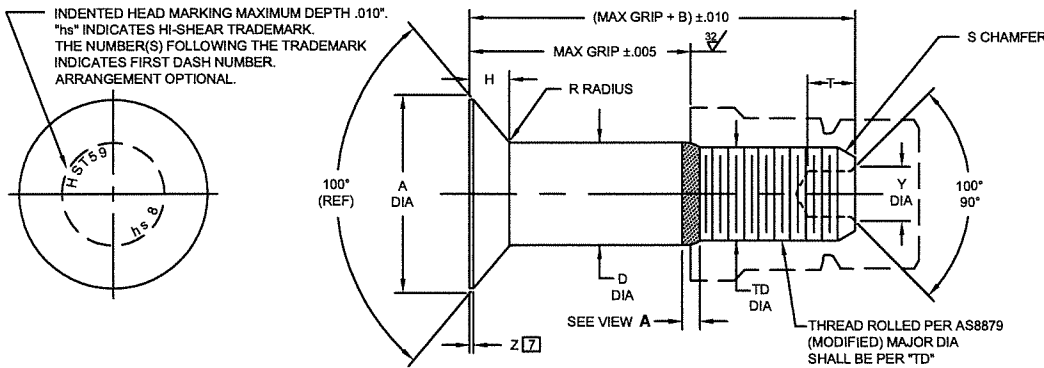


HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE Code. 73197	LISI AEROSPACE FRANCE (Licensee) CAGE Code. F0188
a Lisi Aerospace Company	a Lisi Aerospace Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A & Canada) CAGE Code. 06725	BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE Code. U6300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



HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

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

HI-LITE ST PIN

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	.3304 .3256	.280	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0700 .0680	.025 .015	.012	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	8	5,280	2,940
6	3/16	.3813 .3765	.290	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0805 .0785	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,060	4,350
8	1/4	.5066 .5018	.320	.2495 .2490	.2495 .2485	.2440 .2410	.006	.1080 .1060	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	12,260	7,750
10	5/16	.6335 .6287	.380	.3120 .3115	.3120 .3110	.3060 .3020	.007	.1350 .1330	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	19,160	12,300
12	3/8	.7604 .7556	.420	.3745 .3740	.3745 .3735	.3680 .3640	.008	.1620 .1600	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	27,600	19,100
14	7/16	.8884 .8812	.500	.4370 .4365	.4370 .4360	.4310 .4260	.009	.1895 .1865	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	37,500	25,800
16	1/2	1.0139 1.0068	.600	.4995 .4990	.4995 .4985	.4930 .4880	.010	.2160 .2130	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	49,100	34,300
18	9/16	1.1408 1.1337	.700	.5615 .5610	.5615 .5605	.5550 .5500	.010	.2430 .2400	.050 .040	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	62,100	43,500
20	5/8	1.2723 1.2651	.780	.6240 .6235	.6240 .6230	.6180 .6120	.010	.2720 .2690	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.326 .306	76,700	54,600
24	3/4	1.5308 1.5236	1.020	.7490 .7485	.7490 .7480	.7430 .7370	.012	.3280 .3250	.050 .040	.025	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.330 .300	.398 .378	110,400	79,200
28	7/8	1.7845 1.7773	1.160	.8740 .8735	.8740 .8730	.8680 .8610	.014	.3820 .3790	.050 .040	.025	5/64" x 45°	7/8-14UNJF-3A Modified	.3820 .3780	.400 .370	.471 .451	150,300	117,000
32	1	2.0405 2.0310	1.305	.9990 .9985	.9990 .9980	.9930 .9860	.014	.4370 .4330	.050 .040	.025	5/64" x 45°	1-12UNJF-3A Modified	.5100 .5040	.520 .490	.618 .598	196,300	143,000

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 Dept. 104	DATE 03-11-94	TITLE HI-LITE® ST™ PIN
APPROVED E.E.B.	DATE 3-16-94	100° FLUSH MS24694 TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION
REVISION (10)	DATE L.Valencia 11-17-10	DRAWING NUMBER HST59

HST59

- GENERAL NOTES:**
1. Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 3. "H" is dimensioned from maximum "D" diameter.
 4. Dimensions to be met after finish.
 5. Surface texture per ANSI B46.1.
 6. Hole preparation per NAS618.
 7. Curved or flat edge manufacturer's option.
 8. Evidence of broken edge across points.
 9. Broach petals removed.

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

- FINISH:**
- HST59(-)(-) = Passivate per Hi-Shear 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST59AC(-)(-) = Hi-Kote 1 aluminum pigmented coating per Hi-Shear Spec. 294 with color code green on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST59AG(-)(-) = Hi-Kote 1 aluminum pigmented coating per Hi-Shear Spec. 294 with color code orange on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST59AP(-)(-) = Hi-Kote 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HST59DU(-)(-) = Solid film lube per AS5272, Type I.
 - 10. HST59GM(-)(-) = 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.
 - 9. HST59MA(-)(-) = Solid film lube per Kalgard RA.
 - HST59TB(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per HST59TP(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 with color code orange on HST59GD(-)(-) = Hi-Kote 1 aluminum pigmented coating on threads only per Hi-Shear Spec. 294

SPECIFICATION: Hi-Lite Product Specification 380.

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:**

