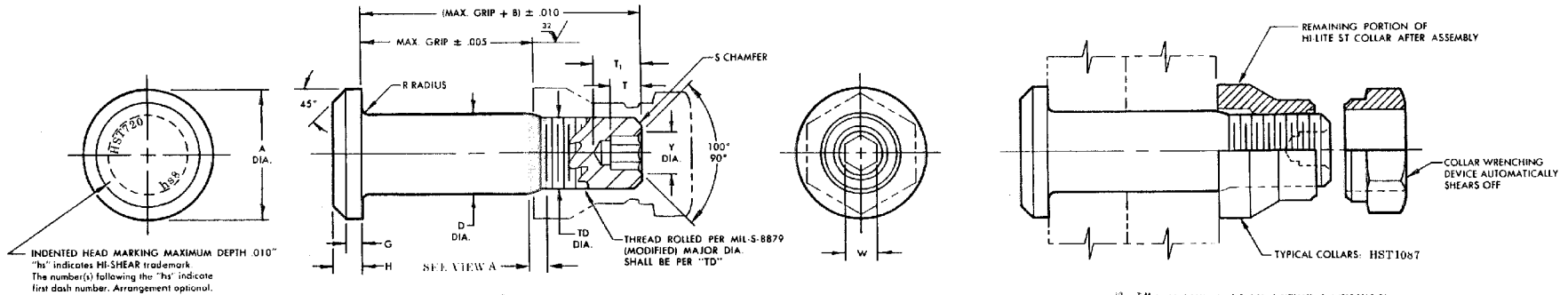


hi-shear
CORPORATION

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

CAGE = Commercial And Government Entity

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197	KAMAX-WERKE Germany (Licenses-EEC Countries) Rudolph Kellerman GmbH & Co.
Division of Hi-Shear Industries, Inc., U.S.A.	
AIR INDUSTRIES CO., INC. (License - U.S. & Canada) CAGE No. 06725	SIMMONDS S.A. France (License-EEC Countries-Gulfair)
SPS TECHNOLOGIES, U.S.A. (Licensees) CAGE No. 56878	SI-CHAUMOND GRANAT S.A. France (License-EEC Countries)
HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensees) CAGE No. 08864	TOKYO SCREW COMPANY, Japan (Licensee-Japan)
Division of Hi-Shear Industries, Inc., U.S.A.	



HI-LITE[®]ST[™] PIN

HI-LITE[®]ST[™] PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	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
											W HEX.	T DEPTH MIN.	L DEPTH		
-5	5/32	.322 .306	.280	.1635 .1570	.1595 .1570	.030	.065 .055	.025 .015	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.080	.135	.119 .104	4,560 3,850
-6	3/16	.377 .357	.290	.1895 .1810	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.080	.135	.119 .104	6,125 3,850
-8	1/4	.440 .415	.320	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0847	.090	.160	.142 .122	10,600 6,550
-10	5/16	.505 .475	.380	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.110	.200	.180 .160	16,600 10,350
-12	3/8	.600 .565	.420	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.140	.235	.217 .197	23,900 15,750
-14	7/16	.676 .641	.485	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.170	.275	.253 .233	32,500 21,200
-16	1/2	.770 .735	.525	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.200	.315	.289 .269	42,400 28,900
-18	9/16	.877 .842	.600	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.240	.365	.326 .306	53,700 36,400
-20	5/8	.953 .918	.640	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.240	.365	.326 .306	66,300 46,100
-24	3/4	1.150 1.110	.895	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.300	.465	.388 .378	95,400 66,900
-28	7/8	1.330 1.290	1.000	.8740 .8730	.8680 .8610	.250	.385 .370	.050 .035	5/64" x 45°	7/8-14UNJF-3A Modified	.3820 .3780	.370	.608	.471 .451	129,000 93,000
-32	1	1.510 1.470	1.160	.9990 .9980	.9930 .9860	.300	.435 .420	.060 .045	5/64" x 45°	1-12UNJF-3A Modified	.5100 .5050	.490	.770	.618 .598	168,500 120,500
-36	1-1/8	1.695 1.655	1.305	1.1240 1.1230	1.1170 1.1100	.350	.490 .475	.070 .055	5/64" x 45°	1-1/8-12UNJF-3A Modified	.5725 .5675	.550	.850	.693 .673	214,000 153,800

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.

- ① GENERAL NOTES:
- Concentricity: "A" to "D" diameter within .010 FIR.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B48.1.
 - Hole preparation per NAS618.
 - Evidence of broken edge across points.
 - Use HST764 for oversize replacement.

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5026 or MIL-S-6049.

HEAT TREAT: 180,000-200,000 psi tensile per Spec. MIL-H-6875.

- FINISH: HST720-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, with color code black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST720BJ-()-() = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST720BL-()-() = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, with color black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST720CC-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, with color green 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.
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
HST720-8-8
—8/16 or 1/2 Maximum Grip Length
—8/32 of 1/4 Nominal Diameter Pin
—Pin Part Number with Type II Cadmium Plate
- Pin and Collar Assembly Part Number Combination
HST7201087-8-8
—Size and Grip Length. See Above Example
—Collar Part Number
—Pin Part Number

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	TITLE
D. P. S.	2-22-83	HI-LITE [®] ST [™] PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16" GRIP VARIATION
APPROVED	DATE	DRAWING NUMBER
<i>R. King</i>	2-22-83	HST720
REVISION	DATE	
12	T. Craine 1-25-93	