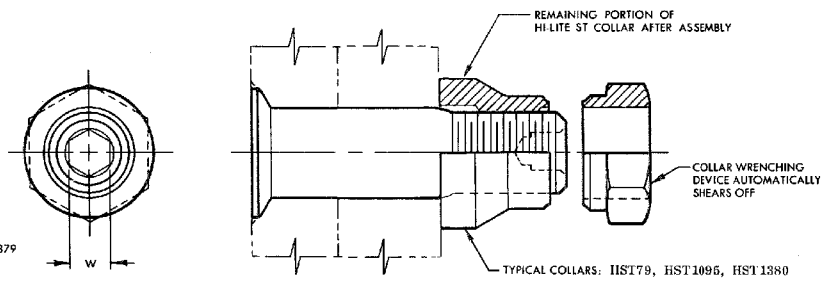
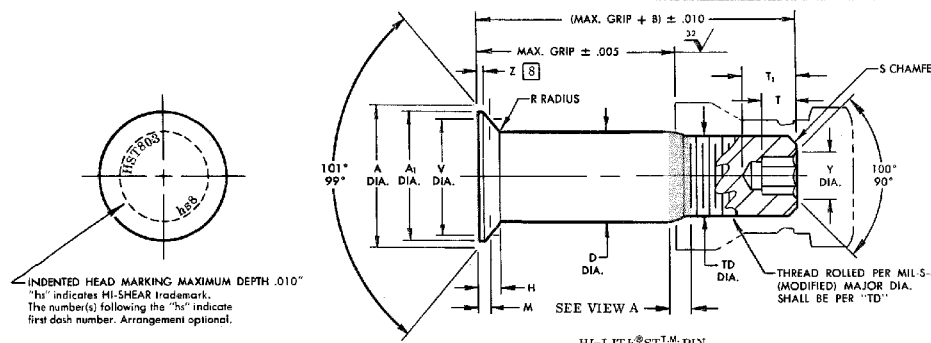


hi-shear
CORPORATION

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CAGE = Commercial And Government Entity

HI-SHEAR CORPORATION U.S.A. (Patent Holder).....CAGE No. 73197	KAWAL-WERKE Germany (Licensee-EEC Countries)
Division of HI-Shear Fasteners, Inc., U.S.A.	Shelbyville, Kentucky GMDH & Co.
AIR INDUSTRIES CO., INC. (Licensee).....CAGE No. 93725	SIMMONDS S.A. France (Licensee-EEC Countries-Collar)
SPS TECHNOLOGIES U.S.A. (Licensee).....CAGE No. 58879	St.-CHAMOND GRANAT S.A. France (Licensee-EEC Countries)
HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee).....CAGE No. 01809	TOKYO SCREW COMPANY, Japan (Licensee-Japan)



HI-LITE[®] ST[™] PIN

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

FIRST DASH NO.	NOM. DIA.	A DIA. MAX.	A1 DIA. MIN.	S REF.	D DIA.	TD DIA.	F	H REF.	M GAGE PROT.	R ROLD. Cold-Worked	V GAGE DIA.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION - TENSION POUNDS MAXIMUM
															W HEX.	T DEPTH MIN.	T DEPTH MAX.	Y DIA.			
-5	5/32	.2827	.260	.280	.1635 .1625	.1595 .1570	-.004	.049	-.0330 -.0298	.025 .015	.2029 .2026	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.080	.135	.119 .104	4,560	1,850	620
-6	3/16	.3277	.293	.290	.1895 .1885	.1840 .1810	-.005	.056	-.0295 -.0263	.030 .020	.2560 .2558	.015	1/32" x 45°	10-32UNJF-3A Modified	.0808 .0791	.080	.135	.142 .122	6,125	2,600	910
-8	1/4	.4283	.394	.320	.2495 .2485	.2440 .2410	-.006	.074	-.0227 -.0195	.030 .020	.3732 .3730	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.090	.160	.180 .160	10,600	5,000	1,750
-10	5/16	.5361	.501	.380	.3120 .3110	.3060 .3020	-.007	.092	-.0234 -.0198	.040 .030	.4791 .4789	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.110	.200	.180 .160	16,600	7,500	2,625
-12	3/8	.6415	.607	.420	.3745 .3735	.3680 .3640	-.008	.110	-.0295 -.0259	.040 .030	.5698 .5696	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.140	.235	.217 .197	23,900	11,000	3,850
-14	7/16	.7425	.691	.485	.4370 .4360	.4310 .4260	-.009	.126	-.0347 -.0307	.050 .040	.6582 .6580	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1938 .1895	.170	.275	.253 .233	32,500	14,300	5,000
-16	1/2	.8423	.791	.525	.4995 .4985	.4930 .4880	-.010	.142	-.0504 -.0464	.050 .040	.7200 .7198	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.200	.315	.289 .269	42,400	19,800	6,930
-18	9/16	.9300	.881	.600	.5615 .5605	.5550 .5500	-.010	.153	-.0533 -.0485	.050 .040	.8012 .8010	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.240	.365	.326 .306	53,700	24,600	8,600
-20	5/8	1.0440	.995	.640	.6240 .6230	.6180 .6120	-.010	.174	-.0633 -.0589	.050 .040	.8902 .8900	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.240	.365	.326 .306	66,300	31,000	10,850
-24	3/4	1.3000	1.251	.885	.7490 .7480	.7430 .7370	-.012	.229	-.0776 -.0716	.050 .040	1.1124 1.1122	.022	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.300	.465	.398 .378	95,400	48,000	16,800
-28	7/8	1.5091	1.461	1.000	.8740 .8730	.8680 .8610	-.014	.263	-.0694 -.0622	.050 .040	1.3440 1.3438	.022	5/64" x 45°	7/8-14UNJF-3A Modified	.3829 .3780	.370	.608	.471 .451	129,000	65,000	22,750
-32	1	1.7201	1.671	1.160	.9990 .9980	.9930 .9860	-.014	.298	-.0617 -.0536	.050 .040	1.5732 1.5730	.022	5/64" x 45°	1-12UNJF-3A Modified	.5100 .5040	.490	.770	.618 .598	168,500	85,000	29,750
-36	1-1/8	1.9350	1.887	1.305	1.1240 1.1230	1.1170 1.1100	-.015	.340	-.0560 -.0475	.060 .050	1.8026 1.8024	.022	5/64" x 45°	1-1/8-12UNJF-3A Modified	.5732 .5675	.550	.850	.693 .673	214,000	109,500	38,000

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH IPIN 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 FIR.
- "H" is dimensioned from maximum "D" diameter.
- Dimensions in inches and to be met after finish.
- Surface texture per ANSI B46.1.
- Recommended standard for hole preparation NAS618.
- Fatigue test pins having grip equal two diameters or longer using these leads at R = 0.1.
- Curved or flat edge manufacturer's option.
- Evidence of broken edges across points.
- Use HST823 for oversize replacement.

MATERIAL: Alloy steel per MIL-S-5000, MIL-S-5626 or MIL-S-6049.
HEAT TREAT: 108,000 psi shear minimum (180,000-200,000 psi tensile per MIL-H-6875).
FINISH: HST803-()-() = 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.
HST803BJ-()-() = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST803CE-()-() = I.V.D. aluminum coating per MIL-C-83488, Type II (.00015-.00045 thick), with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST803CG-()-() = 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.

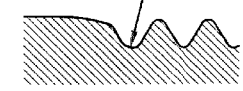
SPECIFICATION: Hi-Lite Product Specification 380.

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
HST803-8-8
8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Pin Part Number with Type II Cadmium Plate
Pin and Collar Assembly Part Number Combination
HST80379-8-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

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



VIEW A HI-LITE THREADED TRANSITION AREA. SEE SPECIFICATION FOR INSPECTION.

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 D. P. S. 2-18-83	TITLE HI-LITE[®] ST[™] PIN 100° FLUSH SPECIAL SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION
APPROVED DATE <i>[Signature]</i> 2-22-83	DRAWING NUMBER HST803
REVISION DATE 13 T. Craine 1-25-93	

HST803