

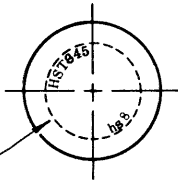
hi-shear
CORPORATION

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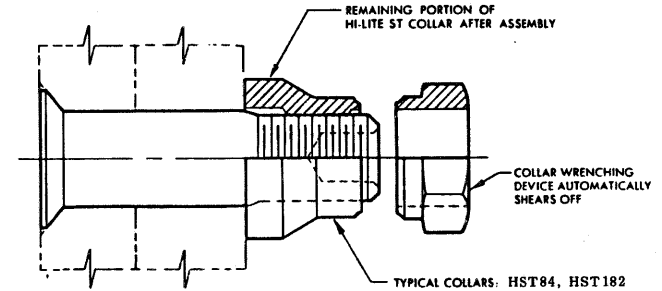
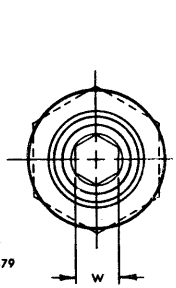
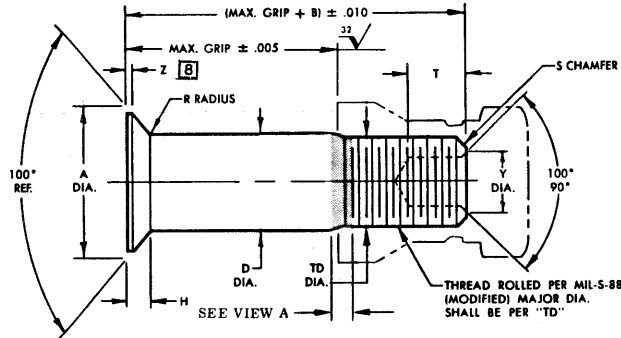
"CAGE" = Commercial And Government Entity

HI-SHEAR CORPORATION, U.S.A. (Patent Holder).....CAGE No. 73197
Division of Hi-Shear Industries, Inc., U.S.A.
AIR INDUSTRIES CO., INC. (Licensee-U.S.A. & Canada).....CAGE No. 06725
SPS TECHNOLOGIES, U.S.A. (Licensee)CAGE No. 56878
HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee).....CAGE No. OLB88
Division of Hi-Shear Industries, Inc., U.S.A.

HUCK INTERNATIONAL Gmbh & Co. Germany
.....(Licensee - EEC Countries)
SIMMONDS S.A. France.....(Licensee - EEC Countries-Collars)
St.-CHAMOND GRANAT S.A. France.(Licensee - EEC Countries)
TOKYO SCREW COMPANY, Japan.....(Licensee-Japan)



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



① HI-LITE ST PIN ② HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA. ⑦		TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM LUBE	AFTER COATING OR SOLID FILM LUBE								W HEX.	T DEPTH	Y DIA.		
5	5/32																
NOTE: USE HST745-6-()																	
6	7/32	.3307 .3253	.300	.2182 .2172	.2182 .2172	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	9,400	2,600
8	9/32	.4260 .4210	.330	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	15,500	4,400
10	11/32	.5051 .5001	.390	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	23,200	7,000
12	13/32	.5916 .5866	.430	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	32,400	10,000
14	15/32	.6992 .6932	.495	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0970 .0945	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	43,100	12,500
16	17/32	.7852 .7792	.535	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1070 .1045	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	55,400	18,000

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.

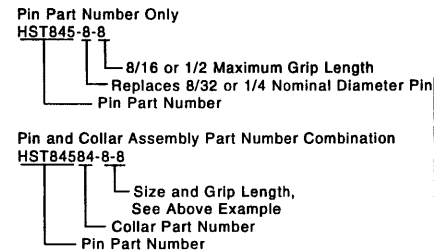
GENERAL NOTES:

- Head edge out of roundness shall not exceed "F".
- Concentricity: Conical surface of head to "D" diameter within .005 FIR.
- "H" is dimensioned from maximum "D" diameter.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Maximum "D" diameter may be increased by .0002 to allow for solid film application.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HST845 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLES:



MATERIAL:
HEAT TREAT:
FINISH:

- HST845-(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
① HST845AP-(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
HST845DU-(-)(-) = Solid film lube per MIL-L-46010, Type I.
HST845TB-(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
HST845TP-(-)(-) = 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.

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. 1-20-88

APPROVED DATE
E.E.Beeles 1-25-88

TITLE
HI-LITE[®]ST[™] PIN
100° FLUSH SHEAR HEAD
PH13-8Mo STAINLESS STEEL
1/16" GRIP VARIATION, 1/32" OVERSIZE

REVISION DATE
① J.F.Obispo 08-28-95

DRAWING NUMBER
HST845

HST845