

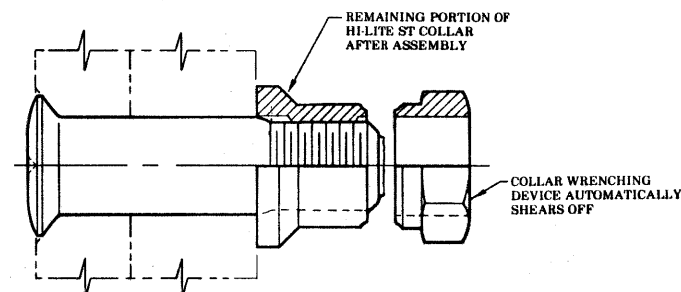
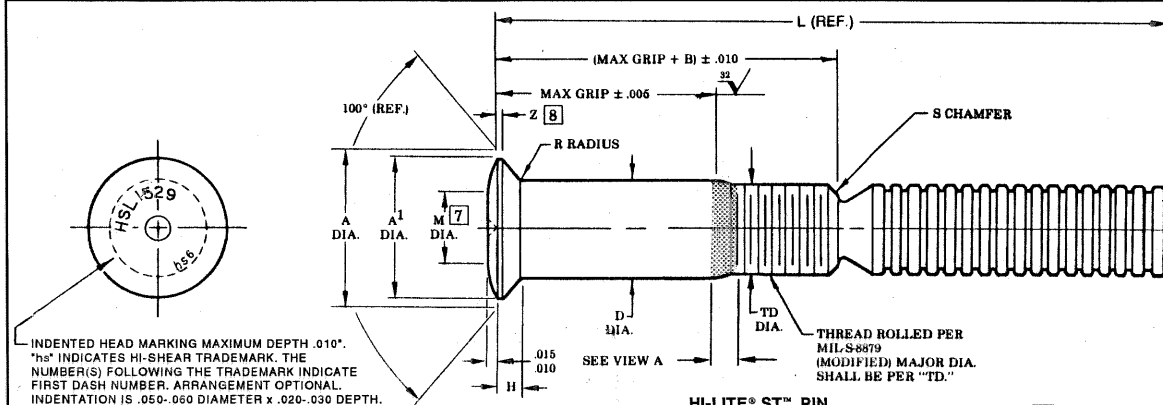
hi-shear
CORPORATION

2600 Skypark Drive
Torrance, California 90509 U.S.A.
Telephone (310) 326-8110
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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. & Canada) CAGE No. 06725
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878
HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee) CAGE No. 0LB68
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)
941103



FIRST DASH NO.	NOM. DIA.	A DIA.	A' DIA.	B REF.	D DIA BEFORE FINISH	TD DIA.	F	H	K MAX	M DIA. FLAT	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
5	5/32	.2922 .2874	.285 .273	.312	.1694 .1690	.1595 .1570	.004	.0515 .0495	.013	.140 .120	.025 .015	.010	1/32" x 37°	8-32UNJC-3A Modified	4,600 4,010	1,730
6	3/16	.3536 .3486	.346 .334	.325	.1954 .1950	.1840 .1810	.005	.0664 .0643	.016	.155 .135	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	6,200 5,380	2,590
8	1/4	.4732 .4682	.466 .454	.395	.2554 .2550	.2440 .2410	.006	.0914 .0893	.021	.200 .180	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	10,600 9,300	4,760
10	5/16	.5619 .5569	.555 .542	.500	.3179 .3175	.3060 .3020	.007	.1024 .1003	.026	.265 .245	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	16,600 14,600	7,100
12	3/8	.6912 .6862	.684 .672	.545	.3804 .3800	.3680 .3640	.008	.1304 .1283	.030	.325 .300	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	23,900 21,000	10,600
14	7/16	.8041 .7969	.797 .772	.635	.4429 .4425	.4310 .4260	.009	.1515 .1485	.035	.380 .355	.050 .040	.022	3/64" x 37°	7/16-20UNJF-3A Modified	32,500 28,600	14,450
16	1/2	.9166 .9095	.910 .885	.685	.5054 .5050	.4930 .4880	.010	.1725 .1695	.039	.445 .415	.050 .040	.022	3/64" x 37°	1/2-20UNJF-3A Modified	42,400 37,300	19,550

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN 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 to be met after finish, except as noted.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Flat permissible within "M" diameter.
- Curved or flat edge manufacturer's option.
- Use HSL1629 for oversize replacement.
- Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
- "D" diameter may increase by .001 after application of finish.
- Shorter or longer grips than those listed may be available as specials.

MATERIAL: 6Al-4V titanium alloy per Spec. AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HSL1529DL-(-) = Kalgard FA or EM620C solid film lube per MIL-L-46010, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.
HSL1529AP-(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

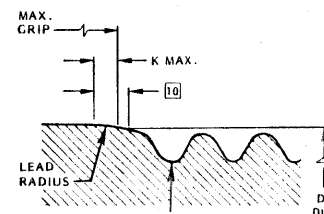
SPECIFICATION: Hi-Lite Product Specification 380-2.

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
HSL1529DL-8-8
8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Pin Part Number



VIEW A
HI-LITE THREAD TRANSITION AREA. THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS. 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 J.F.Obispo	DATE 4-11-95	TITLE HI-LITE® ST™ PIN 100° FLUSH CROWN (MS20426) HEAD TITANIUM SPECIAL THREAD AND SHANK 1/16" GRIP VARIATION
APPROVED J. Ramirez	DATE 2/24/96	DRAWING NUMBER HSL1529
REVISION	DATE	

Sheet 1 of 2

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SECOND DASH NO.	L REF.										
	-5	-6	-8	-10	-12	-14	-16				
1	-	-	-	-	-	-	-				
2	.835	.955	.940	-	-	-	-				
3	.960	1.080	1.065	1.185	-	-	-				
4	1.085	1.205	1.190	1.310	1.300	-	-				
5	1.210	1.330	1.315	1.435	1.425	-	-				
6	1.335	1.455	1.440	1.560	1.550	1.655	1.645				
7	1.460	1.580	1.565	1.685	1.675	1.780	1.770				
8	1.585	1.705	1.690	1.810	1.800	1.905	1.895				
9	1.710	1.830	1.815	1.935	1.925	2.030	2.020				
10	1.835	1.955	1.940	2.060	2.050	2.155	2.145				
11	1.960	2.080	2.065	2.185	2.175	2.280	2.270				
12	2.085	2.205	2.190	2.310	2.300	2.405	2.395				
13	2.210	2.330	2.315	2.435	2.425	2.530	2.520				
14	2.335	2.455	2.440	2.560	2.550	2.655	2.645				
15	2.460	2.580	2.565	2.685	2.675	2.780	2.770				
16	2.585	2.705	2.690	2.810	2.800	2.905	2.895				
17	2.710	2.830	2.815	2.935	2.925	3.030	3.020				
18	2.835	2.955	2.940	3.060	3.050	3.155	3.145				
19	2.960	3.080	3.065	3.185	3.175	3.280	3.270				
20	3.085	3.205	3.190	3.310	3.300	3.405	3.395				
21	-	3.330	3.315	3.435	3.425	3.530	3.520				
22	-	3.455	3.440	3.560	3.550	3.655	3.645				
23	-	3.580	3.565	3.685	3.675	3.780	3.770				
24	-	3.705	3.690	3.810	3.800	3.905	3.895				
25	-	-	-	3.935	3.925	4.030	4.020				
26	-	-	-	4.060	4.050	4.155	4.145				
27	-	-	-	4.185	4.175	4.280	4.270				
28	-	-	-	4.310	4.300	4.405	4.395				
29	-	-	-	-	-	4.530	4.520				
30	-	-	-	-	-	4.655	4.645				
31	-	-	-	-	-	4.780	4.770				
32	-	-	-	-	-	4.905	4.895				

DRAWING NUMBER

HSL1529

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