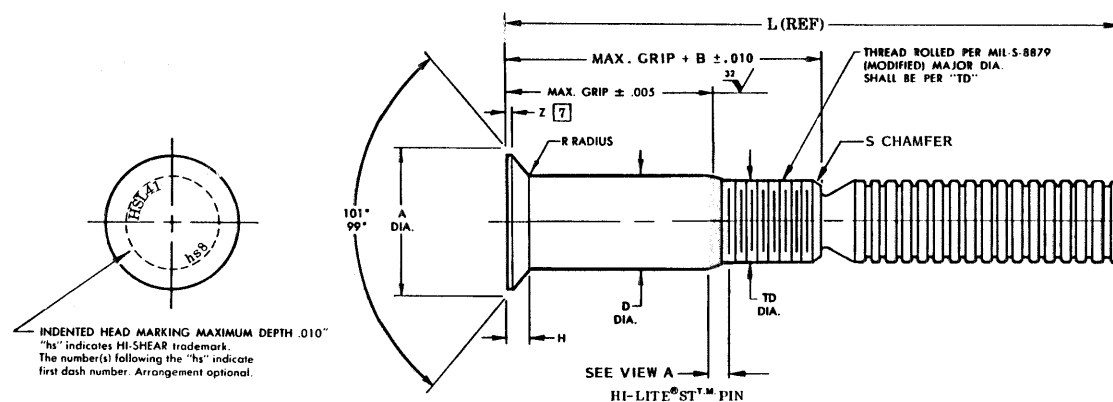


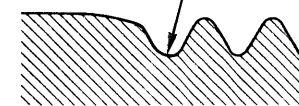
**hi-shear**  
CORPORATION

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



| FIRST DASH NO. | NOM. DIA. | A DIA. | B REF. | WITHOUT SOLID FILM LUBE | WITH SOLID FILM LUBE | TD DIA. | F    | H REF. | R RAD. COLD-WORKED | Z MAX. | S CHAMFER REF. | THREAD                  | DOUBLE SHEAR POUNDS MINIMUM | TENSION POUNDS MINIMUM |
|----------------|-----------|--------|--------|-------------------------|----------------------|---------|------|--------|--------------------|--------|----------------|-------------------------|-----------------------------|------------------------|
| ① -5           | 5/32      | .2612  | .280   | .1635                   | .1635                | .1595   | .004 | .0410  | .025               | .010   | 1/32" x 45°    | 8-32UNJC-3A Modified    | 4,010                       | 1,290                  |
| -6             | 3/16      | .3016  | .290   | .1895                   | .1895                | .1840   | .005 | .0470  | .030               | .015   | 1/32" x 45°    | 10-32UNJF-3A Modified   | 5,380                       | 2,000                  |
| -8             | 1/4       | .3948  | .320   | .2495                   | .2495                | .2440   | .006 | .0610  | .030               | .015   | 1/32" x 45°    | 1/4-28UNJF-3A Modified  | 9,300                       | 3,700                  |
| -10            | 5/16      | .4739  | .380   | .3120                   | .3120                | .3060   | .007 | .0679  | .040               | .015   | 3/64" x 45°    | 5/16-24UNJF-3A Modified | 14,600                      | 5,000                  |
| -12            | 3/8       | .5604  | .420   | .3745                   | .3745                | .3680   | .008 | .0780  | .040               | .015   | 3/64" x 45°    | 3/8-24UNJF-3A Modified  | 21,000                      | 7,200                  |
| -14            | 7/16      | .6620  | .495   | .4370                   | .4370                | .4310   | .009 | .0944  | .040               | .022   | 3/64" x 45°    | 7/16-20UNJF-3A Modified | 28,600                      | 10,000                 |
| -16            | 1/2       | .7540  | .545   | .4995                   | .4995                | .4930   | .010 | .1068  | .050               | .022   | 3/64" x 45°    | 1/2-20UNJF-3A Modified  | 37,300                      | 13,500                 |

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



- ① 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.
  - Hole preparation per NAS618.
  - Curved or flat edge manufacturer's option.
  - This Hi-Lite ST pin is to be used in combination with a Hi-Lite ST collar.
  - This Hi-Lite ST pin is to be used in interference fit holes only.
  - Maximum "D" diameter may be increased by .0002 to allow for solid film application.

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:

HSL41-8-8  
8/16 or 1/2 Maximum Grip Length  
8/32 or 1/4 Nominal Diameter  
Pin Part Number

MATERIAL: A-286 high temperature alloy per Spec. AMS5731 or AMS5737.

HEAT TREAT: 95,000 psi shear minimum at 70°F.

① FINISH: HSL41-( )-( ) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.  
HSL41TB-( )-( ) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 380, except as noted ⑧.

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<br>D. P. S.       | DATE<br>7-31-92          | TITLE<br><b>HI-LITE®ST™ PIN</b><br>100° FLUSH SHEAR HEAD<br>BREAK STEM - INTERFERENCE FIT<br>A-286 HIGH TEMPERATURE ALLOY<br>1/16" GRIP VARIATION |
| APPROVED<br>[Signature] | DATE<br>8-4-92           | DRAWING NUMBER<br><b>HSL41</b>                                                                                                                    |
| REVISION<br>①           | DATE<br>D.P.S.<br>9-2-92 | Sheet 1 of 2                                                                                                                                      |

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HSL41

# HSL41

HSL41

Sheet 2 of 2