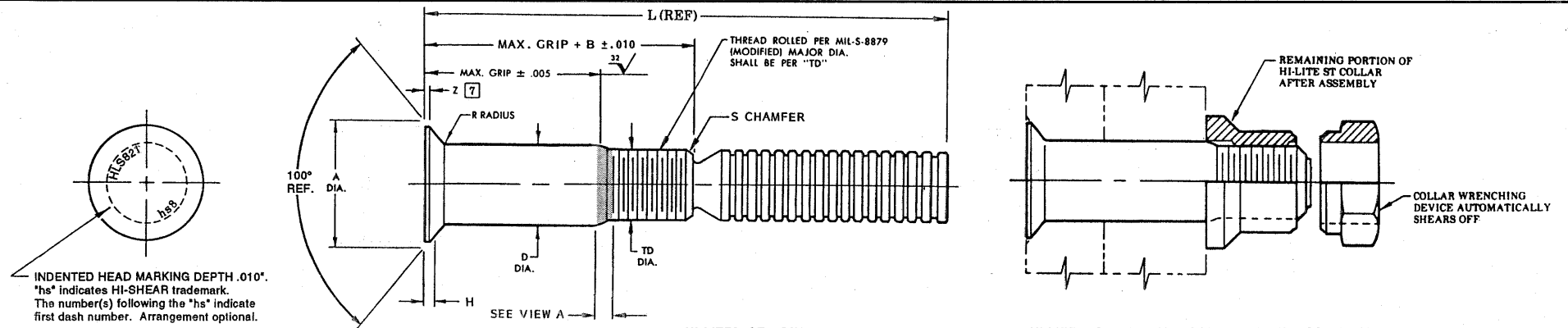
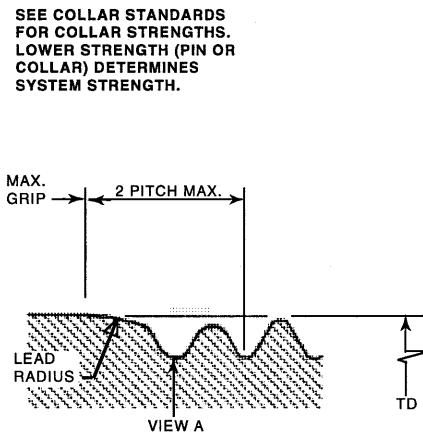


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CAGE = Commercial And Government Entity			943103
HI-SHEAR CORPORATION, U.S.A. (Patent Holder)	CAGE No. 73197	HUCK INTERNATIONAL GmbH & Co. Germany	(Licensee-EEC Countries)
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AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada)	CAGE No. 06725	St.-CHAMOND GRANAT S.A. France	(Licensee-EEC Countries)
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HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee)	CAGE No. 0LB68		
Division of Hi-Shear Industries, Inc., U.S.A.			



HI-LITE® ST™ PIN											HI-LITE® ST™ PIN AND COLLAR				
①											1	7			
FIRST DASH NO.	NOM. DIA.	A DIA.		B REF.	D DIA.	TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	
5	5/32	.2612 .2564		.312	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.012	1/32" x 45°	8-32UNJC-3A Modified	5,280	1,700	
6	3/16	.3016 .2966		.325	.1895 .1885	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	7,060	2,600	
8	1/4	.3948 .3898		.395	.2495 .2485	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	12,260	4,400	
10	5/16	.4739 .4689		.500	.3120 .3110	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	19,160	7,000	
12	3/8	.5604 .5554		.545	.3745 .3735	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	27,600	10,000	
14	7/16	.6680 .6620		.635	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	37,500	13,500	
16	1/2	.7540 .7480		.685	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	49,100	18,000	



- GENERAL NOTES:
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - Use HSL831 for oversize replacement.
 - Lead radius must be tangent to 'D' diameter at max grip.
 - Shorter or longer grips than those listed may be available as specials.

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: HSL821DL-8-8
8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter
Pin Part Number

MATERIAL: Nickel Base Alloy per AMS 5662.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HSL821AP-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HSL821DL-()-() = Kalgard FA or EM620C solid film lube per MIL-L-46010, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 380-2.

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	
J.Obispo	10-16-96	HI-LITE® ST™ PIN	
APPROVED	DATE	100° FLUSH SHEAR HEAD BREAK STEM - INTERFERENCE FIT NICKEL BASE ALLOY (INCONEL 718) 1/16" GRIP VARIATION	
J.Rausch	10-16-96	DRAWING NUMBER	
REVISION	DATE	HSL821 Sheet 1 of 2	
①	J.Obispo 11-11-96		

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SECOND DASH NO.	L REFERENCE									
	-5	-6	-8	-10	-12	-14	-16	-18	-20	-22
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	1.530				
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

HSL821

SHEET 2 OF 2