

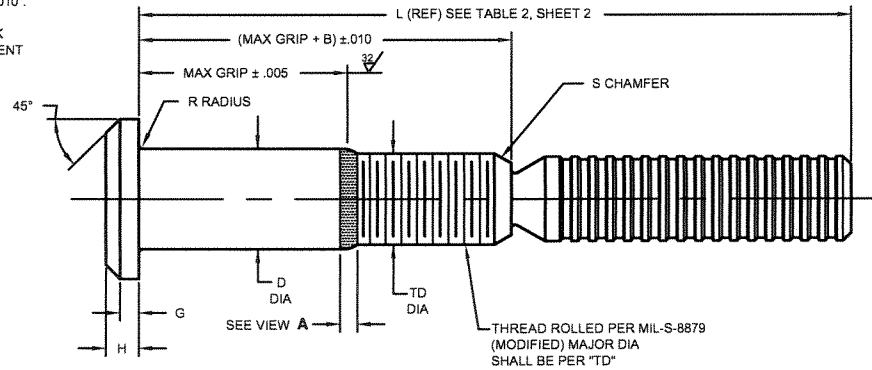
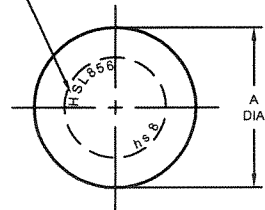
hi-shear
CORPORATION

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Hi-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
a LISI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878
FAIRCHILD - SIMMONDS S.A. France (Licensee) CAGE No. 92215

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68
a LISI AEROSPACE Company
BLANC AERO S.A. France (Licensee - ECC Countries)
a LISI AEROSPACE Company
TOKYO SCREW COMPANY, Japan (Licensee - Japan)

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



HI-LITE® ST™ PIN

TABLE 1

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE LBS. MAX
NOTE: USE HSL756-6 ()													
6	13/64	.377 .357	.300	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 37°	10-32UNJF-3A Modified	6,130	3,180	1,050
8	17/64	.440 .415	.330	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 37°	1/4-28UNJF-3A Modified	10,490	5,820	1,950
10	21/64	.505 .475	.390	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 37°	5/16-24UNJF-3A Modified	16,000	9,200	3,140
12	25/64	.600 .565	.430	.3901 .3891	.3680 .3640	.075	.140 .130	.030 .020	3/64" x 37°	3/8-24UNJF-3A Modified	22,700	14,000	4,850
14	29/64	.676 .641	.510	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64" x 37°	7/16-20UNJF-3A Modified	30,600	18,900	6,120
16	33/64	.770 .735	.610	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64" x 37°	1/2-20UNJF-3A Modified	39,600	25,600	8,340

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions to be met after finish.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
5. This Hi-Lite ST Pin is to be used in combination with a Hi-Lite ST Collar.
7. This Hi-Lite ST Pin to be used in interference fit holes only.

MATERIAL:

6AL-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT:

160,000 psi tensile minimum (95,000 psi shear minimum).

FINISH:

- HSL856()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HSL856CE()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick), with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HSL856CF()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick), with color black on thread end.
- HSL856KM()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HSL856KN()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color white on thread end.
- HSL856RP()-() = Phosphate fluoride treat with color orange on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

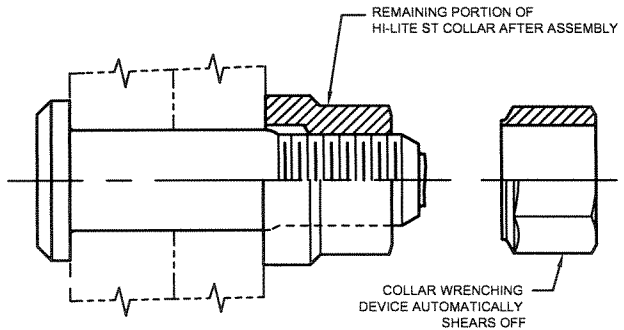
Hi-Lite Product Specification 380-2.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HSL856 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

**HOW TO ORDER
EXAMPLE:**

Pin Part Number Only
HSL856CE8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ Replaces 8/32 or 1/4 Nominal Diameter Pin
└─ Finish
└─ Pin Basic Part Number



HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

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

U.S. Patents 4,326,825; 4,485,510 and 4,957,401. Other U.S. and international patents pending. "Hi-Lite" and "HST" are registered trademarks and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.		
DRAWN J.F.Obispo	DATE 5-16-95	TITLE HI-LITE® ST™ PIN PROTRUDING TENSION HEAD BREAK STEM, INTERFERENCE FIT TITANIUM 1/16" GRIP VARIATION, 1/64" OVERSIZE
APPROVED J.Rausch	DATE 5-23-95	DRAWING NUMBER HSL856
REVISION ①	DATE JFO 2-4-03	Sheet 1 of 2

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TABLE 2

SECOND DASH NUMBER	L REF						
		-6 DIA.	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.
1		-	-	-	-	-	-
2		1.000	1.000	-	-	-	-
3		1.125	1.125	1.250	-	-	-
4		1.250	1.250	1.375	1.375	-	-
5		1.375	1.375	1.500	1.500	1.625	-
6		1.500	1.500	1.625	1.625	1.750	1.750
7		1.625	1.625	1.750	1.750	1.875	1.875
8		1.750	1.750	1.875	1.875	2.000	2.000
9		1.875	1.875	2.000	2.000	2.125	2.125
10		2.000	2.000	2.125	2.125	2.250	2.250
11		2.125	2.125	2.250	2.250	2.375	2.375
12		2.250	2.250	2.375	2.375	2.500	2.500
13		2.375	2.375	2.500	2.500	2.625	2.625
14		2.500	2.500	2.625	2.625	2.750	2.750
15		2.625	2.625	2.750	2.750	2.875	2.875
16		2.750	2.750	2.875	2.875	3.000	3.000
17		2.875	2.875	3.000	3.000	3.125	3.125
18		3.000	3.000	3.125	3.125	3.250	3.250
19		3.125	3.125	3.250	3.250	3.375	3.375
20		3.250	3.250	3.375	3.375	3.500	3.500
21		3.375	3.375	3.500	3.500	3.625	3.625
22		3.500	3.500	3.625	3.625	3.750	3.750
23		3.625	3.625	3.750	3.750	3.875	3.875
24		3.750	3.750	3.875	3.875	4.000	4.000
25		-	-	4.000	4.000	4.125	4.125
26		-	-	4.125	4.125	4.250	4.250
27		-	-	4.250	4.250	4.375	4.375
28		-	-	4.375	4.375	4.500	4.500
29		-	-	-	-	4.625	4.625
30		-	-	-	-	4.750	4.750
31		-	-	-	-	4.875	4.875
32		-	-	-	-	5.000	5.000

DRAWING NUMBER

HSL856

Sheet 2 of 2