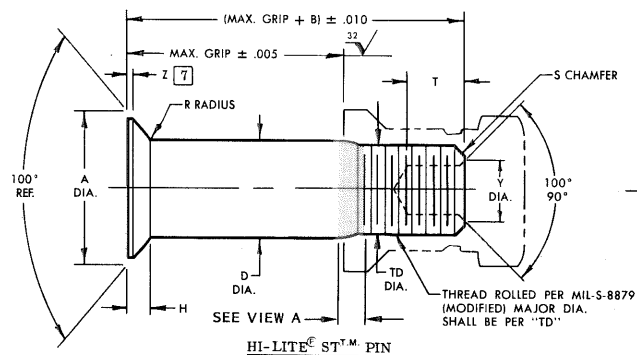
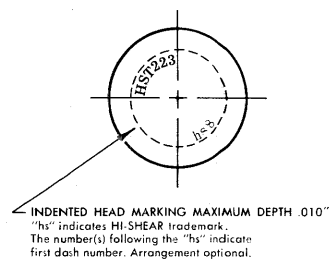


HI-LITE® ST™. PIN AND COLLAR AFTER ASSEMBLY

HI-LITE[®] ST[™].M. PIN

[illegible]

**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. 7



VIEW A
HI-LITE THREAD TRANSITION AREA.
SEE SPECIFICATION FOR INSPECTION

- GENERAL NOTES: 1. Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
3. "H" dimensioned from maximum "D" diameter.
4. Dimensions to be met after finish.
5. Surface texture per ANSI B46.1.
6. Hole preparation per NAS618.
7. Curved or flat edge manufacturer's option.

CODE: First dash number indicates nominal diameter in 1/32nds which HST223 oversize pin replaces.
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

HST223DU-8-8

—8/16 or 1/2 Maximum Grip Length

- Replaces 8/32 or 1/4 Nominal Diameter Pin

Solid Film Lubricant.

- Pin Part Number

Pin and Collar Assembly Part Number Combination

HST223DU84-8-8

Size and Grip Length, See Above Example

- Collar Part Number

☐ Pin Finish

- Pin Part Number

MATERIAL: 7075 aluminum alloy per QQ-A-225/9 or QQ-A-430.

HEAT TREAT: Age to T6 condition per MIL-H-6088.

FINISH:	HST223-() ()	= Anodize per MIL-A-8625, dye color natural, and cetyl alcohol lube per Hi-Shear Spec. 305.
	HST223DU-() ()	= Anodize per MIL-A-8625, and solid film lube per MIL-L-46010, Type I.
	HST223EY-() ()	= Anodize per MIL-A-8625, dye color yellow, and cetyl alcohol lube per Hi-Shear Spec. 305.
	HST223TT-() ()	= Anodize per MIL-A-8625, dye color natural, and translube.

SPECIFICATION: Hi-Lite Product Specification 380.

U.S. Patents 4,326,825 and 4,485,510. 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
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Dept. 104 8-3-90

Sept: 194 0 0 50

APPROVED	DATE
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DA 8-3-90

REVISION	DATE
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TITLE

HI-LITE[®] ST^{T.M.} PIN

100° FLUSH MS20426 SHEAR HEAD

100° FLUSH MS20426 SHEAR HEAD
ALUMINUM ALLOY

VARIATION, 1/

DRAWING NUMBER

HST223