

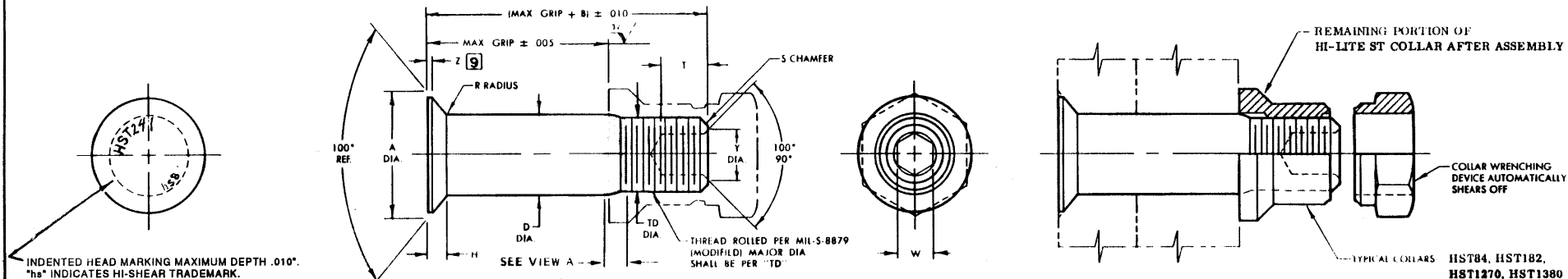
hi-shear
CORPORATION

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CAGE = Commercial And Government Entity

HI-SHEAR CORPORATION, U.S.A.(Patent Holder).....CAGE No. 73197
A Subsidiary of GFI Industries, France
AIR INDUSTRIES CO., INC. (Licensee-U.S.A. & Canada).....CAGE No. 06725
SPS TECHNOLOGIES, U.S.A. (Licensee)CAGE No. 56878
HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee).....CAGE No. 0LB68
A Subsidiary of GFI Industries, France

SIMMONDS S.A. France.....(Licensee - EEC Countries-Collars)
ST-CHAMOND GRANAT S.A. France.....(Licensee - EEC Countries)
TOKYO SCREW COMPANY, Japan.....(Licensee-Japan)



HI-LITE ST PIN

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9

HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			** DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING OR SOLID FILM LUBE	AFTER COATING OR SOLID FILM LUBE								W HEX.	T DEPTH	Y DIA.		
5	13/64																
NOTE: USE HST141-6 ()																	
6	7/32	.3303 .3253	.300	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,100	2,000
8	9/32	.4260 .4210	.330	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	11,800	3,700
10	11/32	.5051 .5001	.390	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	17,600	5,000
12	13/32	.5916 .5866	.430	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	24,600	7,200
14	15/32	.6992 .6932	.495	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0970 .0945	.050 .040	.022	3/64" x 37°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	32,700	10,000
16	17/32	.7852 .7792	.535	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1070 .1045	.050 .040	.022	3/64" x 37°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	42,000	13,500

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.

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.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Oversize replacement for HST41 and HST141 pins.
- Non-lubed pins must be used with lubed collars.
- Curved or flat edge manufacturer's option.

MATERIAL:

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

HEAT TREAT:

95,000 psi shear minimum.

FINISH:

- HST241-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
 [8] HST241DU()-() = Solid film lube per AS5272, Type I.
 [8] HST241GU()-() = Silver plate per AMS2410.
 [8] HST241PY()-() = Passivate per Hi-Shear Spec. 258.
 [8] HST241TF()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
 HST241V()-() = Solid film lube per "Lubeco" 2123, Type II.
 [1] HST241YV()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 on threads only, with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

Hi-Lite Product Specification 380.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HST241 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

HST241-8-8

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

Pin and Collar Assembly Part Number Combination

HST24184-8-8

Size and Grip Length.
 See Above Example
 Collar Part Number
 Pin Part Number

** The Double Shear Values shown are based on cross section area for nominal pin diameter.

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 DATE		TITLE	
J.Henderson	1-21-98	HI-LITE®ST™ PIN	
APPROVED DATE		A-286 HIGH TEMPERATURE ALLOY	
MC	1-22-98	1/16" GRIP VARIATION, 1/32" OVERSIZE	
REVISION DATE		DRAWING NUMBER	
①	JRH 2-2-98	HST241	