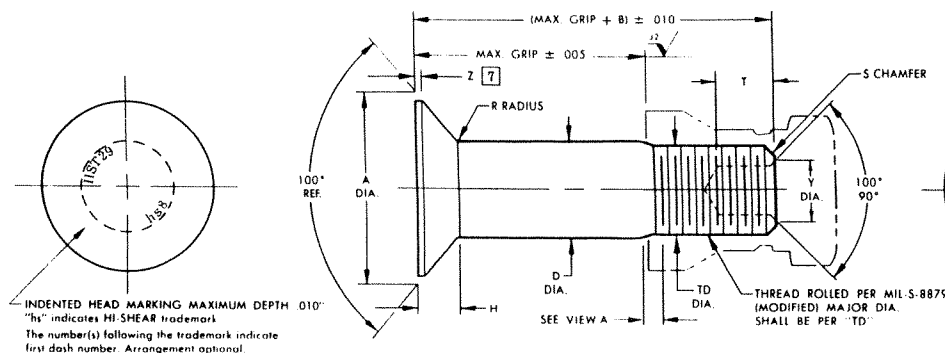


hi-shear
CORPORATION

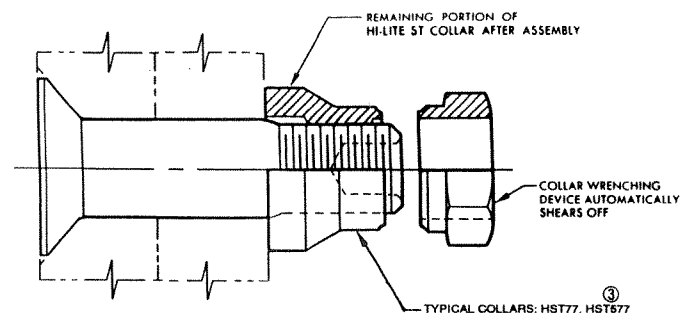
2600 Skypark Drive
Torrance, California 90509 U.S.A.
Telephone (310) 326-8110
FAX (310) 784-4144

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
A Subsidiary of GFI Industries, France
AIR INDUSTRIES CO., INC. (Licensee - U.S. & 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

HUCK INTERNATIONAL GmbH & Co. Germany (Licensee-EEC Countries)
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



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
												W HEX.	T DEPTH	Y DIA.		
5	5/32	.3304 .3256	.280	.1635 .1625	.1595 .1570	.004	.0700 .0680	.025 .015	.015	1/32" x 45°	8-32UNJC-3A Modified	.0645 .0635	.100 .080	.090 .075	1,760	1,030
6	3/16	.3813 .3765	.290	.1895 .1885	.1840 .1810	.005	.0805 .0785	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	2,540	1,640
8	1/4	.5066 .5018	.320	.2495 .2485	.2440 .2410	.006	.1079 .1059	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	4,500	2,950
10	5/16	.6335 .6287	.380	.3120 .3110	.3060 .3020	.007	.1349 .1329	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	7,050	4,660
12	3/8	.7604 .7556	.420	.3745 .3735	.3680 .3640	.008	.1619 .1599	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	10,100	7,200
14	7/16	.8884 .8812	.485	.4370 .4360	.4310 .4260	.009	.1895 .1865	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	13,800	9,350
16	1/2	1.0139 1.0068	.525	.4995 .4985	.4930 .4880	.010	.2160 .2130	.050 .040	.022	3/64" X 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	18,000	13,000

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



GENERAL NOTES:

- Head edge out of roundness shall not exceed "F".
- Concentricity: Conical surface of head to "D" diameter within .005 FIR.
- "H" 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 HST129 for oversize replacement.

CODE:

First dash number indicates nominal diameter in 1/32nds.
Second dash number indicates maximum grip in 1/16ths.

HOW TO ORDER
EXAMPLES:

Pin Part Number Only
HST29-8-8

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

Pin and Collar Assembly Part Number Combination
HST2977-8-8

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

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

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

FINISH: HST29-(-)(-) = Anodized per Spec. MIL-A-8625, dye color green, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 380.

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	
D.P.S.	4-16-86	HI-LITE® ST PIN	
APPROVED DATE		100° FLUSH MS24694 TENSION HEAD	
E.E.B.	4-28-86	ALUMINUM ALLOY	
REVISION DATE		1/16" GRIP VARIATION	
③	J. R. H. 2-24-97	DRAWING NUMBER	
		HST29	