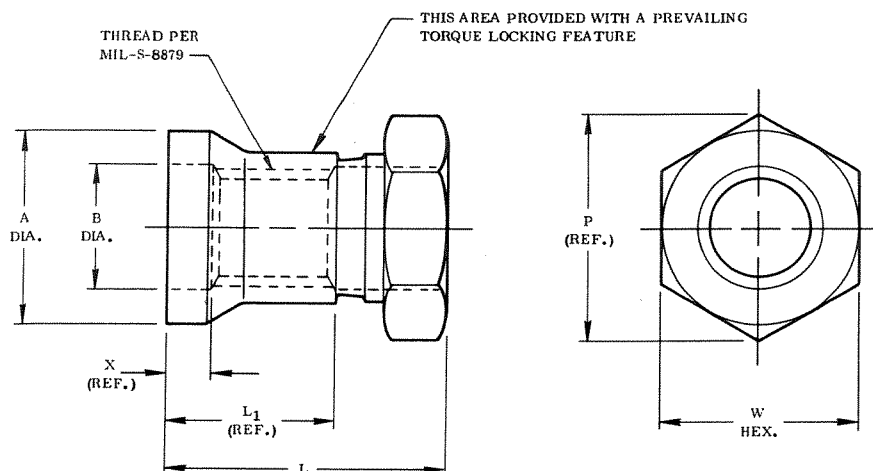


hi-shear
CORPORATION

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CAGE - Commercial And Government Entity

HI-SHEAR CORPORATION, U.S.A. (Patent Holder)	CAGE No. 73197	KAMAX-WERKE Germany (Licensee-EEC Countries)
Division of Hi-Shear Industries, Inc., U.S.A.		Rudolph Kellerman GmbH & Co.
AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada)	CAGE No. 06725	BIMMONDS S.A. France (Licensee-EEC Countries-Collars)
SPS TECHNOLOGIES, U.S.A. (Licensee)	CAGE No. 56878	St.-CHAMOND GRANAT S.A. France (Licensee-EEC Countries)
HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee)	CAGE No. 0LB86	TOKYO SCREW COMPANY, Japan (Licensee-Japan)
Division of Hi-Shear Industries, Inc., U.S.A.		



DASH NO.	PIN NOM. DIA.	THREAD	A DIA.	B DIA.	L	L1 REF.	P REF.	W HEX.	X REF.	UTS LBS. MIN.	TENSION PRELOAD LBS. MIN.	TORQUE-OFF INCH-LBS.
-5	3											
-6	13/64 7/32	10-32UNJF-3B	.355 .345	.227 .223	.415 .395	.240	.380	.346 .332	.095	1,240	500	20-30
-8	17/64 9/32	1/4-28UNJF-3B	.440 .430	.290 .286	.485 .465	.280	.484	.440 .425	.100	2,170	1,000	55-70
-10	21/64 11/32	5/16-24UNJF-3B	.535 .525	.353 .347	.565 .545	.385	.484	.440 .425	.105	3,020	1,400	90-115
-12	25/64 13/32	3/8-24UNJF-3B	.635 .625	.416 .410	.635 .615	.365	.557	.503 .488	.105	4,370	1,950	100-130
-14	29/64 15/32	7/16-20UNJF-3B	.735 .725	.481 .475	.715 .695	.415	.624	.565 .550	.110	6,000	3,000	160-200
-16	33/64 17/32	1/2-20UNJF-3B	.850 .840	.543 .537	.775 .755	.445	.763	.690 .675	.110	7,600	3,800	200-250

GENERAL NOTES:

1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. Dimensions apply after finish.
3. Use 3/16 standard diameter pin and HST77-6 collar as oversize for 5/32 diameter.
4. Cetyl alcohol may be applied to HST377DU at manufacturer's option.

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

HEAT TREAT: Age to T73 condition per MIL-H-6088.

FINISH: HST377- () = Anodize per MIL-A-8625, dye color brown, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST377DU- () = Anodize per MIL-A-8625, and solid film lube per MIL-L-46010, Type I, 4

SPECIFICATION: Hi-Lite Product Specification 381, except tension preload as tabulated.

CODE: Dash number indicates nominal thread size in 1/32nds.

EXAMPLE: HST377-8 = 1/4-28 Hi-Lite ST collar, anodize color brown, with cetyl alcohol lube.

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.

	DATE	BY	TITLE	DRAWING NUMBER
DRAWN	5-7-92	D.P.S.	HI-LITE® ST™ COLLAR	HST377
APPROVED	5-11-92	<i>Schilke</i>	7075-T73 ALUMINUM ALLOY 1/16" GRIP VARIATION - SHEAR APPLICATION FOR USE ON 1/64" AND 1/32" OVERSIZE ALUMINUM HI-LITE ST PINS	
REVISION				