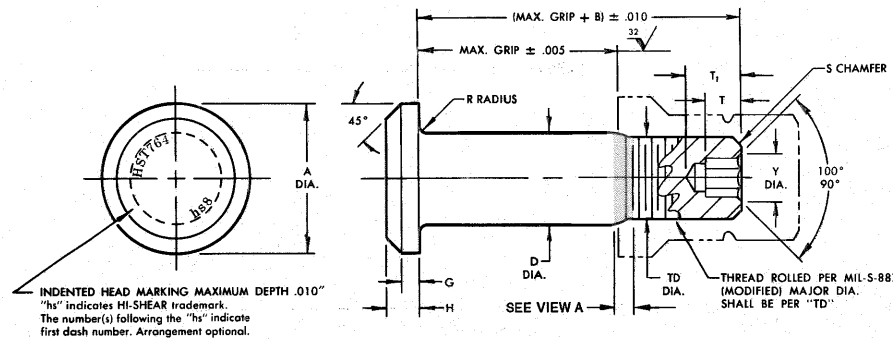
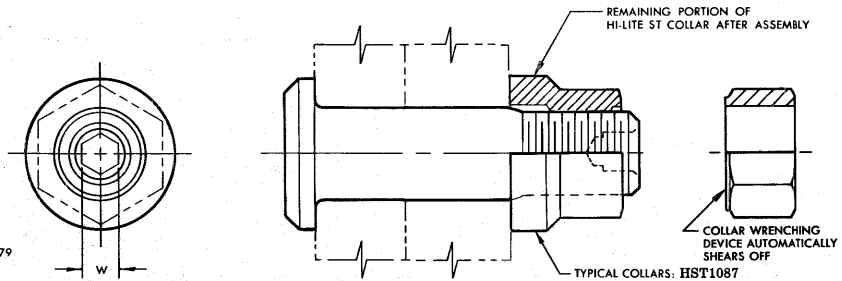




"CAGE" = Commercial And Government Entity			
HI-SHEAR CORPORATION, U.S.A. (Patent Holder)	CAGE No. 73197	KAMAX-WERKE Germany (Licensee-EEC Countries)	
Division of HI-Shear Industries, Inc., U.S.A.		Rudolph Kollman GmbH & Co.	
AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada)	CAGE No. 06725	SIMMONDS S.A. France (Licensee-EEC Countries-Collars)	
SPS TECHNOLOGIES, U.S.A. (Licensee)	CAGE No. 54378	SI-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.			



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.	G REF.	H	R RAD.	S CHAMFER REF.	THREAD	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											W HEX.	T DEPTH MIN.	T ₁ DEPTH	Y DIA.		
-5	3/16			NOTE: Use HST720-6												
-6	13/64	.377 .357	.300	.2026 2016	.1840 1810	.035	.074 .064	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.080	.135	.119 .104	6,970	3,850
-8	17/64	.440 .415	.330	.2651 2641	.2440 2410	.045	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.090	.160	.142 .122	11,920	6,550
-10	21/64	.505 .475	.390	.3276 3266	.3060 3020	.055	.112 .102	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.110	.200	.180 .160	18,200	10,350
-12	25/64	.600 .565	.430	.3901 3891	.3680 3640	.075	.140 .130	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.140	.235	.217 .197	25,800	15,750
-14	29/64	.676 .641	.495	.4526 4516	.4310 4260	.095	.160 .150	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.170	.275	.253 .233	34,800	21,200
-16	33/64	.770 .735	.535	.5151 5141	.4930 4880	.095	.188 .178	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.200	.315	.289 .269	45,000	28,800
-18	37/64	.877 .842	.610	.5771 5761	.5550 5500	.125	.210 .200	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.240	.365	.326 .306	56,500	36,400
-20	41/64	.953 .918	.650	.6396 6386	.6180 6120	.140	.238 .228	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.240	.365	.326 .306	69,300	46,100
-24	49/64	1.150 1.110	.905	.7646 7636	.7430 7370	.200	.335 .320	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.300	.440	.398 .378	99,100	66,900

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:**
1. Concentricity: "A" to "D" diameter within .010 FIR.
 2. Dimensions to be met after finish.
 3. Surface texture per ANSI B46.1.
 4. Hole preparation per NAS618.
 5. Use HST820 for oversize replacement.

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626 or MIL-S-6049.

HEAT TREAT: 180,000 - 200,000 psi tensile per Spec. MIL-H-6875.

FINISH: HST764(-)(-) = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, with color code black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
HST764BJ(-)(-) = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST764BL(-)(-) = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, with color black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
HST764CG(-)(-) = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, with color green 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 HST764 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
HST764-8-8
8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Pin Part Number with Type II Cadmium Plate

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 D. P. S. 11/3/92	TITLE HI-LITE® ST™ PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16" GRIP VARIATION - 1/64" OVERSIZE
APPROVED DATE A. EX. UN 11-3-92	DRAWING NUMBER HST764
REVISION DATE	

HST764