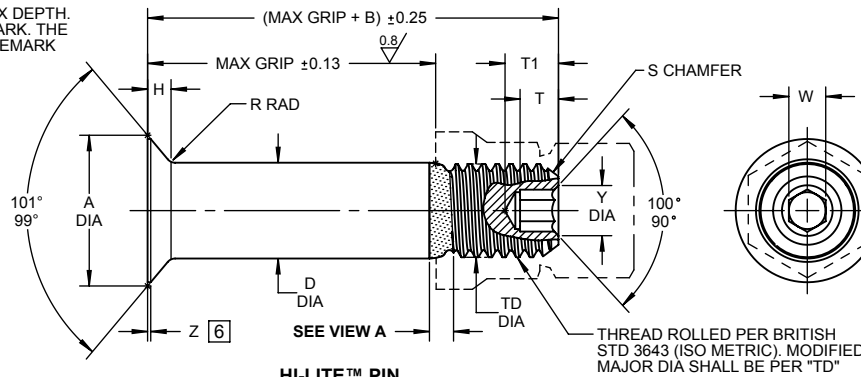
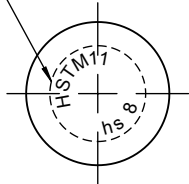
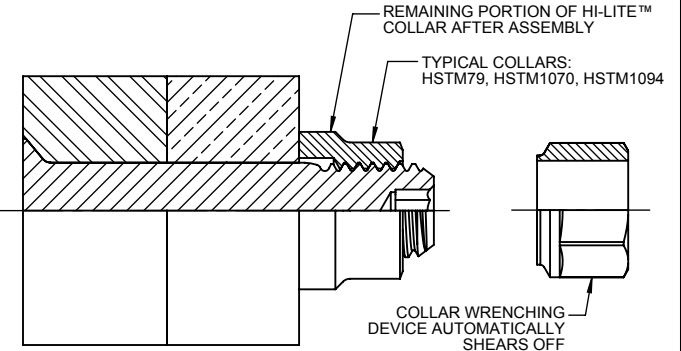


INDENTED HEAD MARKING 0.25 MAX DEPTH.
"hs" INDICATES HI-SHEAR TRADEMARK. THE
NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER.
ARRANGEMENT OPTIONAL.



HI-LITE™ PIN



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM								W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA		
04	4	6.49 6.35	7.11	3.990 3.978	3.990 3.965	3.91 3.86	0.11	1.05 0.99	0.65 0.40	0.25	0.8 x 37°	M4 x 0.7-4h	1.64 1.61	1.63	2.90	2.30 1.90	16400	6200
05	5	7.85 7.71	7.65	4.990 4.978	4.990 4.965	4.90 4.84	0.13	1.20 1.14	0.75 0.50	0.38	0.8 x 37°	M5 x 0.8-4h	2.05 2.01	2.00	3.43	3.05 2.60	25700	9300
06	6	9.68 9.54	8.65	5.990 5.978	5.990 5.965	5.88 5.81	0.16	1.55 1.49	0.75 0.50	0.38	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.25	4.06	3.60 3.10	37000	14700
08	8	12.73 12.59	9.65	7.987 7.972	7.987 7.962	7.88 7.80	0.18	1.99 1.93	1.00 0.75	0.38	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	2.75	5.08	4.60 4.05	65800	24400
10	10	15.68 15.54	11.82	9.987 9.972	9.987 9.962	9.88 9.80	0.21	2.39 2.33	1.00 0.75	0.38	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	3.50	5.97	5.50 5.00	102900	37800
12	12	18.42 18.28	13.33	11.984 11.966	11.984 11.959	11.87 11.76	0.23	2.70 2.64	1.25 1.00	0.56	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	4.30	6.99	6.45 5.90	148100	52000

SEE COLLAR STANDARDS
FOR COLLAR STRENGTHS.
LOWER STRENGTH (PIN OR
COLLAR) DETERMINES
SYSTEM STRENGTH.

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .08 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions are in millimeters and to be met after finish.
 - Surface texture per ISO/R468.
 - Curved or flat edge manufacturer's option.
 - Use HSTM311 for oversize replacement.
 - After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: 6Al-4V titanium alloy per AMS4928 or AMS4967.

⑪ 6Al-6V-2Sn titanium alloy per AMS4971 is acceptable for -10 and larger sizes.

HEAT TREAT: 655 N/mm² shear minimum.

- FINISH:**
- HSTM11(-)(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet (equivalent to LN9368 Blatt 4), with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑧ HSTM11AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- ⑧ HSTM11AZ(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HSTM11BJ(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification M380.

CODE: First dash number indicates nominal diameter in 1mm.
Second dash number indicates maximum grip in 1mm.
See Finish note for explanation of code letters.

**HOW TO ORDER
EXAMPLE:**

Pin Part Number
HSTM11AP08-8

8mm Maximum Grip Length
8mm Nominal Diameter Pin
Finish code
Pin Basic Part Number

THIS AREA OF SPECIAL CONFIGURATION
AND COLD WORKING TO MEET PHYSICAL
REQUIREMENTS



VIEW A

HI-LITE™ THREAD TRANSITION AREA
SEE SPECIFICATION FOR INSPECTION

"HI-LITE", "HST", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY J.OBISPO	DATE 2014-12-22	TITLE HI-LITE™ PIN (METRIC SERIES) 100° FLUSH SHEAR HEAD TITANIUM 1mm GRIP VARIATION
D.P.S.	1982-10-08	
APPROVED J.G.WILCOX	DATE 1982-10-11	DRAWING NUMBER HSTM11
REVISION ⑪	DATE F.CARINGELLA 2018-12-10	