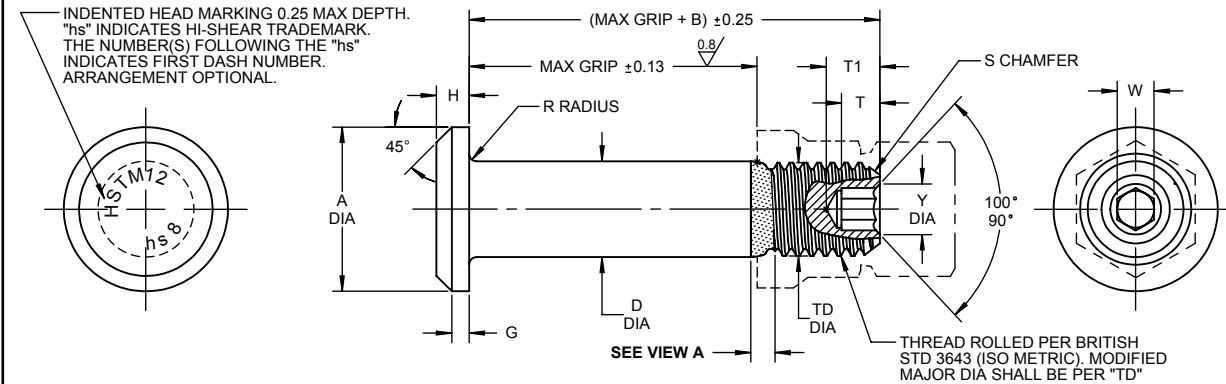
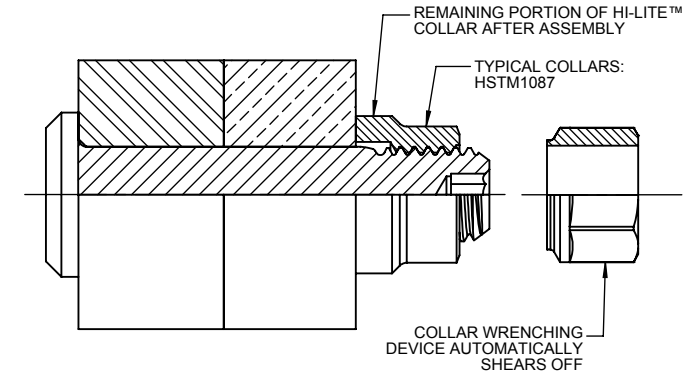


(10)



HI-LITE™ PIN



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	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	8.15 7.75	7.11	3.990 3.978	3.990 3.965	3.91 3.86	0.9	1.60 1.40	0.65 0.40	0.8 x 37°	M4 x 0.7-4h	1.64 1.61	1.63	2.90	2.30 1.90	16400	9800
05	5	9.75 9.25	7.65	4.990 4.978	4.990 4.965	4.90 4.84	1.0	1.90 1.65	0.65 0.40	0.8 x 37°	M5 x 0.8-4h	2.05 2.01	2.00	3.43	3.05 2.60	25700	15600
06	6	10.90 10.40	8.65	5.990 5.978	5.990 5.965	5.88 5.81	1.3	2.30 2.05	0.65 0.40	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.25	4.06	3.60 3.10	37000	22200
08	8	12.85 12.25	9.65	7.987 7.972	7.987 7.962	7.88 7.80	1.6	3.05 2.80	0.75 0.50	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	2.75	5.08	4.60 4.05	65800	42000
10	10	16.20 15.40	11.82	9.987 9.972	9.987 9.962	9.88 9.80	1.9	3.75 3.50	0.75 0.50	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	3.50	5.97	5.55 5.00	102900	68000
12	12	18.80 18.00	13.33	11.984 11.966	11.984 11.959	11.87 11.76	2.3	4.45 4.20	0.75 0.50	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	4.30	6.99	6.45 5.90	148100	100200

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within 0.25 FIM.
2. Dimensions are in millimeters and to be met after finish.
3. Surface texture per ISO/R468.

4 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 for all sizes.
6AL-6V-2Sn titanium alloy per AMS4971 is acceptable for -10 and larger sizes.

HEAT TREAT: 655 N/mm² shear minimum.

FINISH: HSTM12(-)(-) = 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.

4 HSTM12AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

HSTM12AU(-)(-) = Solid film lube per "ELECTROFILM™" XSF-104.

4 HSTM12AZ(-)(-) = 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.

HSTM12BJ(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.

HSTM12CE(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II with color black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification M380.

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

HOW TO ORDER

(10) **EXAMPLE:**

Pin Part Number
HSTM12AP08-8

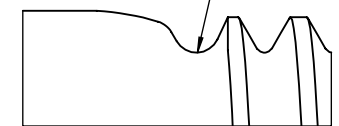
8 mm Maximum Grip Length

8 mm 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.F. OBISPO	DATE 2014-10-13	TITLE HI-LITE™ PIN (METRIC SERIES) PROTRUDING TENSION HEAD TITANIUM 1 mm GRIP VARIATION
D.P.S.	1982-10-08	
APPROVED J.G. WILCOX	DATE 1982-10-11	DRAWING NUMBER HSTM12 1 OF 1
REVISION (10)	DATE KEVIN TRAN 2017-06-28	