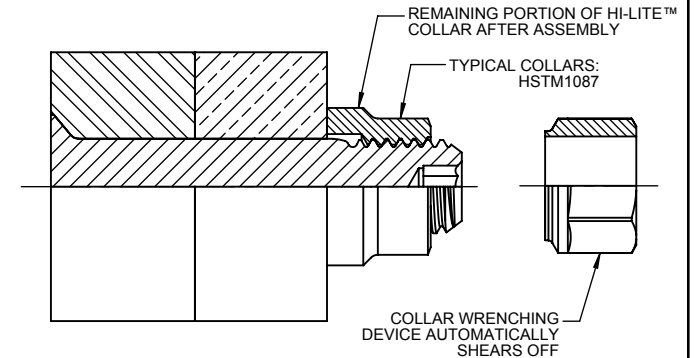
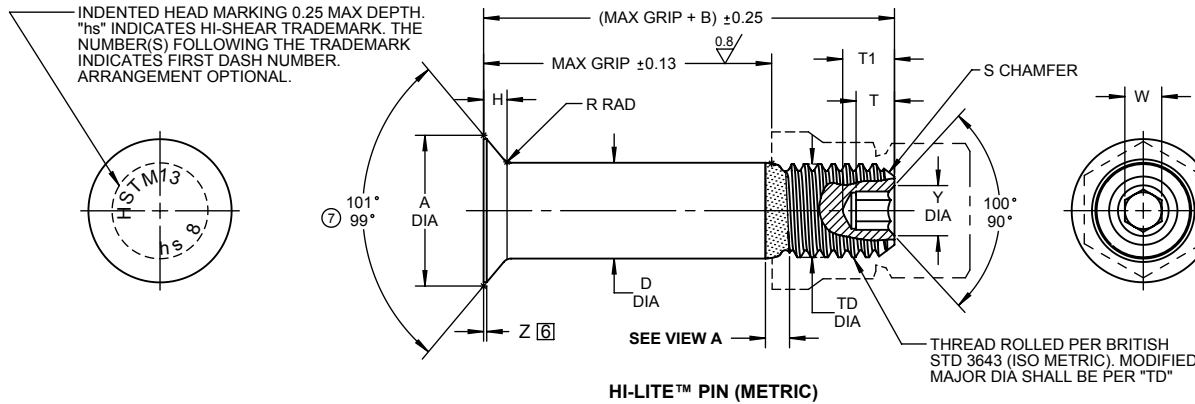




FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
				WITHOUT COATING OR SOLID FILM	AFTER COATING OR SOLID FILM								W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA		
04	4	8.13 7.99	7.11	3.990 3.978	3.990 3.965	3.91 3.86	0.11	1.74 1.68	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	9800
05	5	10.13 9.99	7.65	4.990 4.978	4.990 4.965	4.90 4.84	0.13	2.16 2.10	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	15600
.06	6	12.13 11.99	8.65	5.990 5.978	5.990 5.965	5.88 5.81	0.16	2.58 2.52	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	22200
08	8	16.13 15.99	9.65	7.987 7.972	7.987 7.962	7.88 7.80	0.18	3.42 3.36	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	42000

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 0.08 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.
 - After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 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.

HEAT TREAT: 655 N/mm² shear minimum.

FINISH: HSTM13(-)(-) = 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.

[7] HSTM13AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

HSTM13AU(-)(-) = Solid film lube per "ELECTROFILM™" XSF-104.

[7] HSTM13AZ(-)(-) = 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.

HSTM13BJ(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.

HSTM13CE(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick) color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification M380.

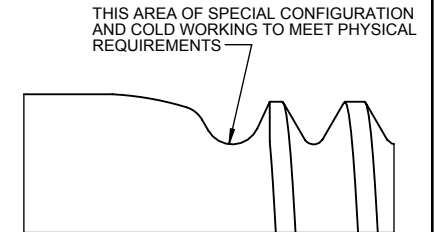
CODE: First dash number indicates nominal diameter in 1 mm. Second dash number indicates maximum grip in 1 mm. See Finish note for explanation of code letters.

HOW TO ORDER

[7] **EXAMPLE:**

Pin Part Number
 HSTM13AP04-8

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



HI-LITE™ THREAD TRANSITION AREA
 SEE SPECIFICATION FOR INSPECTION

"HI-LITE", "HST", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY D.P.S.	DATE 1982-10-08	TITLE HI-LITE™ PIN (METRIC SERIES) 100° FLUSH TENSION HEAD TITANIUM 1 mm GRIP VARIATION
APPROVED JG WILCOX	DATE 1982-10-11	
REVISION [7]	DATE KEVIN TRAN 2017-06-28	DRAWING NUMBER HSTM13 1 OF 1