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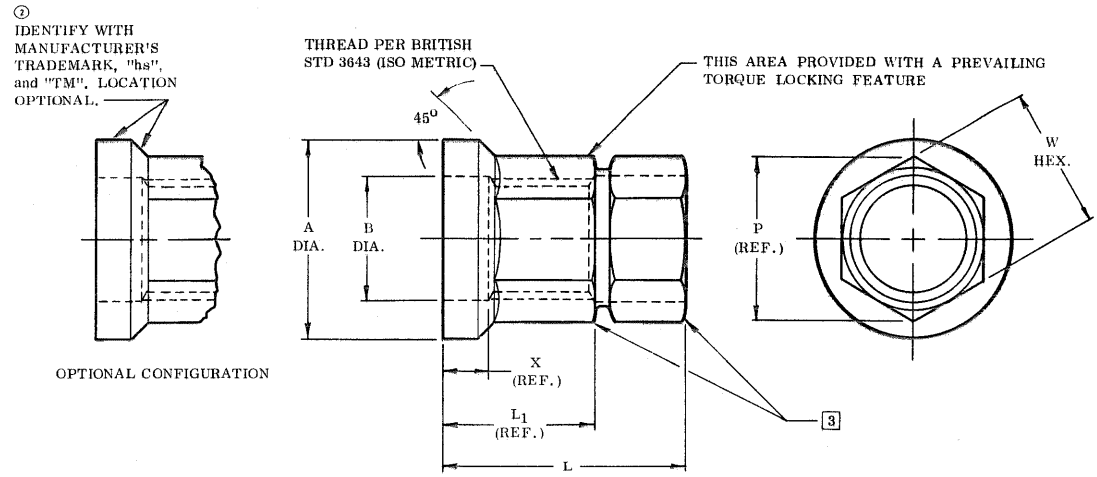
hi-shear CORPORATION
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 · 775-3181 · 326-8110



	DASH NO. (METRIC)	PIN NOM. DIA.	THREAD	A DIA.		B DIA.		L	L_1 (REF.)		P (REF.)		W HEX.	X (REF.)	TORQUE-OFF NEWTON-METER	ULT TNSN STR NEWTONS MINIMUM
4	04	4	M4 x 0.7-4H5H	7.72 7.47		4.78 4.62		9.78 9.27	5.58		6.05		5.50 5.28	1.7	1.7 - 2.9	5800
4	05	5	M5 x 0.8-4H5H	8.47 8.22		5.78 5.62		10.03 9.53	5.84		7.86		7.00 6.78	1.7	2.8 - 4.6	7300
	06	6	M6 x 1.0-4H5H	11.35 11.10		7.28 7.12		11.68 11.30	6.60		8.90		8.00 7.78	2.4	5.6 - 9.1	12000
	08	8	M8 x 1.0-4H5H	14.25 14.00		9.32 9.12		14.73 14.48	8.12		11.20		10.00 9.78	2.5	14.6 - 18.1	22200

NOTES:
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
2. Dimensions apply after finish.
3. Burrs from cutoff process and cutting torque-off groove allowed.
4. -04 and -05 available for procurement in 0.5 mm oversize only.

MATERIAL: 7050 aluminum alloy per AMS4340 or 7075 aluminum alloy per QQ-A-225/9.

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

FINISH: HSTM1380-( ) = Anodize per MIL-A-8625, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification M381.

CODE: Dash number indicates nominal thread size in 1 mm.

EXAMPLE: HSTM1380-08 = M8 x 1.0 Hi-Lite ST collar.

U.S. Patents 4,326,825 and 4,485,510. 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
DRAWN	9-18-85	D.P.S.
APPROVED	[illegible]	[illegible]
2 REVISION	3-13-86	D.P.S.

TITLE

HI-LITE® ST™ COLLAR
(METRIC SERIES)

ALUMINUM ALLOY
1 mm GRIP VARIATION — SHEAR APPLICATION
FOR USE ON 0.5mm AND 1mm OVERSIZE HI-LITE ST PINS

DRAWING NUMBER

HSTM1380

2-1599136

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