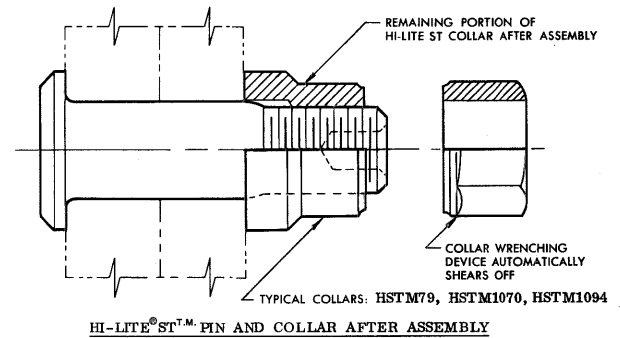
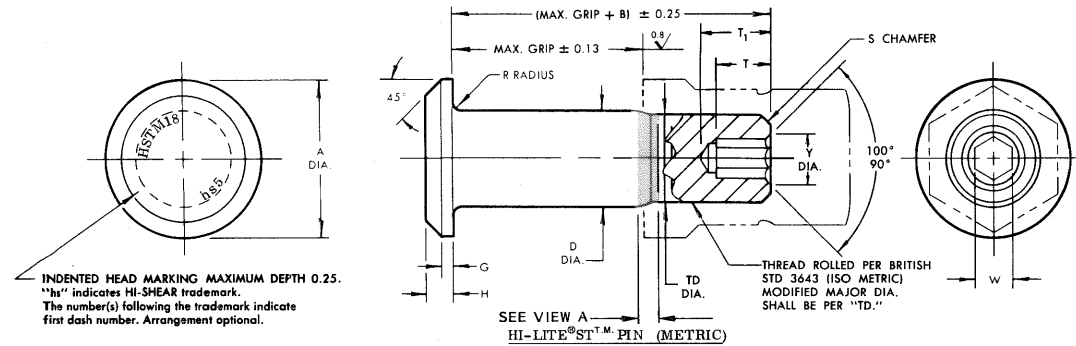


hi-shear
CORPORATION

2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



FIRST DASH NO.	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
											* W HEX.	T HEX DEPTH MIN.	T1 DEPTH MAX.	Y DIA.		
-04	4	6.65 6.25	7.11	3.990 3.965	3.91 3.86	0.6	1.20 0.95	0.65 0.40	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	1.63	2.90	2.30 1.90	16400	7800
-05	5	8.15 7.65	7.65	4.990 4.965	4.90 4.84	0.8	1.40 1.15	0.65 0.40	0.8 x 45°	M5 x 0.8-4h	2.05 2.01	2.00	3.43	3.05 2.60	25700	11800
-06	6	10.20 9.70	8.65	5.990 5.965	5.88 5.81	0.9	1.75 1.50	0.65 0.40	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.25	4.06	3.60 3.10	37000	18200
-08	8	12.85 12.25	9.65	7.987 7.962	7.88 7.80	1.0	2.20 1.95	0.75 0.50	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	2.75	5.08	4.60 4.05	65800	31600

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

* INCH STANDARD HEX.

- ① GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within 0.25 FIR.
 2. Dimensions to be met after finish.
 3. Surface texture per ISO/R468.
 4. Use HSTM118 for next oversize replacement.

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

HEAT TREAT: 655 N/mm² shear minimum per Spec. MIL-H-6875.

FINISH: HSTM18CG-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, with color code green on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.
HSTM18RG-()-() = Cadmium plate per Spec. QQ-P-416, Type I, Class 2, with color code green on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification No. 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
EXAMPLES:

Pin Part Number Only
HSTM18RG-04-8
8 mm Maximum Grip Length
4 mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HSTM18RG79-04-8
Size and Grip Length, See Above Example
Collar Part Number
Pin 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.

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.	
DRAWN D. P. S.	DATE 6-18-84
APPROVED <i>[Signature]</i>	DATE 6-18-84
REVISION ③	DATE 8-1-90
TITLE HI-LITE [®] ST [™] PIN (METRIC SERIES) PROTRUDING SHEAR HEAD ALLOY STEEL 1 mm GRIP VARIATION	
DRAWING NUMBER HSTM18	

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