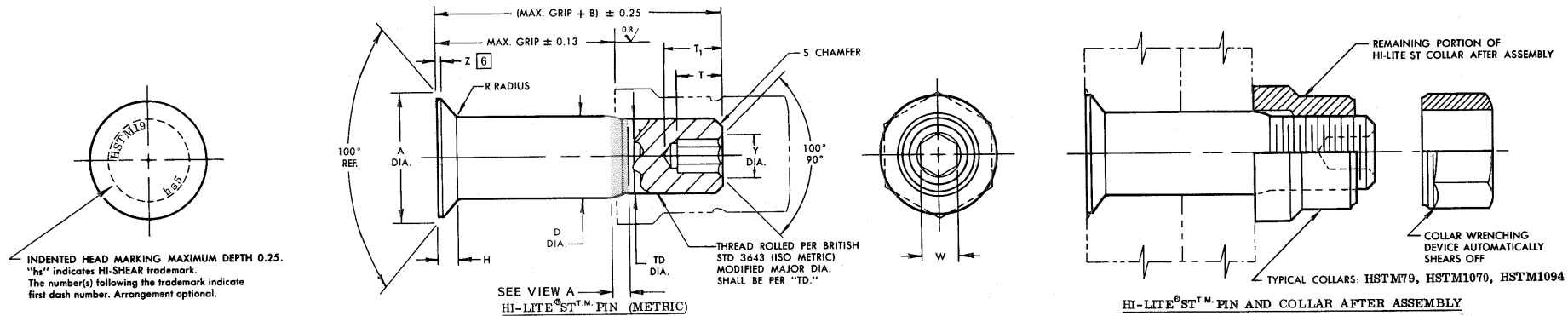




FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
												* W HEX.	T HEX DEPTH MIN.	T1 DEPTH MAX.	Y DIA.		
-04	4	6.49 6.35	7.11	3.990 3.965	3.91 3.86	0.11	1.05 0.99	0.65 0.40	0.25	0.8 x 45°	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 4.965	4.90 4.84	0.13	1.20 1.14	0.75 0.50	0.38	0.8 x 45°	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 5.965	5.88 5.81	0.16	1.55 1.49	0.75 0.50	0.38	0.8 x 45°	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 7.962	7.88 7.80	0.18	1.99 1.93	1.00 0.75	0.38	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	2.75	5.08	4.60 4.05	65800	24400

* INCH STANDARD HEX.

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

- ① GENERAL NOTES:
1. Head edge out of roundness shall not exceed "F".
 2. Concentricity: Conical surface of head to "D" diameter within 0.08 FIR.
 3. "H" is dimensioned from maximum "D" diameter.
 4. Dimensions to be met after finish.
 5. Surface texture per ISO/R468.
 6. Curved or flat edge manufacturer's option.
 7. Use HSTM119 for 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: HSTM19CG-()-() = 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.
HSTM19RG-()-() = 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
HSTM19RG-04-8
— 8 mm Maximum Grip Length
— 4 mm Nominal Diameter Pin
— Pin Part Number

Pin and Collar Assembly Part Number Combination
HSTM19RG79-04-8
— 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. 6-18-84	DATE 6-18-84
APPROVED [Signature]	DATE 6-18-84
REVISION 3	DATE D.P.S. 8-1-90
TITLE HI-LITE[®]ST[™]PIN (METRIC SERIES) 100° FLUSH SHEAR HEAD ALLOY STEEL 1 mm GRIP VARIATION DRAWING NUMBER HSTM19	

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