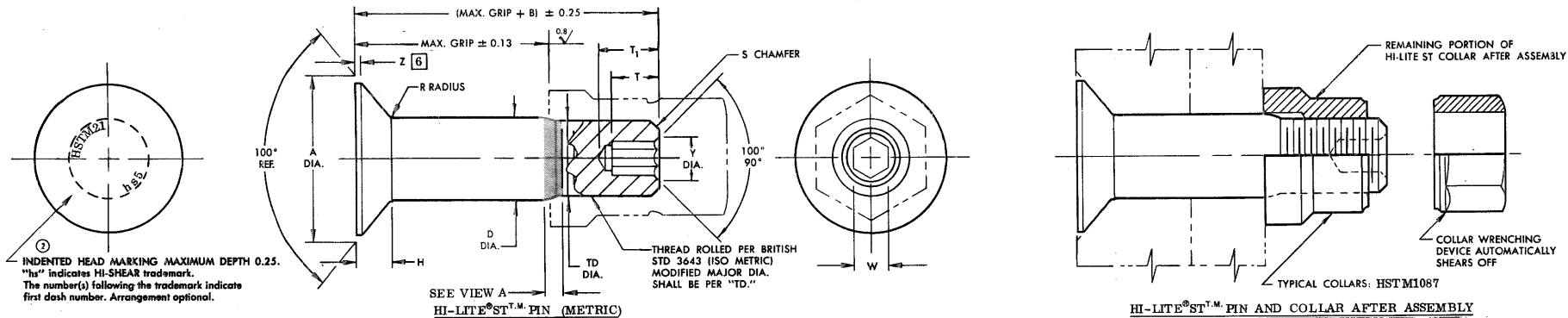




FIRST DASH NO.	①	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
													* W HEX.	T HEX DEPTH MIN.	T1 DEPTH MAX.	Y DIA.		
-04		4	8.13 7.99	7.11	3.990 3.965	3.91 3.86	0.11	1.74 1.68	0.65 0.40	0.25	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	1.63	2.90	2.30 1.90	16400	9800
-05		5	10.13 9.99	7.65	4.990 4.965	4.90 4.84	0.13	2.16 2.10	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	15600
-06		6	12.13 11.99	8.65	5.990 5.965	5.88 5.81	0.16	2.58 2.52	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	22200
-08		8	16.13 15.99	9.65	7.987 7.962	7.88 7.80	0.18	3.42 3.36	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	42000

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH IPIN OR COLLAR DETERMINES SYSTEM STRENGTH.

* INCH STANDARD HEX.

- 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.

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: HSTM21CG-()-() = 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.
HSTM21RG-()-() = 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
HSTM21RG-04-8
— 8 mm Maximum Grip Length
— 4 mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HSTM21RG1087-04-8
— 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 <i>[Signature]</i> 6-18-84	DATE 6-18-84
REVISION ②	DATE D. P. S. 12-5-85
TITLE HI-LITE®ST™ PIN (METRIC SERIES) 100° FLUSH TENSION HEAD ALLOY STEEL 1 mm GRIP VARIATION	
DRAWING NUMBER HSTM21	

©1985 Hi-Shear Corporation

HSTM21