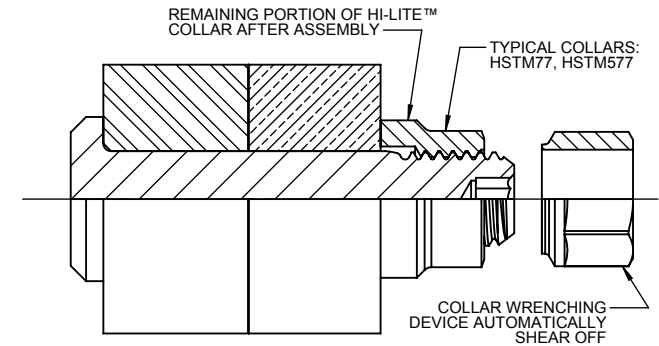
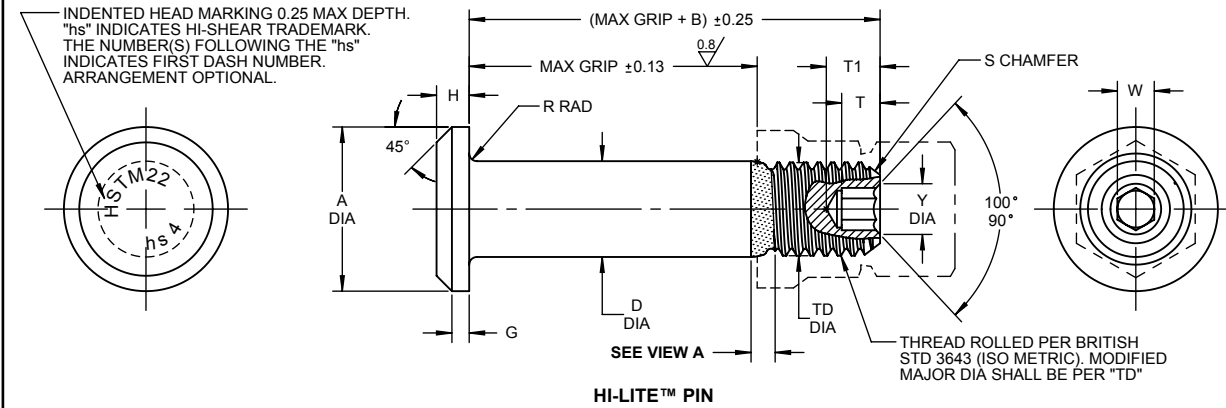




FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
											* W HEX	T HEX DEPTH MIN	T1 DEPTH MAX	Y DIA		
04	4	6.65 6.25	7.11	3.990 3.965	3.91 3.86	0.8	1.52 1.14	0.65 0.40	0.8 x 37°	M4 x 0.7-4h	1.64 1.61	1.63	2.90	2.64 2.39	7560	4000
05	5	8.15 7.65	7.65	4.990 4.965	4.90 4.84	0.9	1.88 1.40	0.65 0.40	0.8 x 37°	M5 x 0.8-4h	2.05 2.01	2.00	3.43	3.05 2.60	11740	5700
06	6	10.20 9.70	8.65	5.990 5.965	5.88 5.81	1.0	2.29 2.08	0.65 0.40	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.25	4.06	3.60 3.10	17800	9074
08	8	12.85 12.25	9.65	7.987 7.962	7.88 7.80	1.4	2.91 2.70	0.75 0.50	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	2.75	5.08	4.60 4.05	31670	13400
10	10	16.20 15.40	11.82	9.987 9.962	9.88 9.80	1.8	3.70 3.45	0.75 0.50	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	3.50	5.97	5.55 5.00	49700	24000
12	12	18.80 18.00	13.33	11.984 11.959	11.87 11.76	2.1	4.26 4.02	0.75 0.50	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	4.30	6.99	6.45 5.90	71500	28700

* INCH STANDARD HEX.

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within 0.25 FIR.
2. Surface texture per ISO/R468.
3. Dimensions are in millimeters and to be met after finish.
4. Use HSTM122 for oversize replacement.

MATERIAL: 7075 aluminum alloy per Spec. AMS-QQ-A-225/9 or QQ-A-430.

HEAT TREAT: Age to T6 condition per Spec. AMS2770.

FINISH:

HSTM22-()-() = Anodize per Spec. MIL-A-8625, dye color natural, with color code black on thread end plus cetyl alcohol lubricant per Hi-Shear Spec. 305.

HSTM22DU-()-() = Anodize per Spec. MIL-A-8625, and solid film lubricant per Spec. AS5272.

HSTM22TF-()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.

Ⓢ HSTM22HK-()-() = HI-KOTE™ 4 NC aluminum pigmented coating per Hi-Shear Spec. 397.

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
EXAMPLE:**

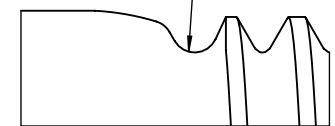
Pin Part Number
HSTM22DU-04-8

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

Pin and Collar Assembly Part Number Combination
HSTM2277-04-8

└─ Size and Grip Length, See Above Combination
└─ 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

"HI-LITE", "HST", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY S. GRAPHICS	DATE 1983-09-30	TITLE HI-LITE™ PIN (METRIC SERIES) PROTRUDING SHEAR HEAD ALUMINUM ALLOY 1 mm GRIP VARIATION
APPROVED E. E. B.	DATE 1983-10-04	
REVISION 8	DATE F. CARINGELLA 2019-05-01	DRAWING NUMBER HSTM22