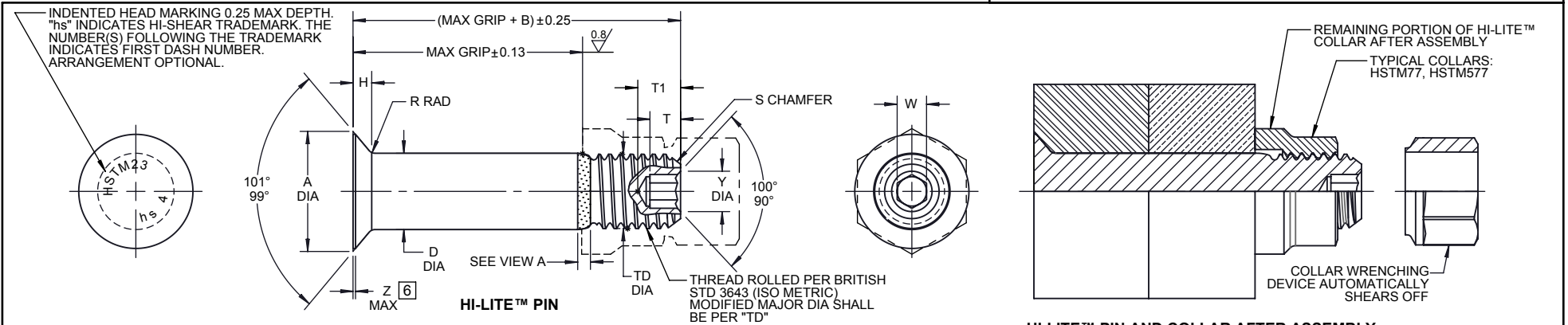


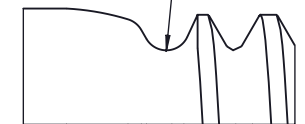


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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		
4	4	7.14 7.02	7.11	3.990 3.965	3.91 3.86	0.11	1.32 1.27	0.65 0.40	0.25	0.8 x 37°	M4 x 0.7-4h	1.64 1.61	1.63	2.90	2.64 2.39	7560	3670
5	5	9.29 9.18	7.65	4.990 4.965	4.90 4.84	0.13	1.80 1.75	0.75 0.50	0.38	0.8 x 37°	M5 x 0.8-4h	2.05 2.01	2.00	3.43	3.05 2.60	11740	5328
6	6	11.32 11.20	8.65	5.990 5.965	5.88 5.81	0.16	2.24 2.18	0.75 0.50	0.38	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.25	4.06	3.60 3.10	17800	8360
8	8	14.40 14.28	9.65	7.987 7.962	7.88 7.80	0.18	2.69 2.64	1.00 0.75	0.38	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	2.75	5.08	4.60 4.05	31670	12450
10	10	18.40 18.28	11.82	9.987 9.962	9.88 9.80	0.21	3.53 3.48	1.00 0.75	0.38	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	21.91 21.79	13.33	11.984 11.959	11.87 11.76	0.23	4.17 4.11	1.00 0.75	0.56	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	4.30	6.99	6.45 5.90	71500	28000

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

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS



VIEW A

HI-LITE™ THREAD TRANSITION AREA
 SEE SPECIFICATION FOR INSPECTION

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F"
 - Concentricity: Conical surface of head to "D" diameter within 0.08 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Surface texture per ISO/R468.
 - Dimensions are in millimeters and to be met after finish.
 - Curved or flat edge manufacturer's option.
 - Use HSTM123 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. AMS-H-6088.

FINISH:

HSTM23-()-() = Anodize per Spec. MIL-A-8625, dye color natural, with color black on thread end, plus cetyl alcohol lubricant per Hi-Shear Spec. 305.

HSTM23DU()-() = Anodize per Spec. MIL-A-8625, and solid film lubricant per Spec. AS5272, type 1.

HSTM23TF()-() = HI-KOTE™ 2 solid film lubricant per Hi-Shear Spec. 292.

Ⓢ HSTM23HK()-() = 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 1mm.
 Second dash number indicates maximum grip in 1mm.
 See Finish note for explanation of code letters.

**HOW TO ORDER
 EXAMPLE:**

Pin Part Number
 HSTM23TF04-8

Pin and Collar Assembly Part Number Combination
 HSTM2377-04-8

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

Size and Grip Length, See Above Example
 Collar Part Number
 Pin Part Number

* INCH STANDARD HEX.

"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) 100° FLUSH SHEAR HEAD ALUMINUM ALLOY 1 mm GRIP VARIATION
APPROVED E.E.B	DATE 1983-10-04	
REVISION 8	DATE F. CARINGELLA 2019-05-02	DRAWING NUMBER HSTM23