lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

Design Holder

CAGE No. 73197

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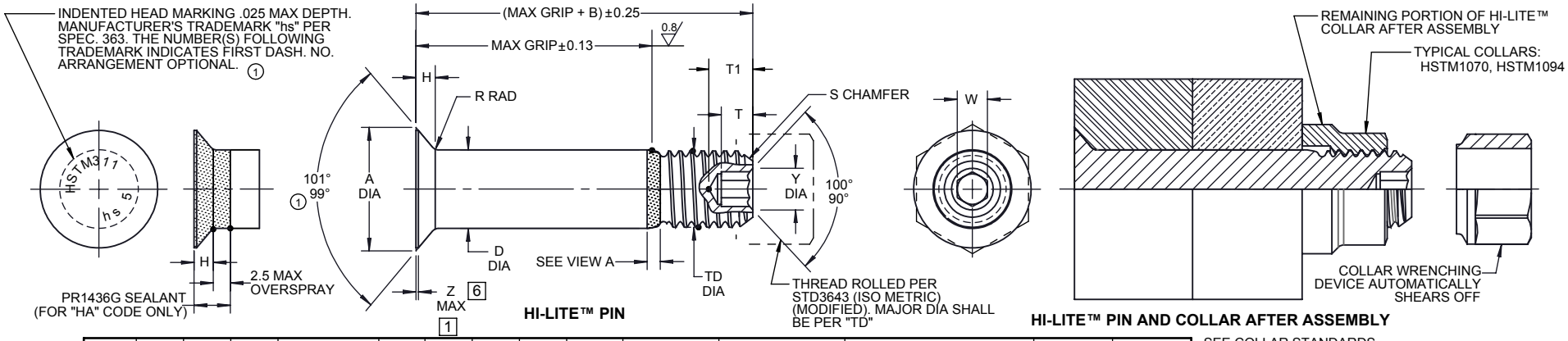
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA HSTM311	D DIA HSTM311AZ AND HSTM311HA	TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD	SOCKET * W HEX	SOCKET T HEX DEPTH MIN	SOCKET T1 DEPTH MAX	SOCKET Y DIA	DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
04	4	6.99 6.85	7.11	4.490 4.478	4.490 4.465	3.91 3.86	0.11	1.05 0.99	0.65 0.40	0.25	0.8 x 37°	M4 x 0.7-4h	1.64 1.61	1.63	2.90	2.30 1.90	20,800	6,200
05	5	8.35 8.21	7.65	5.490 5.478	5.490 5.465	4.90 4.84	0.13	1.20 1.14	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	31,100	9,300
06	6	10.18 10.04	8.65	6.490 6.478	6.490 6.465	5.88 5.81	0.16	1.55 1.49	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	43,500	14,700
08	8	13.23 13.09	9.65	8.487 8.472	8.487 8.462	7.88 7.80	0.18	1.99 1.93	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	74,300	24,400
10	10	16.18 16.04	11.82	10.487 10.472	10.487 10.462	9.88 9.80	0.21	2.39 2.33	1.00 0.75	0.38	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	3.50	5.97	5.50 5.00	113,400	37,800
12	12	18.92 18.78	13.33	12.484 12.466	12.484 12.459	11.87 11.76	0.23	2.70 2.64	1.25 1.00	0.56	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	4.30	6.99	6.45 5.90	160,800	52,000

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN 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" dimensioned from maximum "D" diameter.
4. Surface texture per ISO/R468.
1. 5. Dimensions are in millimeters and to be met after finish.
6. Curved or flat edge manufacturer's option.
7. Use HSTM611 for oversize replacement.
1. 8. After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: 6AL-4V titanium alloy per Spec. AMS4928 or AMS4967 for all sizes.
6AL-6V-2sn titanium alloy per Spec. AMS4971 is acceptable for -10 size and larger.

HEAT TREAT: 655 N/mm^2 shear minimum.

FINISH: HSTM311-( )-( ) = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet (equivalent to LN9368 Blatt 4) with color code black on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.

1. 8. HSTM311AZ-( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 with color code black on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.

1. 8. HSTM311HA-( )-( ) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294 apply precoat No. PR1436G sealant (.051-.127 mm thick) with color code black on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.

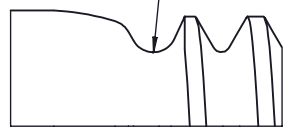
SPECIFICATION: HI-LITE™Product Specification No. M380.

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
1. **EXAMPLE:** Pin Part Number
HSTM311AZ-04-8
8mm Maximum Grip Length
4mm Nominal Diameter Pin
Finish Code
Pin Basic Part Number

~~Pin and Collar Assembly Part Number Combination~~
~~HSTM3111070-04-8~~
~~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

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY	DATE	TITLE
D.P.S.	1987-01-28	HI-LITE™ PIN (METRIC SEIRES) 100° FLUSH SHEAR HEAD TITANIUM 1mm GRIP VARIATION -0.5 mm OVERSIZE
APPROVED	DATE	
E.E.B.	1987-01-28	
REVISION	DATE	DRAWING NUMBER
1	K. TRAN 2017-12-12	HSTM311 1 OF 1

HSTM311