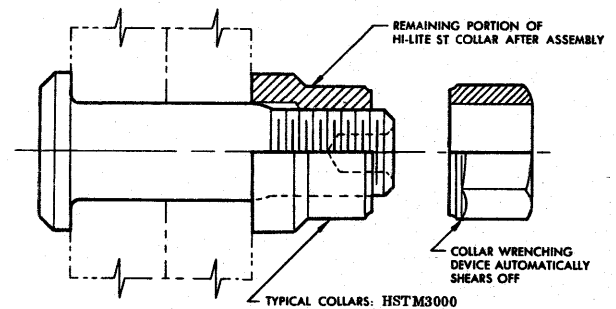
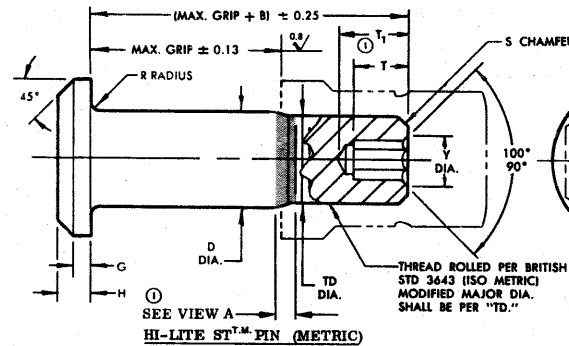
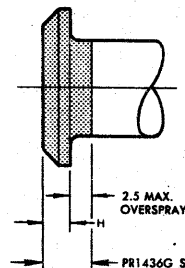
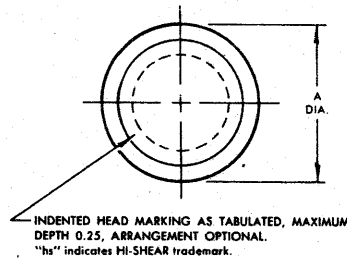


hi-shear
CORPORATION

2800 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



HI-LITE ST™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA. ①		TD DIA.	G REF.	H	R RAD.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET ①				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					HSTM312	HSTM312AU, HSTM312AZ AND HSTM312HA							* W HEX.	T HEX DEPTH MIN.	T ₁ DEPTH MAX.	Y DIA.		
-04	HSTM312M4	4	8.65 8.25	7.11	4.490 4.978	4.490 4.465	3.91 3.86	0.9	1.60 1.40	0.65 0.40	0.8 x 37°	M4 x 0.7-4h	1.64 1.61	1.63	2.90	2.30 1.90	20800	9800
-05	HSTM312M5	5	10.25 9.75	7.65	5.490 5.478	5.490 5.465	4.90 4.84	1.0	1.90 1.65	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	31100	15600
-06	HSTM312M6	6	11.40 10.90	8.65	6.490 6.478	6.490 6.465	5.88 5.81	1.3	2.30 2.05	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	43500	22200
-08	HSTM312M8 x 1	8	13.35 12.75	9.65	8.487 8.472	8.487 8.462	7.88 7.80	1.6	3.05 2.80	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	74300	42000

* INCH STANDARD HEX.

- GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within 0.25 FIR.
 2. Surface texture per ISO/R468.
 3. Dimensions to be met after finish.

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.

① HEAT TREAT: 655 N/mm² shear minimum.

① FINISH: HSTM312-()-() = 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.
HSTM312AU-()-() = Solid film lube per "Electrofilm" XSF-104.
HSTM312AZ-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HSTM312HA-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, apply precoat No. PRI1436G sealant (.051-.127 mm thick) with color code black on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.

① 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
HSTM312-04-8

8 mm Maximum Grip Length
4 mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HSTM3123000-04-8

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

① 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. Patent 4,326,825.
Other U.S. and foreign patents pending.
"Hi-Lite" and "Hi-Lite ST" are trademarks of Hi-Shear Corporation.

DRAWN	DATE	TITLE
D.P.S.	5-18-84	HI-LITE ST™ PIN (METRIC SERIES)
APPROVED	DATE	
E.E.B.	6-11-84	PROTRUDING TENSION HEAD TITANIUM 1 mm GRIP VARIATION - 0.5 mm OVERSIZE
REVISION	DATE	DRAWING NUMBER
①	D.P.S. 12-4-84	HSTM312

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HSTM312