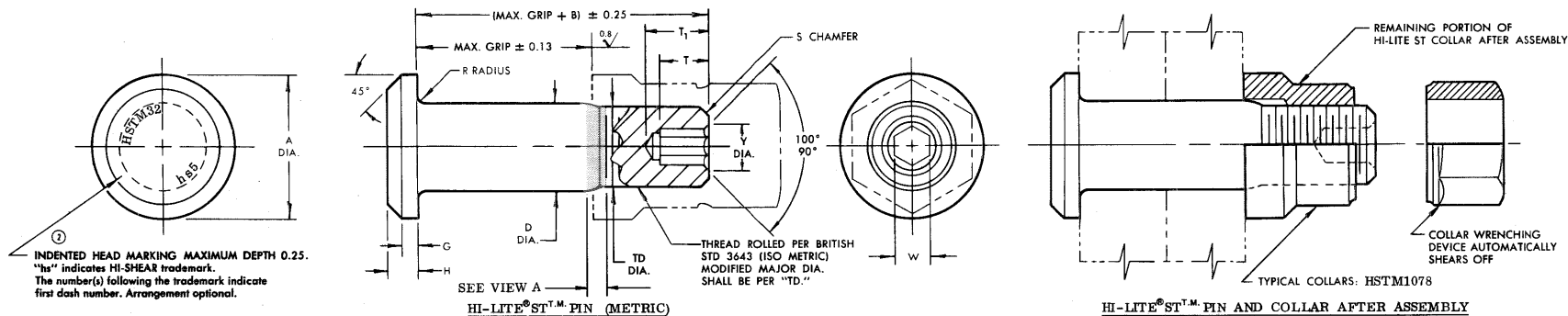


**hi-shear**  
CORPORATION

2600 SKYPARK DRIVE  
TORRANCE, CALIFORNIA 90509  
AREA CODE 213 • 775-3181 • 326-8110



| FIRST DASH NO. | ① | 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         | 8.15<br>7.75   | 7.11   | 8.990<br>3.978 | 3.91<br>3.86 | 0.9    | 1.60<br>1.40 | 0.65<br>0.40 | 0.8 x 45°      | M4 x 0.7-4h       | 1.64<br>1.61 | 1.63             | 2.90          | 2.30<br>1.90 | 18600                        | 11100                   |
| -05            |   | 5         | 9.75<br>9.25   | 7.65   | 4.990<br>4.978 | 4.90<br>4.84 | 1.0    | 1.90<br>1.65 | 0.65<br>0.40 | 0.8 x 45°      | M5 x 0.8-4h       | 2.05<br>2.01 | 2.00             | 3.43          | 3.05<br>2.60 | 29100                        | 17700                   |
| -06            |   | 6         | 10.90<br>10.40 | 8.65   | 5.990<br>5.978 | 5.88<br>5.81 | 1.3    | 2.30<br>2.05 | 0.65<br>0.40 | 0.8 x 45°      | M6 x 1.0-4h       | 2.46<br>2.40 | 2.25             | 4.06          | 3.60<br>3.10 | 41800                        | 25300                   |
| -08            |   | 8         | 12.85<br>12.25 | 9.65   | 7.987<br>7.972 | 7.88<br>7.80 | 1.6    | 3.05<br>2.80 | 0.75<br>0.50 | 1.2 x 45°      | M8 x 1.0-4h       | 3.29<br>3.22 | 2.75             | 5.08          | 4.60<br>4.05 | 74400                        | 47700                   |
|                |   |           |                |        |                |              |        |              |              |                |                   |              |                  |               |              |                              |                         |
|                |   |           |                |        |                |              |        |              |              |                |                   |              |                  |               |              |                              |                         |

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

\* INCH STANDARD HEX

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

CODE: First dash number indicates nominal diameter in 1 mm.  
Second dash number indicates maximum grip in 1 mm.

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 740 MPa shear minimum.

FINISH: HSTM32-( )-( ) = Passivate per Hi-Shear Spec. 258 with color black on thread end.

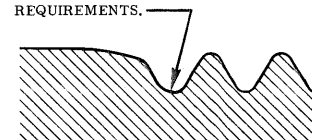
SPECIFICATION: Hi-Lite Product Specification No. M380.

HOW TO ORDER  
EXAMPLES:

Pin Part Number Only  
HSTM32-04-8  
8 mm Maximum Grip Length  
4 mm Nominal Diameter Pin  
Pin Part Number

Pin and Collar Assembly Part Number Combination  
HSTM321078-04-8  
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<br>D. P. S.    | DATE<br>12-14-83 | TITLE<br>HI-LITE <sup>®</sup> ST <sup>™</sup> PIN (METRIC SERIES)<br>PROTRUDING TENSION HEAD<br>NICKEL BASE ALLOY (INCONEL 718)<br>1 mm GRIP VARIATION |
| APPROVED<br>E. E. B. | DATE<br>12-15-83 |                                                                                                                                                        |
| REVISION<br>(2)      | DATE<br>12-5-85  | DRAWING NUMBER<br>HSTM32                                                                                                                               |

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HSTM32