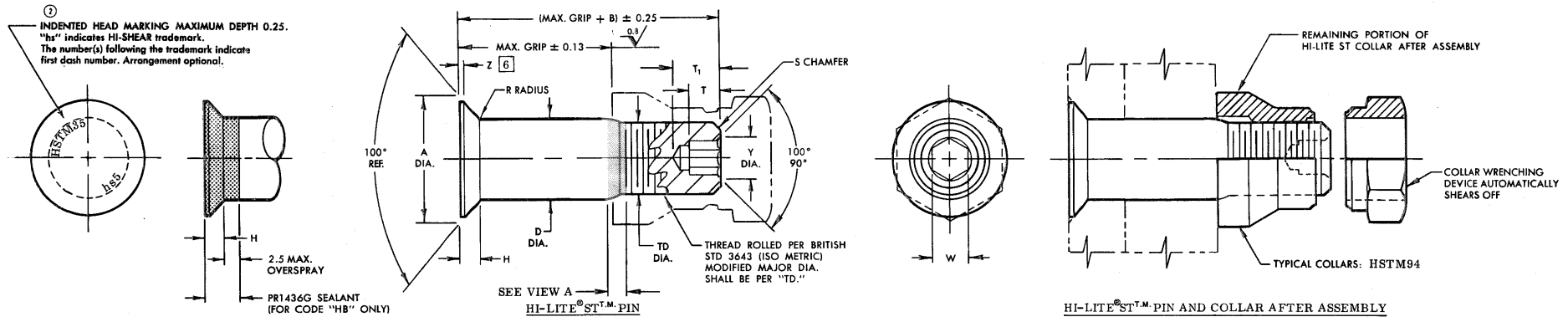




2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



FIRST DASH NO.	①	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					HSTM35	HSTM35TB OR HSTM35HB								* W HEX.	T HEX DEPTH MIN.	T ₁ DEPTH MAX.	Y DIA.		
-04		4	6.49 6.35	7.11	3.990 3.978	3.990 3.965	3.91 3.86	0.11	1.05 0.99	0.65 0.40	0.25	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	1.63	2.90	2.30 1.90	21600	8200
-05		5	7.85 7.71	7.65	4.990 4.978	4.990 4.965	4.90 4.84	0.13	1.20 1.14	0.75 0.50	0.38	0.8 x 45°	M5 x 0.8-4h	2.05 2.01	2.00	3.43	3.05 2.60	33800	12200
-06		6	9.68 9.54	8.65	5.990 5.978	5.990 5.965	5.88 5.81	0.16	1.55 1.49	0.75 0.50	0.38	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.25	4.06	3.60 3.10	48600	19300
-08		8	12.73 12.59	9.65	7.987 7.972	7.987 7.962	7.88 7.80	0.18	1.99 1.93	1.00 0.75	0.38	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	2.75	5.08	4.60 4.05	86500	32000
-10		10	15.68 15.54	11.82	9.987 9.972	9.987 9.962	9.88 9.80	0.21	2.39 2.33	1.00 0.75	0.38	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	3.50	5.97	5.55 5.00	135100	49600
-12		12	18.42 18.28	13.33	11.984 11.966	11.984 11.959	11.87 11.76	0.23	2.70 2.64	1.25 1.00	0.56	1.2 x 45°	M12 x 1.25-4h	4.90 4.81	4.30	6.99	6.45 5.90	194500	68300

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

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

MATERIAL: PH13-8Mo stainless steel per Spec. AMS5629.

HEAT TREAT: 860 MPa shear minimum.

FINISH: HSTM35-()-() = Passivate per Hi-Shear Spec. 258 with black paint on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

HSTM35HB-()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and apply precoat No. PR1436G sealant (.051-.127 mm thick) plus cetyl alcohol lube per Hi-Shear Spec. 305.

HSTM35TB-()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and 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.

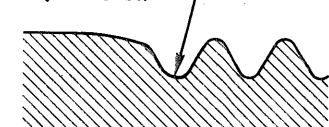
HOW TO ORDER

EXAMPLES:

Pin Part Number Only
HSTM35-04-8
8 mm Maximum Grip Length
4 mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HSTM3594-04-8
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.

* Inch standard hex.

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 D. P. S.	DATE 2-17-84
APPROVED E. P. B.	DATE 2-17-84
REVISION (2)	DATE D. P. S. 12-3-85
HI-LITE® ST™ PIN (METRIC SERIES) 100° FLUSH SHEAR HEAD PH13-8Mo STAINLESS STEEL 1 mm GRIP VARIATION DRAWING NUMBER HSTM35	

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HSTM35