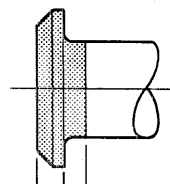
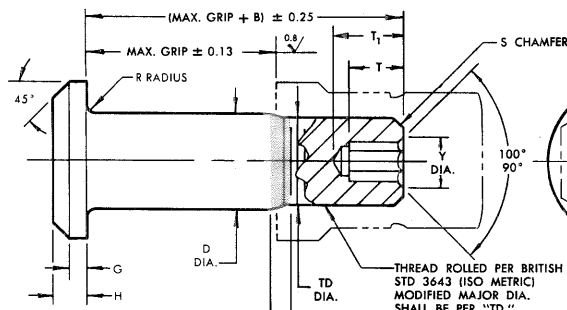


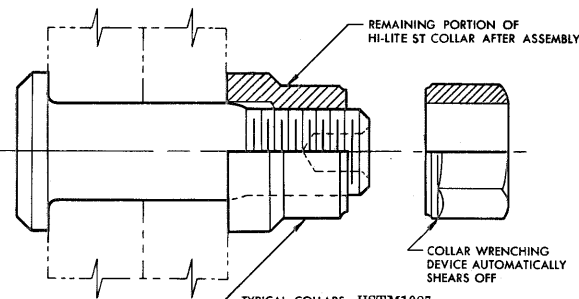
③ INDENTED HEAD MARKING MAXIMUM DEPTH 0.25.
"hs" indicates HI-SHEAR trademark.
The number(s) following the trademark indicate first dash number. Arrangement optional.



PR1436G SEALANT
ON BEARING FACE
(FOR CODE "HB" ONLY)



SEE VIEW A
HI-LITE® ST™ PIN



HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

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
					HSTM36	HSTM36HB OR HSTM36TB							* W HEX.	T HEX DEPTH MIN.	T ₁ DEPTH MAX.	Y DIA.		
-04		4	8.15 7.75	7.11	3.990 3.978	3.990 3.965	3.91 3.86	0.9	1.60 1.40	0.65 0.40	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	1.63	2.90	2.30 1.90	21600	13600
-05		5	9.75 9.25	7.65	4.990 4.978	4.990 4.965	4.90 4.84	1.0	1.90 1.65	0.65 0.40	0.8 x 45°	M5 x 0.8-4h	2.05 2.01	2.00	3.43	3.05 2.60	33800	22000
-06		6	10.90 10.40	8.65	5.990 5.978	5.990 5.965	5.88 5.81	1.3	2.30 2.05	0.65 0.40	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.25	4.06	3.60 3.10	48600	31100
-08		8	12.85 12.25	9.65	7.987 7.972	7.987 7.962	7.88 7.80	1.6	3.05 2.80	0.75 0.50	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	2.75	5.08	4.60 4.05	86500	58000
-10		10	16.20 15.40	11.82	9.987 9.972	9.987 9.962	9.88 9.80	1.9	3.75 3.50	0.75 0.50	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	3.50	5.97	5.55 5.00	135100	90800
-12		12	18.80 18.00	13.33	11.984 11.966	11.984 11.959	11.87 11.76	2.3	4.45 4.20	0.75 0.50	1.2 x 45°	M12 x 1.25-4h	4.90 4.81	4.30	6.99	6.45 5.90	194500	130700

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH IPIN OR COLLAR DETERMINES SYSTEM STRENGTH.

GENERAL NOTES: 1. Concentricity: Head to "D" diameter within 0.25 FIR.
2. Dimensions to be met after finish.
3. Surface texture per ISO/R468.
4. Overspray permitted within "H" dimension and 2.5 maximum on shank.

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

HEAT TREAT: 860 MPa shear minimum.

FINISH: HSTM36-()-() = Passivate per Hi-Shear Spec. 258 with black paint on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
HSTM36HB-()-() = 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.
HSTM36TB-()-() = 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
HSTM36-04-8
8 mm Maximum Grip Length
4 mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HSTM361087-04-8
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	DATE	HI-LITE® ST™ PIN (METRIC SERIES) PROTRUDING TENSION HEAD PH13-8Mo STAINLESS STEEL 1 mm GRIP VARIATION
D. P. S.	2-17-84	
APPROVED	DATE	
E. E. B.	2-17-84	
REVISION	DATE	DRAWING NUMBER
②	D. P. S. 12-3-85	HSTM36

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