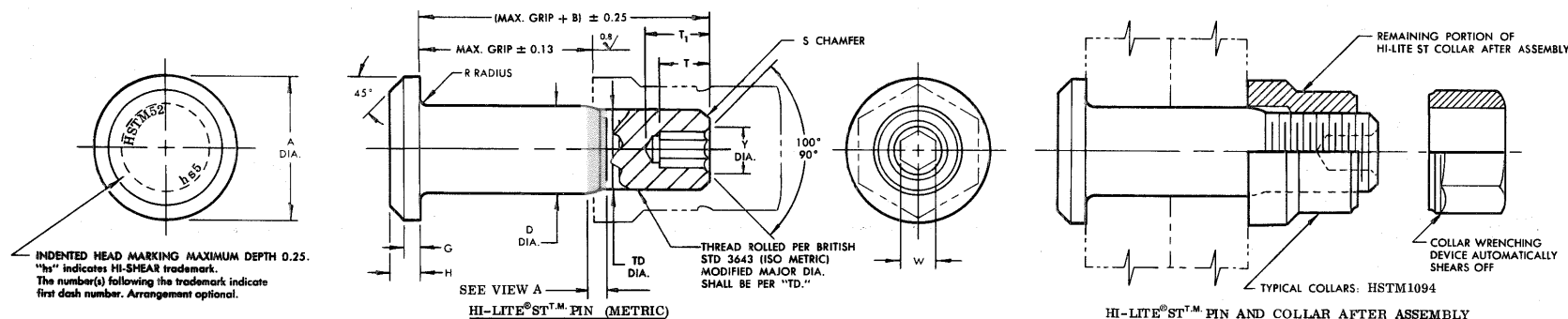


**hi-shear**  
CORPORATION

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



| FIRST DASH NO. | 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         | 6.65<br>6.25   | 7.11   | 3.990<br>3.978 | 3.91<br>3.86 | 0.9    | 1.20<br>0.95 | 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 | 21600                        | 10300                   |
| -05            | 5         | 8.15<br>7.65   | 7.65   | 4.990<br>4.978 | 4.90<br>4.84 | 1.0    | 1.40<br>1.15 | 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 | 33800                        | 15500                   |
| -06            | 6         | 10.20<br>9.70  | 8.65   | 5.990<br>5.978 | 5.88<br>5.81 | 1.3    | 1.75<br>1.50 | 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 | 48600                        | 23900                   |
| -08            | 8         | 12.85<br>12.25 | 9.65   | 7.987<br>7.972 | 7.88<br>7.80 | 1.6    | 2.20<br>1.95 | 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 | 86500                        | 41500                   |
|                |           |                |        |                |              |        |              |              |                |                   |              |                  |               |              |                              |                         |
|                |           |                |        |                |              |        |              |              |                |                   |              |                  |               |              |                              |                         |

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.

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 860 MPa shear minimum.

FINISH: HSTM52-( )-( ) = 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

HSTM52-04-8

8 mm Maximum Grip Length

4 mm Nominal Diameter Pin

Pin Part Number

Pin and Collar Assembly Part Number Combination

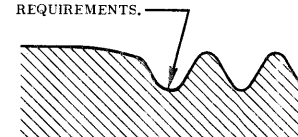
HSTM521094-04-8

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    |  | DATE     |  | TITLE                           |  |
|----------|--|----------|--|---------------------------------|--|
| D. P. S. |  | 6-27-88  |  | HI-LITE ST PIN (METRIC SERIES)  |  |
| APPROVED |  | DATE     |  | PROTRUDING SHEAR HEAD           |  |
| E.E.B.   |  | 6-28-88  |  | NICKEL BASE ALLOY (INCONEL 718) |  |
| REVISION |  | DATE     |  | 1 mm GRIP VARIATION             |  |
| ①        |  | D. P. S. |  | DRAWING NUMBER                  |  |
|          |  | 10-9-89  |  | HSTM52                          |  |

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HSTM52