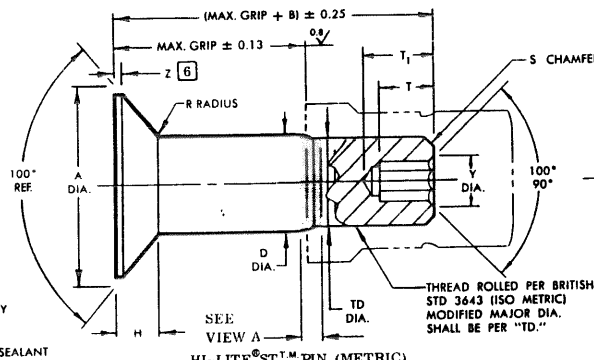
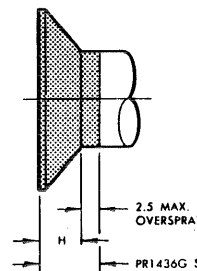
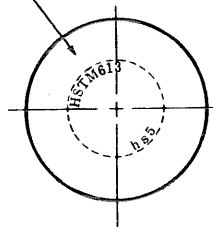
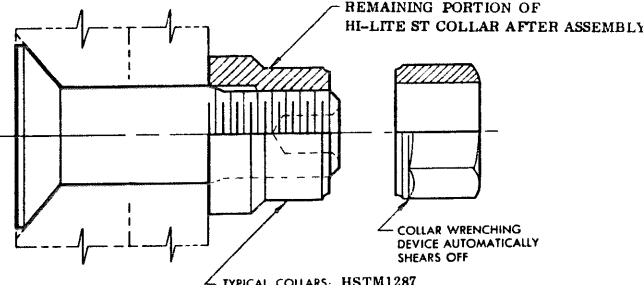
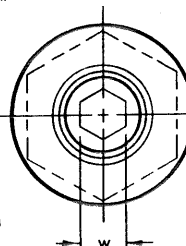


INDENTED HEAD MARKING MAXIMUM DEPTH 0.25.
"hs" indicates HI-SHEAR trademark.
The number(s) following the trademark indicate first dash number. Arrangement optional.



HI-LITE®ST™ PIN (METRIC)



TYPICAL COLLARS: HSTM1287

HI-LITE®ST™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	1 F	H	R RAD.	6 Z MAX.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
				HSTM613	HSTM613AU HSTM613AZ AND HSTM613HA								* W HEX.	T HEX DEPTH MIN.	T1 DEPTH MAX.	Y DIA.		
-04	4	NOTE: USE HSTM13-05 (SEE HSTM13 SALES DRAWING FOR COLLAR SELECTION)																
-05	5	NOTE: USE HSTM13-06 (SEE HSTM13 SALES DRAWING FOR COLLAR SELECTION)																
-06	6	13.13 12.99	8.65	6.990 6.978	6.990 6.965	5.88 5.81	0.16	2.58 2.52	0.75 0.50	0.38	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.25	4.06	3.60 3.10	50400	22200
-08	8	17.13 16.99	9.65	8.987 8.972	8.987 8.962	7.88 7.80	0.18	3.42 3.36	1.00 0.75	0.38	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	2.75	5.08	4.60 4.05	83300	42000
-10	10	21.13 20.99	11.82	10.987 10.972	10.987 10.962	9.88 9.80	0.21	4.26 4.20	1.00 0.75	0.38	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	3.50	5.97		124500	68000
-12	12	25.13 24.99	13.33	12.984 12.966	12.984 12.959	11.87 11.76	0.23	5.10 5.04	1.25 1.00	0.56	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	4.30	6.99		173900	100200

* INCH STANDARD HEX.

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

- GENERAL NOTES: 1. Head edge out of roundness shall not exceed "F."
2. Concentricity: Conical surface of head to "D" diameter within 0.08 FIR.
3. "H" is dimensioned from maximum "D" diameter.
4. Surface texture per ISO/R468.
5. Dimensions to be met after finish.
6. Curved or flat edge manufacturer's option.

MATERIAL: 6Al-4V titanium alloy per Spec. AMS 4928 or AMS 4967 for all sizes.
6Al-6V-2Sn titanium alloy per Spec. AMS 4971 is acceptable for -10 size and larger.

HEAT TREAT: 655 N/mm² minimum.

FINISH: HSTM613-()-() = 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.
HSTM613AU-()-() = Solid film lube per "Electrofilm" XSF-104.
HSTM613AZ-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color code black on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.
HSTM613HA-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, apply precoat No. PR1436G sealant (.051-.127 mm thick) with color code black on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification No. M380.

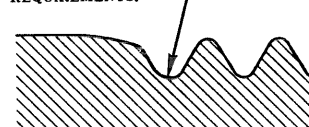
CODE: First dash number indicates nominal diameter in 1 mm.
Second dash number indicates maximum grip in 1 mm.
See "Finish" note for explanation of code letters.

HOW TO ORDER
EXAMPLES: Pin Part Number Only

HSTM613-04-8
8 mm Maximum Grip Length
4 mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HSTM6131287-04-8
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.		4-10-87		HI-LITE®ST™ PIN (METRIC SERIES)	
APPROVED		DATE		100° FLUSH TENSION HEAD	
E.P.B.		4-14-87		TITANIUM	
REVISION		DATE		1 mm GRIP VARIATION-1 mm OVERSIZE	
				DRAWING NUMBER	
				HSTM613	