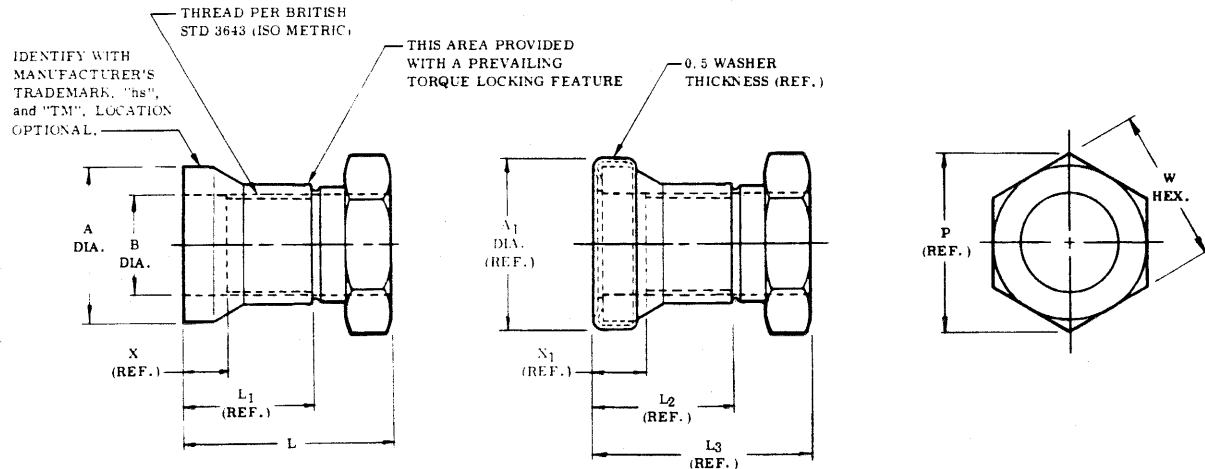


hi-shear
CORPORATION

2600 Skypark Drive
Torrance, California 90509 U.S.A.
Telephone (310) 326-8110
FAX (310) 784-4144

Hi-Shear Corporation, U.S.A. (Patent Holder).... CAGE No. 73107
Division of Hi-Shear Industries, Inc., U.S.A.
Air Industries Co. Inc. (Licensee - U.S.A. & Canada) CAGE No. 06726
SPS Technologies, U.S.A. (Licensee)..... CAGE No. 06078
Hi-Shear Fasteners Europe Ltd., U.K. (Licensee) CAGE No. 0L808
Division of Hi-Shear Industries, Inc., U.S.A.

KAMAX WERKE Germany (Licensee-EEC Countries)
Rudolph Kellerman GmbH & Co.
SIMMONDS S.A. France (Licensee-EEC Countries-Collore)
St.-Chamond Granat S.A. France (Licensee-EEC Countries)
Tokyo Screw Company, Japan (Licensee-Japan)



(8)

DASH NO. (METRIC)	PIN NOM. DIA.	THREAD	A DIA.	A DIA. (REF.)	B DIA.	L	L1 (REF.)	L2 (REF.)	L3 (REF.)	P (REF.)	W HEX.	X (REF.)	X (REF.)	TORQUE-OFF NEWTON-METER	ULT TNSN STR NEWTONS MINIMUM
-04	4	M4 x 0.7-4H5H	7.49 7.24	8.7	4.78 4.62	10.16 9.65	5.58	6.3	10.6	8.87	8.00 7.78	1.7	2.4	1.7 - 2.9	5800
-05	5	M5 x 0.8-4H5H	8.24 7.99	9.5	5.78 5.62	10.42 9.90	5.84	6.5	10.8	11.10	10.00 9.78	1.7	2.4	2.8 - 4.6	7300
-06	6	M6 x 1.0-4H5H	10.77 10.52	12.2	6.78 6.62	11.94 11.43	6.60	7.4	12.5	12.12	11.00 10.73	2.3	3.1	5.6 - 9.1	12000
-08	8	M8 x 1.0-4H5H	13.45 13.20	15.0	8.82 8.62	14.23 13.71	8.12	9.0	14.9	14.40	13.00 12.73	2.4	3.3	14.6 - 18.1	22200
-10	10	M10 x 1.0-4H5H	16.63 16.33	17.9	10.88 10.63	16.39 15.87	9.52	10.5	17.1	15.56	14.00 13.73	2.4	3.4	23.7 - 28.3	33300
-12	12	M12 x 1.25-4H5H	21.85 21.55	23.0	12.88 12.63	18.80 18.28	10.92	11.9	19.6	18.90	17.00 16.73	2.5	3.5	36.1 - 43.0	48900

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 2. Dimensions apply after finish.
 3. Use HSTM370 for oversize replacement.

MATERIAL: Collar - 7075 aluminum alloy per QQ-A-225/9.
Washer - 2024 aluminum alloy per QQ-A-250/4 or 250/5.

HEAT TREAT: Collar - Age to T73 condition per MIL-H-6088.
Washer - Age to T6 condition per MIL-H-6088.

FINISH: Collar - HSTM70-() = Anodize, dye color black, and cetyl alcohol lube per Hi-Shear Spec. 305.
Collar & Washer - HSTM70RW-() = Collar finish same as HSTM70-(), and washer with anodize, dye color red.

SPECIFICATION: Hi-Lite Product Specification M381.

CODE: Dash number indicates nominal thread size in 1 mm.
See finish note for explanation of code letters.

EXAMPLE: HSTM70-08 = M8 x 1.0 Hi-Lite ST collar.
HSTM70RW-08 = M8 x 1.0 Hi-Lite ST collar with aluminum washer.

U.S. Patents 4,326,825; 4,485,510 and 4,957,401.
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	BY	HI-LITE® ST™ COLLAR (METRIC SERIES) 7075-T73 ALUMINUM ALLOY 1 mm GRIP VARIATION SHEAR APPLICATION FOR USE ON STANDARD AND 0.5 mm OVERSIZE HI-LITE ST PINS	DRAWING NUMBER
	3-23-83	D.P.S.		
APPROVED	3-23-83	R.Ting		HSTM70
(8) REVISION	10-25-93	T. Craine		