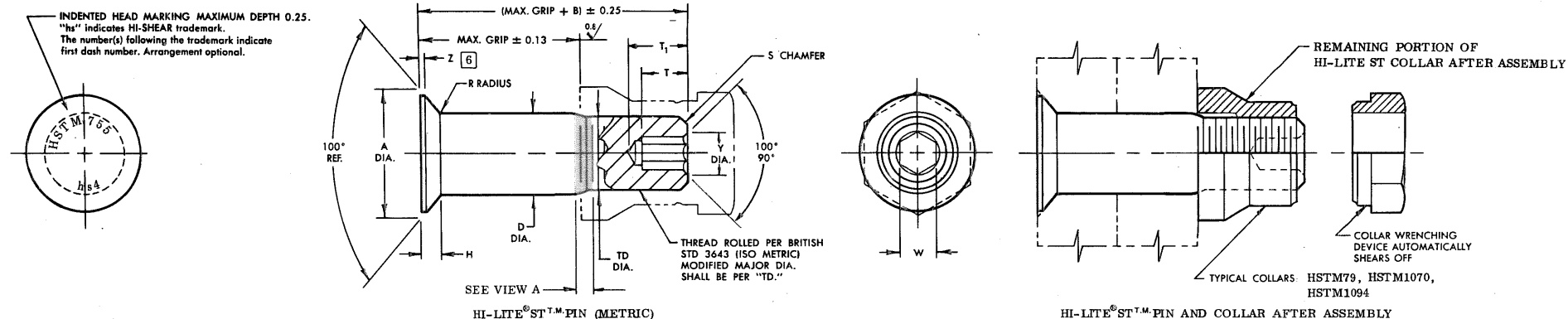


hi-shear
CORPORATION

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.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
				HSTM755	HSTM755AZ								* W HEX.	T HEX DEPTH MIN.	T1 DEPTH MAX.	Y DIA.		
-04	4	7.49 7.21	7.11	3.990 3.978	3.990 3.965	3.91 3.86	0.11	1.47 1.55	0.65 0.40	0.25	0.8 x 37°	M4 x 0.7-4h	2.03 2.01	1.63	2.90	7	16400	7,000
-05	5	9.57 9.28	7.65	4.990 4.978	4.990 4.965	4.90 4.84	0.13	1.42 1.80	0.75 0.50	0.38	0.8 x 37°	M5 x 0.8-4h	2.05 2.01	2.00	3.43	3.05 2.60	25700	11,700
-06	6	11.52 11.23	8.65	5.990 5.978	5.990 5.965	5.88 5.81	0.16	2.32 2.20	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	37000	16,700
-08	8	15.66 15.38	9.65	7.987 7.972	7.987 7.962	7.88 7.80	0.18	3.22 3.10	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	65800	31,500
-10	10	18.62 18.53	11.82	9.987 9.972	9.987 9.962	9.88 9.80	0.21	3.62 3.50	1.00 0.75	0.38	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	3.50	5.97	5.50 5.00	102900	49,600
-12	12	20.61 20.33	13.33	11.984 11.966	11.984 11.959	11.87 11.76	0.23	3.62 3.50	1.25 1.00	0.56	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	4.30	6.99	6.45 5.90	148100	70,100

* INCH STANDARD HEX.

- 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.
 - Surface texture per ISO/R468.
 - Dimensions to be met after finish.
 - Curved or flat edge manufacturer's option.
 - Evidence of broken edge across points.

MATERIAL: 6Al-4V titanium alloy per Spec. AMS4928 or AMS4967 for all sizes.
6Al-6V-2Sn titanium alloy per Spec. AMS4971 is acceptable for -10 size and larger.

HEAT TREAT: 655 N/mm² shear minimum.

FINISH: HSTM755-()-() = 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.

HSTM755AZ-()-() = 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.

SPECIFICATION: Hi-Lite Product Specification No. M380.

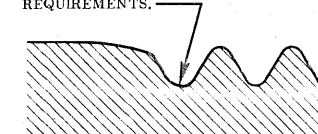
CODE: First dash number indicates nominal diameter in 1 mm.
Second dash number indicates maximum grip in 1 mm.
See "Finish" note for explanation of code letters.

HOW TO ORDER
EXAMPLES:

Pin Part Number Only
HSTM755-04-8
8 mm Maximum Grip Length
4 mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HSTM75579-04-8
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 S. Graphics 1-13-86	TITLE HI-LITE ST™ PIN (METRIC SERIES) 100° FLUSH SPECIAL SHEAR HEAD TITANIUM 1 mm GRIP VARIATION
APPROVED DATE E.E. Beebe 1-21-86	DRAWING NUMBER HSTM755
REVISION DATE	