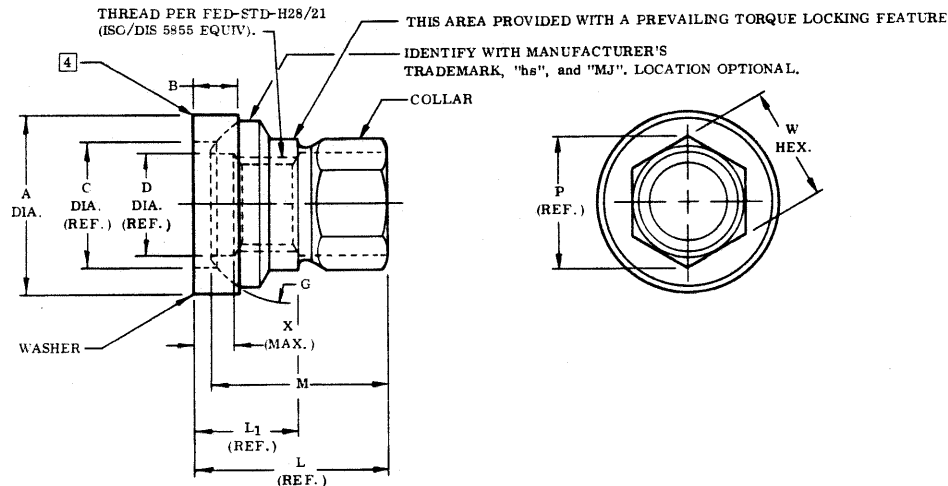


"CAGE" = Commercial And Government Entity

hi-shear
CORPORATION

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Division of Hi-Shear Industries, Inc., U.S.A.
Air Industries Co. Inc. (Licensee - U.S.A. & Canada) CAGE No. 06725
SPS Technologies, U.S.A. (Licensee)..... CAGE No. 56878
Hi-Shear Fasteners Europe Ltd., U.K. (Licensee) CAGE No. 01868
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-Collare)
St.-Chamond Granat S.A. France (Licensee-EEC Countries)
Tokyo Screw Company, Japan (Licensee-Japan)



DASH NO. (METRIC)	PIN NOM. DIA.	THREAD	A DIA.	B	C DIA. (REF.)	D DIA. (REF.)	G SPHER. RAD. (REF.)	L (REF.)	L1 (REF.)	M	P (REF.)	W HEX.	X (REF.)	TORQUE-OFF NEWTON-METER	ULT TNSN STR NEWTONS MINIMUM
-04	4	MJ4 x 0.7-4H6H	9.27 9.01	1.09 1.72	6.0	4.2	5.1	10.80	5.58	9.84 9.33	5.54	5.00 4.78	1.7	1.7 - 2.9	9800
-05	5	MJ5 x 0.8-4H6H	10.90 10.64	2.29 2.03	6.5	5.2	5.1	11.05	5.84	10.35 9.84	6.65	6.00 5.78	1.7	2.8 - 4.6	12700
-06	6	MJ6 x 1.0-4H5H	12.80 12.54	2.67 2.41	8.1	6.2	6.7	13.09	6.60	12.33 11.82	7.82	7.00 6.78	2.3	5.6 - 9.1	20700
-08	8	MJ8 x 1.0-4H5H	16.70 16.44	3.00 2.74	10.6	8.2	8.7	15.88	8.12	14.81 14.30	10.72	9.50 9.28	2.4	14.6 - 18.1	36900
-10	10	MJ10 x 1.25-4H5H	20.60 20.34	3.94 3.68	13.0	10.2	11.4	17.65	9.52	16.32 15.81	13.54	12.00 11.73	2.7	23.7 - 28.3	62300

- NOTES:
1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 2. Dimensions apply after finish.
 3. For use on sloped surfaces up to 7° maximum on Hi-Lite ST standard pins.
 4. Break sharp edge.

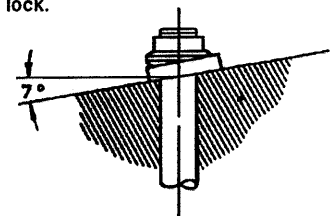
MATERIAL: Collar - 6Al-4V titanium alloy per AMS4928, AMS4930 or AMS4967.
Washer - 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo per AMS5520.

④ FINISH: Collar - HSTMJ1076DL-()A = Solid film lube per MIL-L-46010, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
HSTMJ1076TA-()A = Pretreat per Hi-Shear Ti-Shield III, and Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, with color orange identification on barrel, plus cetyl alcohol lube per Hi-Shear Spec. 305.
HSTMJ1076UM-()A = Pretreat per Hi-Shear Ti-Shield III, and Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, with color green identification on body of collar, plus cetyl alcohol lube per Hi-Shear Spec. 305.
Washer - HSTMJ1076-()W = Passivate per Hi-Shear Spec. 258, and Hi-Kote 2 solid film lube Hi-Shear Spec. 292.

SPECIFICATION: Hi-Lite Product Specification M381, except thread as noted.

CODE: Dash number indicates nominal thread size in 1 mm.
Code letter "A" following dash number indicates Hi-Lite collar only.
Code letter "W" following dash number indicates self-aligning washer only.
See finish note for explanation of code letters.

EXAMPLE: HSTMJ1076TA-08AW = MJ8 x 1.0 Hi-Lite ST collar with HSTMJ1076-08W self-aligning washer.
HSTMJ1076TA-08A = MJ8 x 1.0 Hi-Lite ST collar with Hi-Kote 2 solid film lube.
HSTMJ1076-08W = 8 mm size self-aligning 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.

DATE	BY	TITLE	DRAWING NUMBER
DRAWN 5-20-91	D.P.S.	HI-LITE® ST™ COLLAR (MJ METRIC SERIES)	HSTMJ1076
APPROVED 5-20-91	J.G. Wilcox	SELF-ALIGNING COLLAR ASSEMBLY 6AL-4V TITANIUM ALLOY 1 mm GRIP VARIATION SHEAR APPLICATION	
④ REVISION 10-25-93	T. Craine		