

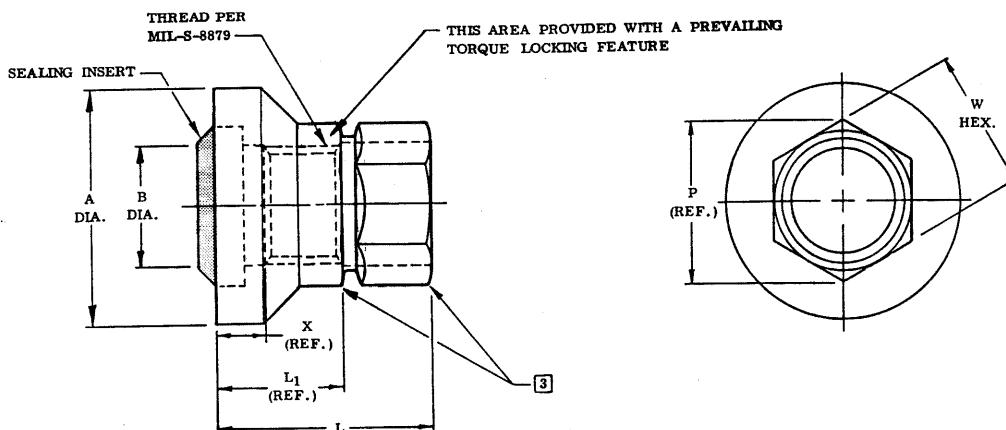
**hi-shear**  
CORPORATION

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'CAGE' = Commercial And Government Entity

Hi-Shear Corporation, U.S.A. (Patent Holder).....CAGE No. 73197  
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. 0LB68  
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 - Collins)  
St. Chamond Grand S.A. France.....(Licensee - EEC Countries)  
Tokyo Screw Company, Japan.....(Licensee - Japan)



| DASH NO. (METRIC) | PIN NOM. DIA. | THREAD             | A DIA.         | B DIA.         | L              | L <sub>1</sub> (REF.) | P (REF.) | W HEX.         | X (REF.) | TORQUE-OFF NEWTON-METER | ULT TNSN STR NEWTONS MINIMUM |
|-------------------|---------------|--------------------|----------------|----------------|----------------|-----------------------|----------|----------------|----------|-------------------------|------------------------------|
| -04               | 4             | MJ4 x 0.7-4H6H     | 9.15<br>8.90   | 4.78<br>4.62   | 10.16<br>9.65  | 5.58                  | 6.6      | 6.00<br>5.78   | 1.7      | 1.7 - 2.9               | 9600                         |
| -05               | 5             | MJ5 x 0.8-4H6H     | 10.55<br>10.30 | 5.78<br>5.62   | 10.42<br>9.90  | 5.84                  | 7.8      | 7.00<br>6.78   | 1.7      | 2.8 - 4.6               | 12700                        |
| -06               | 6             | MJ6 x 1.0-4H5H     | 12.45<br>12.20 | 6.78<br>6.62   | 11.94<br>11.43 | 6.60                  | 8.9      | 8.00<br>7.78   | 2.3      | 5.6 - 9.1               | 20700                        |
| -08               | 8             | MJ8 x 1.0-4H5H     | 16.25<br>16.00 | 8.82<br>8.62   | 14.99<br>14.47 | 8.12                  | 12.1     | 11.00<br>10.73 | 2.4      | 14.6 - 18.1             | 36900                        |
| -10               | 10            | ① MJ10 x 1.25-4H5H | 19.80<br>19.50 | 10.88<br>10.63 | 17.40<br>16.88 | 9.52                  | 13.4     | 13.00<br>12.73 | 2.7      | 23.7 - 28.3             | 62300                        |
|                   |               |                    |                |                |                |                       |          |                |          |                         |                              |
|                   |               |                    |                |                |                |                       |          |                |          |                         |                              |

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
  2. Dimensions apply after finish.
  3. Burrs from cutoff process and cutting torque-off groove allowed.

**MATERIAL:** Collar - 3Al-2.5V titanium alloy per AMS4943 (MIL-T-9047).  
Insert - Teflon per ASTM D1710 Type I Grade 1.

**FINISH:** Collar - HSTMJ1284TR-( ) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.

Insert - None.

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

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

**EXAMPLE:** HSTMJ1284TR-08 = MJ8 x 1.0 Hi-Lite ST titanium collar with Teflon insert and Hi-Kote 2 solid film lube and cetyl alcohol lube.

U.S. Patents 4,326,825; 4,485,510 and 4,957,401.  
Other U.S. and foreign patents pending. "Hi-Lite" and "HST" are registered trademarks and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.

|            | DATE     | BY         | TITLE                                                                                                                                                                                                                              | DRAWING NUMBER   |
|------------|----------|------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------|
| DRAWN      | 8-16-94  | J.F.Obispo | <b>HI-LITE® ST™ COLLAR</b><br><b>(SEALING TYPE, MJ METRIC SERIES)</b><br>3AL-2.5V TITANIUM ALLOY WITH TEFLON INSERT<br>1 mm GRIP VARIATION<br>SHEAR APPLICATION FOR USE ON STANDARD<br>AND 0.5mm OVERSIZE DIAMETER HI-LITE ST PINS | <b>HSTMJ1284</b> |
| APPROVED   | 8-17-94  | JGWilcox   |                                                                                                                                                                                                                                    |                  |
| ① REVISION | 11-22-95 | J.F.Obispo |                                                                                                                                                                                                                                    |                  |