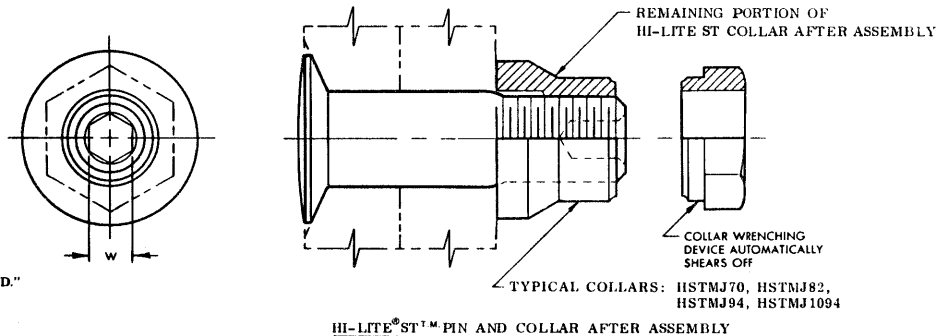
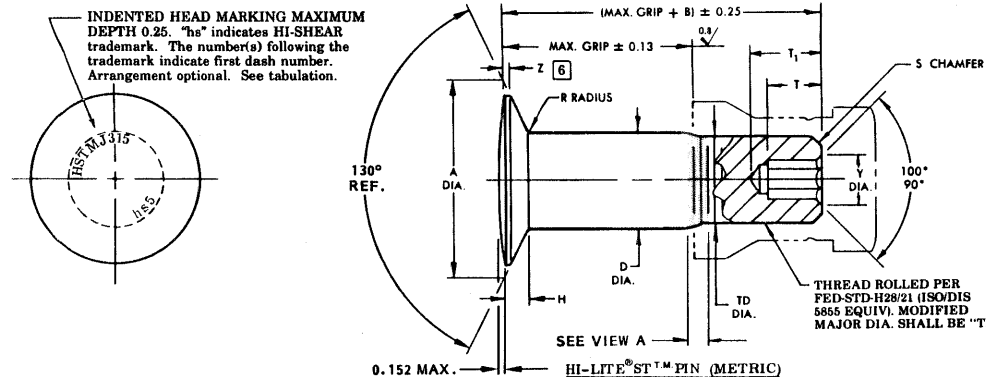


hi-shear
CORPORATION

2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110

"CAGE" - Commercial And Government Entity			
HI-SHEAR CORPORATION, U.S.A. (Patent Holder)	CAGE No. 73197	KAMAX-WERKE Germany (Licensee-EEC Countries)	
Division of Hi-Shear Industries, Inc., U.S.A.		Rudolph Kellerman GmbH	
AIR INDUSTRIES CO., INC. (Licensee)	CAGE No. 96725	SIMMONDS S.A. France (Licensee-EEC Countries-Collars)	
SPS TECHNOLOGIES, U.S.A. (Licensee)	CAGE No. 96876	St.-CHAMOND GRANAT S.A. France (Licensee-EEC Countries)	
HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee)	CAGE No. 01866	TOKYO SCREW COMPANY, Japan (Licensee-Japan)	



FIRST DASH NO.	HEAD MARKING	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
					HSTMJ315YY	HSTMJ315TB								* W HEX.	T HEX DEPTH MIN.	T ₁ DEPTH MAX.	Y DIA.		
-04	MJ315 hs4	4	8.46 8.23	7.11	3.990 3.978	3.990 3.965	3.91 3.86	0.11	1.05 0.99	0.65 0.40	0.25	0.8 x 37°	MJ4 x 0.7-4h	1.64 1.61	1.63	2.90	2.30 1.90	16400	6200
-05	MJ315 hs5	5	10.11 9.89	7.65	4.990 4.978	4.990 4.965	4.90 4.84	0.13	1.20 1.14	0.75 0.50	0.38	0.8 x 37°	MJ5 x 0.8-4h	2.05 2.01	2.00	3.43	3.05 2.60	25700	9300
-06	HSTMJ315 hs6	6	12.64 12.41	8.65	5.990 5.978	5.990 5.965	5.88 5.81	0.16	1.55 1.49	0.75 0.50	0.38	0.8 x 37°	MJ6 x 1.0-4h	2.46 2.40	2.25	4.06	3.60 3.10	37000	14700
-08	HSTMJ315 hs8	8	16.48 16.26	9.65	7.987 7.972	7.987 7.962	7.88 7.80	0.18	1.99 1.93	1.00 0.75	0.38	1.2 x 37°	MJ8 x 1.0-4h	3.29 3.22	2.75	5.08	4.60 4.05	65800	24400
-10	HSTMJ315 hs10	10	20.21 19.98	11.82	9.987 9.972	9.987 9.962	9.88 9.80	0.21	2.39 2.33	1.00 0.75	0.38	1.2 x 37°	MJ10 x 1.25-4h	4.11 4.02	3.50	5.97	5.50 5.00	102900	37800
-12	HSTMJ315 hs12	12	23.54 23.31	13.33	11.984 11.966	11.984 11.959	11.87 11.76	0.23	2.70 2.64	1.25 1.00	0.56	1.2 x 37°	MJ12 x 1.25-4h	4.90 4.81	4.30	6.99	6.45 5.90	148100	52000

* 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.

MATERIAL: 6Al-4V titanium alloy.

HEAT TREAT: 655 N/mm² shear minimum.

FINISH: HSTMJ315TB- () = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
HSTMJ315YY- () = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 on threads only, with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification No. M380 except thread as noted.

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

HOW TO ORDER EXAMPLES:

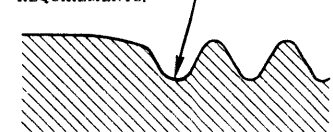
Pin Part Number Only
HSTMJ315TB-04-8

8mm Maximum Grip Length
4mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HSTMJ315TB70-04-8

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, 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 D. P. S. 11-25-91	TITLE HI-LITE® ST™ PIN (MJ METRIC SERIES) 130° FLUSH CROWN SHEAR HEAD TITANIUM 1mm GRIP VARIATION
APPROVED DATE A. BROWN 11-25-91	
REVISION DATE	DRAWING NUMBER HSTMJ315