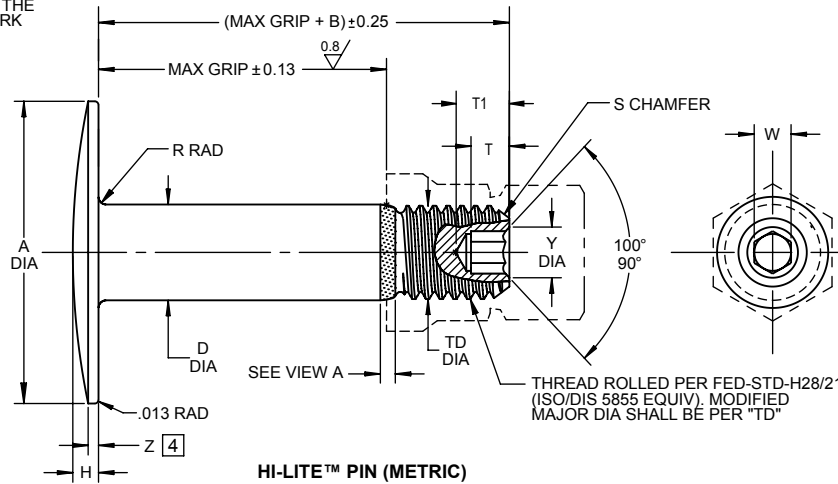
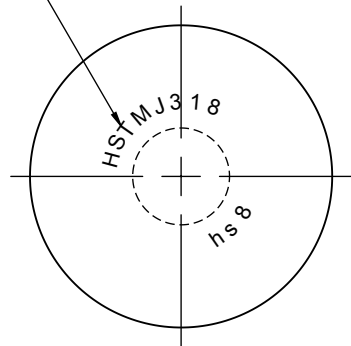


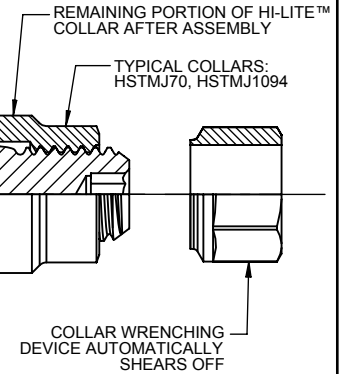
③

INDENTED HEAD MARKING 0.25 MAX DEPTH PER TABULATION.
"hs" INDICATES HI-SHEAR TRADEMARK. THE NUMBER(S) FOLLOWING THE TRADEMARK INDICATES FIRST DASH NUMBER. ARRANGEMENT OPTIONAL.



HI-LITE™ PIN (METRIC)

HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY



FIRST DASH NO.	HEAD MARKING	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	NEWTONS MINIMUM
					WITHOUT COATING OR SOLID FILM	WITH COATING OR SOLID FILM							W HEX	T HEX DEPTH MIN	T1 DEPTH MAX	Y DIA		
04	MJ318 hs 4	4	12.45 11.43	7.11	3.990 3.978	3.990 3.965	3.91 3.86	1.20 0.99	0.65 0.40	0.65	0.8 x 37°	MJ4 x 0.7-4h	1.64 1.61	1.63	2.90	2.30 1.90	16,400	7,450
05	MJ318 hs 5	5	15.49 14.23	7.65	4.990 4.978	4.990 4.965	4.90 4.84	1.37 1.17	0.65 0.40	0.65	0.8 x 37°	MJ5 x 0.8-4h	2.05 2.01	2.00	3.43	3.05 2.60	25,700	11,090
06	HSTMJ318 hs 6	6	18.41 16.51	8.65	5.990 5.978	5.990 5.965	5.88 5.81	1.78 1.53	0.65 0.40	0.75	0.8 x 37°	MJ6 x 1.0-4h	2.46 2.40	2.25	4.06	3.60 3.10	37,000	17,100
08	HSTMJ318 hs 8	8	24.64 23.11	9.65	7.987 7.972	7.987 7.962	7.88 7.80	2.16 1.91	0.75 0.50	0.75	1.2 x 37°	MJ8 x 1.0-4h	3.29 3.22	2.75	5.08	4.60 4.05	65,800	29,700

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within 0.25 FIM.
 - ③ 2. Dimensions are in millimeters and to be met after finish.
 3. Surface texture per ISO/R468.
 - ④ Curved or flat edge manufacturer's option.

- ③ ⑤ After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: 6AL-4V titanium alloy per AMS4928 or AMS4967 for all sizes.

HEAT TREAT: 655 MPa shear minimum.

FINISH: HSTMJ318-(-)(-) = 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.

- ③ ⑤ HSTMJ318AZ(-)(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HSTMJ318UT(-)(-) = Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.

HSTMJ318SY(-)(-) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color red on thread end.

- ③ HSTMJ318HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LITE™ Product Specification No. M380.

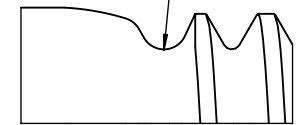
CODE: First dash number indicates nominal diameter in 1 mm. Second dash number indicates maximum grip in 1 mm. See "Finish" note for explanation of code letters.

HOW TO ORDER

③ EXAMPLE:

Pin Part Number
HSTMJ318AZ-04-8
8 mm Maximum Grip Length
4 mm Nominal Diameter Pin
Finish Code
Pin Base Part Number
Pin and Collar Assembly Part Number Combination
HSTMJ31870-04-8
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

"HI-LITE", "HST", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY DEPT. 104	DATE 1988-03-08	TITLE HI-LITE™ PIN (MJ METRIC SERIES) PROTRUDING SHEAR HEAD TITANIUM COMPOSITE APPLICATION 1 mm GRIP VARIATION
APPROVED E.E.B	DATE 1988-03-09	DRAWING NUMBER HSTMJ318
REVISION ③	DATE KEVIN TRAN 2017-06-29	1 OF 1