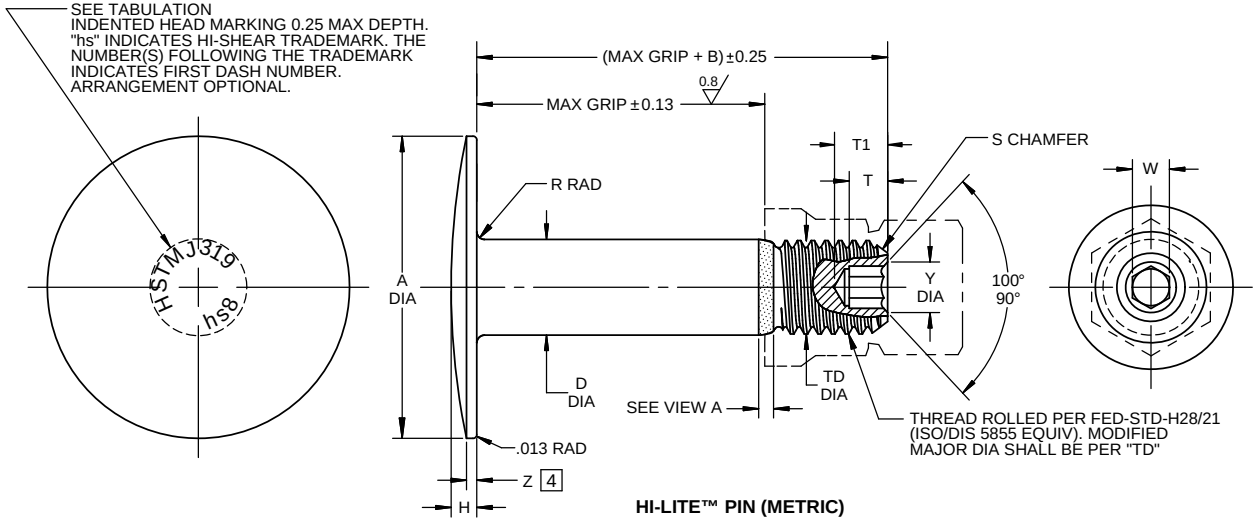
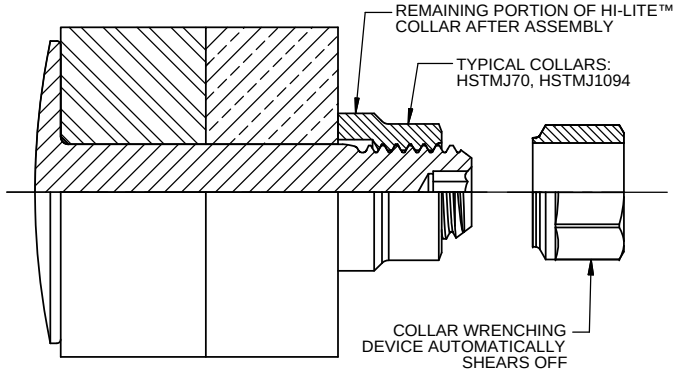
lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company
Design Holder
CAGE No. 73197

① For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



HI-LITE™ PIN (METRIC)



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

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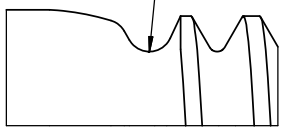
FIRST DASH NO.	HEAD MARKING	PIN NOM DIA	**A** DIA	**B** REF	**D** DIA WITHOUT COATING OR SOLID FILM	**D** DIA WITH COATING OR SOLID FILM	**TD** DIA	**H**	**R** RAD	**Z** MAX	**S** CHAMFER REF	THREAD	SOCKET **W** HEX	SOCKET **T** HEX DEPTH MIN	SOCKET **T1** DEPTH MAX	SOCKET **Y** DIA	DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
04	MJ319 hs 4	4	11.53 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	MJ319 hs 5	5	14.33 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	HSTMJ319 hs 6	6	16.63 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	HSTMJ319 hs 8	8	23.27 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

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 J.F.OBISPO DATE 2007-01-15	TITLE: HI-LITE™ PIN (MJ METRIC SERIES) PROTRUDING REDUCED SHEAR HEAD TITANIUM COMPOSITE APPLICATION 1mm GRIP VARIATION
APPROVED E.E.BEELES DATE 2007-01-16	
REVISION ① DATE M.BEARD 2017-06-28	DRAWING NUMBER **HSTMJ319** 1 OF 2

HSTMJ319

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GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within 0.25 FIM.
① 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.
① [5] After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 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: HSTMJ319-( )-( ) = 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.
① [5] HSTMJ319AZ( )-( ) = 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.
HSTMJ319UT( )-( ) = Ti-Shield III, HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.
HSTMJ319SY( )-( ) = Phosphate fluoride treat, solid film lube per AS5272, Type I, and color red on thread end.

SPECIFICATION: HI-LITE™ Product Specification 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
① **EXAMPLE:** Pin Part Number
HSTMJ319AZ04-8

- 8mm Maximum Grip Length
- 4mm Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number

~~Pin and Collar Assembly Part Number Combination~~
~~HSTMJ31970-04-8~~

- ~~Size and Grip Length, See Above Example~~
- ~~Collar Part Number~~
- ~~Pin Part Number~~

HSTMJ319

DRAWING NUMBER
HSTMJ319 2 OF 2

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