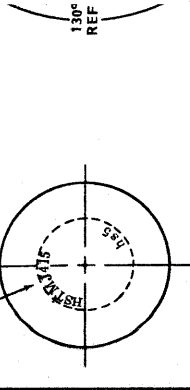


INDENTED HEAD MARKING MAXIMUM DEPTH 0.25. "hs" indicates HI-SHEAR trademark. The number(s) following the trademark indicate first dash number. Arrangement optional. See tabulation.

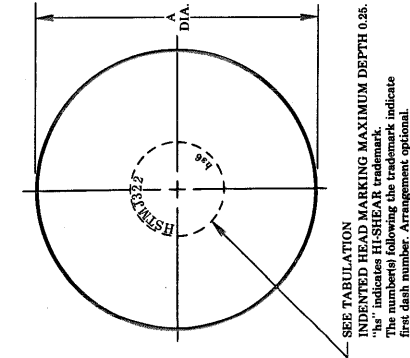


FIRST DASH NO.	HEAD MARKING	NOM. DIA.
04	MJ415 hs4	4
05	MJ415 hs5	5
06	HSTMJ415 hs6	6
08	HSTMJ415 hs8	8
10	HSTMJ415 hs10	10
12	HSTMJ415 hs12	12

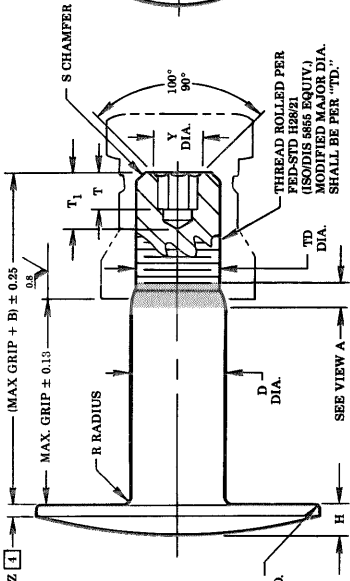
GENERAL NOTES:
[1] Head edge out of
2. Concentricity: Co
3. "H" is dimension
4. Surface texture p
5. Dimensions to be
[E] Curved or flat ed

MATERIAL: 6Al-4V titanium alloy
HEAT TREAT: 655 N/mm 2 shear m
FINISH: HSTMJ415TB-()-()
HSTMJ415VY-()-()

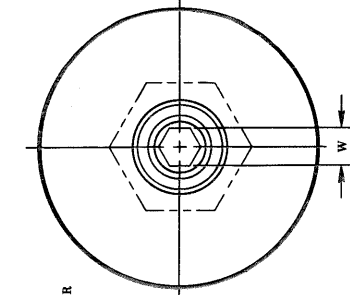
SPECIFICATION: Hi-Lite Product Spec



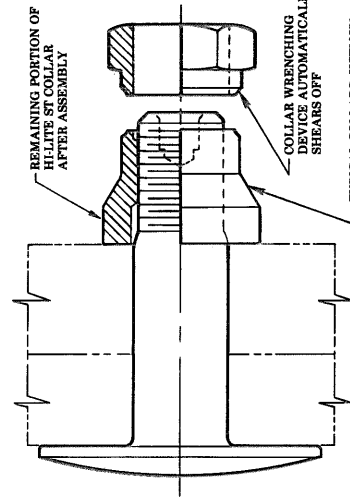
SEE TABULATION
INDENTED HEAD MARKING MAXIMUM DEPTH 0.25.
The numbers following the trademark indicate first dash number. Arrangement optional.



HI-LITE® ST™ PIN (METRIC)



HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY



HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

[4]

FIRST DASH NO.	HEAD MARKING	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	TENSION NEWTONS MINIMUM
					WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE							T HEX DEPTH MIN.	T1 TH MAX.	Y DIA.		
-04	MJ322 hs4	4	12.45	7.11	3.990	3.990	3.91	1.30	0.65	0.65	0.8 x 45°	MJ4 x 0.7-4h	1.64	2.30	2.30	18,600	8,290
-05	MJ322 hs5	5	15.49	7.65	4.990	4.990	4.90	1.37	0.65	0.65	0.8 x 45°	MJ5 x 0.8-4h	2.05	2.90	2.90	29,100	12,550
-06	HSTMJ322 hs6	6	18.41	8.65	5.990	5.990	5.88	1.78	0.65	0.75	0.8 x 45°	MJ6 x 1.0-4h	2.46	4.06	3.60	41,800	19,350
-08	HSTMJ322 hs8	8	24.64	9.65	7.987	7.987	7.88	2.16	0.75	0.75	1.2 x 45°	MJ8 x 1.0-4h	3.29	5.06	4.60	74,400	33,560
			23.11		7.972	7.962	7.80	1.91	0.50				3.22		4.05		

GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within 0.25 FIR.
2. Dimensions to be met after finish.
3. Surface texture per ISO/DR221.

[4] Curved or flat edge manufacturer's option.

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 740 N/mm² shear minimum at room temperature.

FINISH: HSTMJ322-()-() = Passivate per Hi-Shear Spec. 258 and
cetyl alcohol lube per Hi-Shear Spec. 305.
HSTMJ322TB-()-() = Hi-Kote 2 solid film lube per Hi-Shear
Spec. 292 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.

HOW TO ORDER
EXAMPLES:
Pin Part Number Only
HSTMJ322-04-8
8mm Maximum Grip Length
4mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HSTMJ322 70-04-8
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 4,396,825; 4,485,610 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	TITLE
D.P.S. 10-11-91	HI-LITE® ST™ PIN (MJ METRIC SERIES)
DATE	PROTRUDING SHEAR HEAD
APPROVED	NICKEL BASE ALLOY (INCONEL 718)
REVISION	1MM GRIP VARIATION
DATE	DRAWING NUMBER
	HSTMJ322