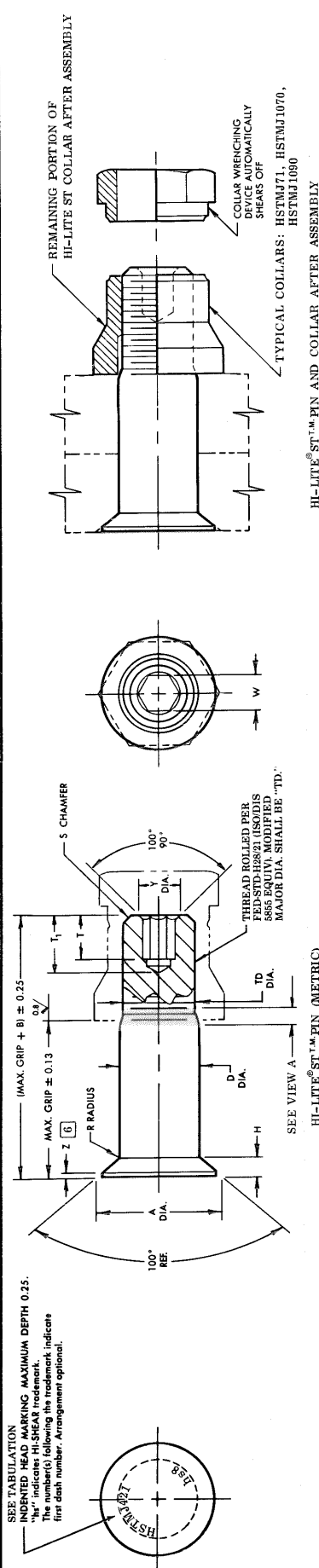


① **hi-shear CORPORATION** U.S.A. (Patent Holder) CAGE No. 71977 (KAWA) WERE QUINCY
 Division of Hi-Shear Industries, Inc., U.S.A. CAGE No. 0725 (SIMMONS) S.A. France CAGE No. 0725 (SIMMONS) S.A. France
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FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	1		R H	Z MAX.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					HSTMJ421	HSTMJ421AZ		F	H					* T HEX W HEX.	DEPTH MIN.	T ₁ DEPTH MAX.	Y DIA.		
-04	MJ421 hs4	4	6.25 6.13	7.11	3.990 3.978	3.990 3.965	3.91 3.86	0.11	0.95 0.89	0.65 0.40	0.25	0.8 x 37°	MJ4 x 0.7-4h	1.64 1.61	1.63	2.90	2.90 1.90	21600	7380
-05	MJ421 hs5	5	7.80 7.68	7.65	4.990 4.978	4.990 4.965	4.90 4.84	0.13	1.18 1.12	0.75 0.50	0.38	0.8 x 37°	MJ5 x 0.8-4h	2.05	2.00	3.43	3.05 2.60	33800	11960
-06	HSTMJ421 hs6	6	9.40 9.28	8.65	5.990 5.978	5.990 5.88	5.88 5.81	0.16	1.43 1.37	0.75 0.50	0.38	0.8 x 37°	MJ6 x 1.0-4h	2.46	2.25	4.06	3.60 2.40	48600	17760
-08	HSTMJ421 hs8	8	12.50 12.38	9.65	7.987 7.972	7.987 7.88	7.88 7.80	0.18	1.90 1.84	1.00 0.75	0.38	1.2 x 37°	MJ8 x 1.0-4h	3.29	2.75	5.08	4.60 3.22	86600	30400
-10	HSTMJ421 hs10	10	15.60 15.48	11.82	9.987 9.972	9.987 9.88	9.88 9.80	0.21	2.36 2.30	1.00 0.75	0.38	1.2 x 37°	MJ10 x 1.25-4h	4.11	3.50	5.97	5.50 5.00	135100	48600

GENERAL NOTES: ① Head edge out of roundness shall not exceed "R".
 2. Concentricity: Conical surface of head to "D" diameter within 0.08 FIR.
 3. "H" is dimensioned from maximum "D" diameter.
 4. Surface texture per ISO/R468.
 5. Dimensions to be met after finish.
 6. Curved or flat edge manufacturer's option.

MATERIAL: Nickel base alloy per AMS5662.

HEAT TREAT: 860 N/mm² shear minimum.

① **FINISH:** HSTMJ421-(-)(-) = Passivate per Hi-Shear Spec. 268, and cetyl alcohol lube per Hi-Shear Spec. 305.

HSTMJ421AZ-(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color code black on thread end, plus cetyl alcohol lube per Hi-Shear Spec. 305.

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

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS.



VIEW A

HI-LITE THREAD TRANSITION AREA. SEE SPECIFICATION FOR INSPECTION.

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

Pin Part Number Only
 HSTMJ421-04-8

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

Pin and Collar Assembly Part Number Combination
 HSTMJ421-04-8

Size and Grip Length, see above example
 Collar Part Number
 Pin Part Number

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.	
HI-LITE ST™ PIN (MJ METRIC SERIES)	
DRAWN DATE	DATE
D.P.S. 10-13-89	D.P.S. 10-16-89
APPROVED DATE	DATE
10-16-89	10-16-89
REVISION	REVISION
1	1
D.P.S. 7-1-92	D.P.S. 7-1-92

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2-1599136

HSTMJ421