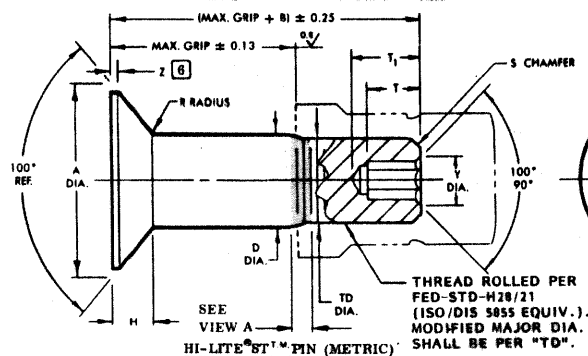
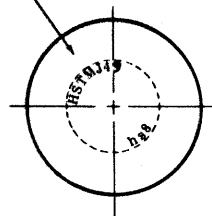
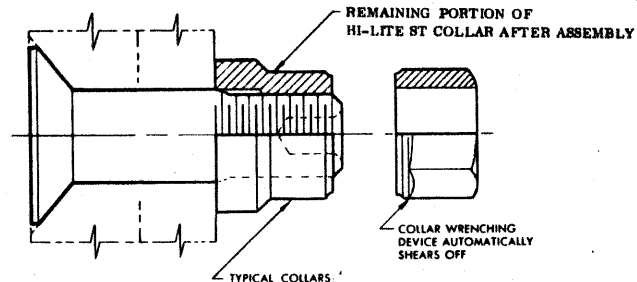
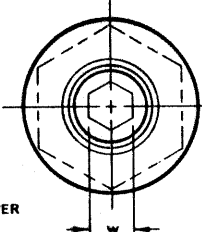


SEE TABULATION
INDENTED HEAD MARKING MAXIMUM DEPTH 0.25.
"hs" indicates HI-SHEAR trademark.
The number(s) following the trademark indicate
First dash number. Arrangement optional.



HI-LITE®ST™ PIN (METRIC)



HI-LITE®ST™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	F.	H	R RAD.	Z REF.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE								* W HEX.	T HEX DEPTH MIN.	T1 DEPTH MAX.	Y DIA.		
-04	MJ49 hs4	4	8.13 7.99	7.11	3.990 3.978	3.990 3.965	3.91 3.86	0.11	1.74 1.68	0.65 0.40	0.25	0.8 x 45°	MJ4 x 0.7-4h	1.64 1.61	1.63	2.90	2.30 1.90	16400	9800
-05	MJ49 hs5	5	10.13 9.99	7.65	4.990 4.978	4.990 4.965	4.90 4.84	0.13	2.16 2.10	0.75 0.50	0.38	0.8 x 45°	MJ5 x 0.8-4h	2.05 2.01	2.00	3.43	3.05 2.60	25700	15600
-06	HSTMJ49 hs6	6	12.13 11.99	8.65	5.990 5.978	5.990 5.965	5.88 5.81	0.16	2.58 2.52	0.75 0.50	0.38	0.8 x 45°	MJ6 x 1.0-4h	2.46 2.40	2.25	4.06	3.60 3.10	37000	22200
-08	HSTMJ49 hs8	8	16.13 15.99	9.65	7.987 7.972	7.987 7.962	7.88 7.80	0.18	3.42 3.36	1.00 0.75	0.38	1.2 x 45°	MJ8 x 1.0-4h	3.29 3.22	2.75	5.08	4.60 4.05	65800	42000
-10	HSTMJ49 hs10	10	20.13 19.99	11.82	9.987 9.972	9.987 9.962	9.88 9.80	0.21	4.26 4.20	1.00 0.75	0.38	1.2 x 45°	MJ10 x 1.25-4h	4.11 4.02	3.50	5.97	5.50 5.00	102900	68000
-12	HSTMJ49 hs12	12	24.13 23.99	13.33	11.984 11.969	11.984 11.969	11.87 11.76	0.23	5.10 5.04	1.00 0.75	0.38	1.2 x 45°	MJ12 x 1.25-4h	4.90 4.80	4.30	6.99	6.45 5.90	148100	100200

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

* INCH STANDARD HEX

GENERAL NOTES:

- Head out of roundness shall not exceed "F".
- Concentricity: Conical surface of head to "D" diameter within 0.13 FIR.
- "H" is dimensioned from maximum "D" diameter.
- Dimensions to be met after finish.
- Surface texture per ISO/DR221.
- Curved or flat edge manufacturer's option.

CODE:

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

**HOW TO ORDER
EXAMPLES:**

Pin Part Number Only
HSTMJ49-04-8

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

Pin and Collar Assembly Part Number Combination
HSTMJ4973-04-8

Size and grip length, see above example
Collar Part Number
Pin Part Number

MATERIAL: A-286 high temperature alloy per Spec. AMS573 or AMS5731.

HEAT TREAT: 655N/mm² shear minimum at room temperature.

FINISH: HSTMJ49-(-)(-) = Passivate per Hi-Shear Spec. 258 with color black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
HSTMJ49TF-(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.

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

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 J. Obispo 7-26-94	TITLE HI-LITE®ST™ PIN (MJ METRIC SERIES) 100° FLUSH TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1 mm GRIP VARIATION
APPROVED DATE E.E.B 7-21-94	
REVISION DATE ① 7-26-94	DRAWING NUMBER HSTMJ49