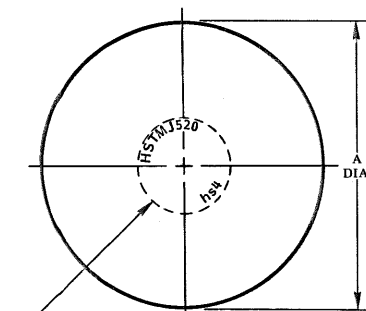
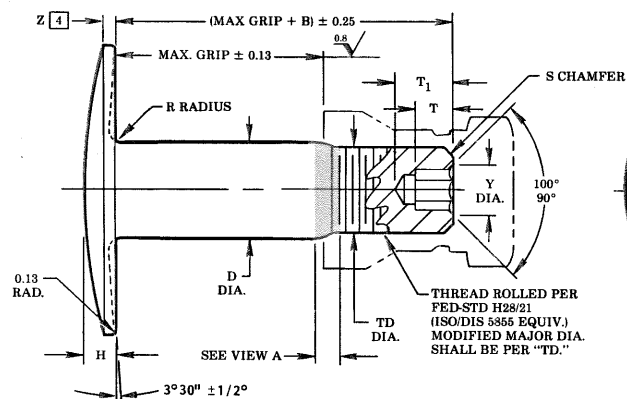


hi-shear
CORPORATION

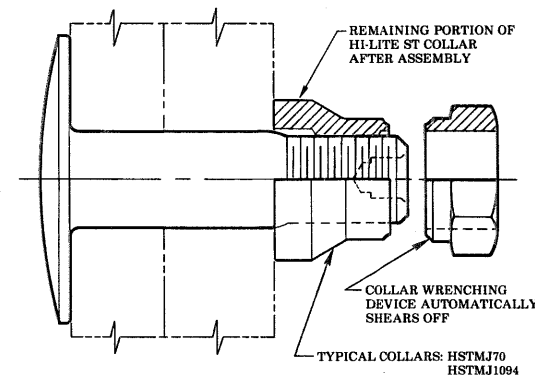
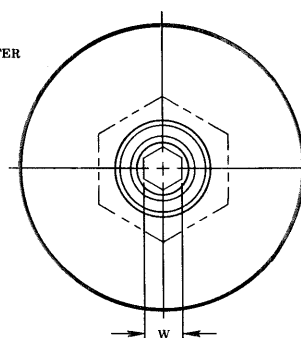
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



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.	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					WITHOUT COATING OR SOLID FILM LUBE	WITH COATING OR SOLID FILM LUBE							* W HEX.	T HEX DEPTH MIN.	T1 DEPTH MAX.	Y DIA.		
-04	MJ520 hs4	4	12.50 11.50	7.11	3.990 3.978	3.990 3.965	3.91 3.86	2.00 1.80	0.65 0.40	0.65	0.8 x 45°	MJ4 x 0.7-4h	1.64 1.61	1.63	2.90	2.30 1.90	16,400	9,800

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

* INCH STANDARD HEX

- 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: A-286 high temperature alloy per Spec. AMS5737 or AMS5731.

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

FINISH: HSTMJ520-()-() = Passivate per Hi-Shear Spec. 258 with color black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

HSTMJ520TB-()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.

HSTMJ520TF-()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.

SPECIFICATION: Hi-Lite Product Specification M380.

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

HOW TO ORDER
EXAMPLES:

Pin Part Number Only

HSTMJ520-04-8

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

Pin and Collar Assembly Part Number Combination

HSTMJ520 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 4,326, 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	TITLE
D.P.S.	12-3-90	HI-LITE ST™ PIN (MJ METRIC SERIES)
APPROVED	DATE	PROTRUDING SHEAR HEAD
		A-286 HIGH TEMPERATURE ALLOY
		COMPOSITE APPLICATION
		1 mm GRIP VARIATION
REVISION	DATE	DRAWING NUMBER
		HSTMJ520