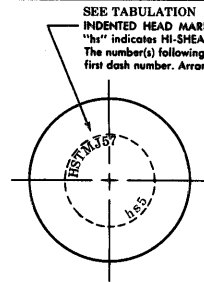


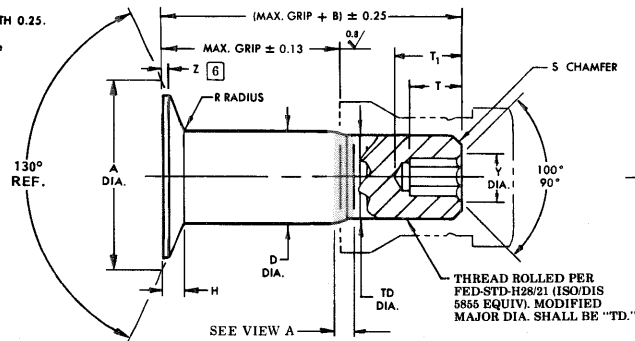
hi-shear
CORPORATION

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

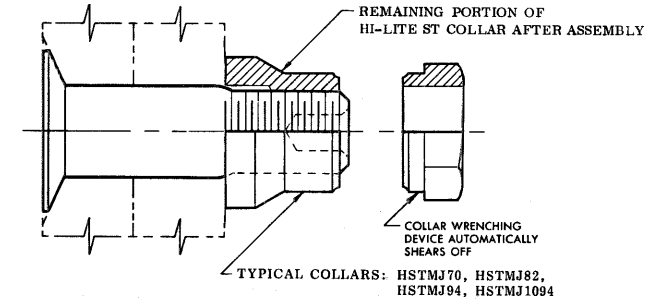
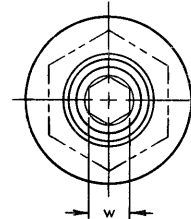
CAGE = Commercial And Government Entity		
1	HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73187	KANAX-WENKE Germany (Licensee-EEC Countries)
	AIR INDUSTRIES CO., INC. (Licensee) CAGE No. 03725	SI-MONODS S.A. France (Licensee-EEC Countries-Collars)
	SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 35174	SI-CHAMOND GRANAT S.A. France (Licensee-EEC Countries)
	HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee) CAGE No. 01390	TOKYO SCREW COMPANY, Japan (Licensee-Japan)



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 MAX.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					HSTMJ57YY	HSTMJ57AZ								* W HEX.	T HEX DEPTH MIN.	T1 DEPTH MAX.	Y DIA.		
-04	MJ57 hs4	4	8.46 8.23	7.11	3.990 3.978	3.990 3.965	3.91 3.86	0.11	1.05 0.99	0.65 0.40	0.25	0.8 x 45°	MJ4 x 0.7-4h	1.64 1.61	1.63	2.90	1.90	16400	6200
-05	MJ57 hs5	5	10.11 9.89	7.65	4.990 4.978	4.990 4.965	4.90 4.84	0.13	1.20 1.14	0.75 0.50	0.38	0.8 x 45°	MJ5 x 0.8-4h	2.05 2.01	2.00	3.43	2.60	25700	9300
-06	HSTMJ57 hs6	6	12.64 12.41	8.65	5.990 5.978	5.990 5.965	5.88 5.81	0.16	1.55 1.49	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	14700
-08	HSTMJ57 hs8	8	16.48 16.26	9.65	7.987 7.972	7.987 7.962	7.88 7.80	0.18	1.99 1.93	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	24400

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

* INCH STANDARD HEX.

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

MATERIAL: Waspaloy high temperature alloy per AMS5708.

HEAT TREAT: 655 N/mm² shear minimum.

- ① FINISH:** HSTMJ57AZ-() = 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.
HSTMJ57YY-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 on threads only, with color green on thread end, 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. See finish note for explanation of code letters.

**HOW TO ORDER
EXAMPLES:**

Pin Part Number Only
HSTMJ57AZ-04-8

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

Pin and Collar Assembly Part Number Combination
HSTMJ57AZ70-04-8

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 D. P. S. 10-26-88	TITLE HI-LITE®ST™PIN (MJ METRIC SERIES)
APPROVED DATE D. P. S. 10-26-88	130° FLUSH SHEAR HEAD WASPALOY HIGH TEMPERATURE ALLOY 1 mm GRIP VARIATION
REVISION DATE ② D. P. S. 8-27-91	DRAWING NUMBER HSTMJ57

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HSTMJ57