

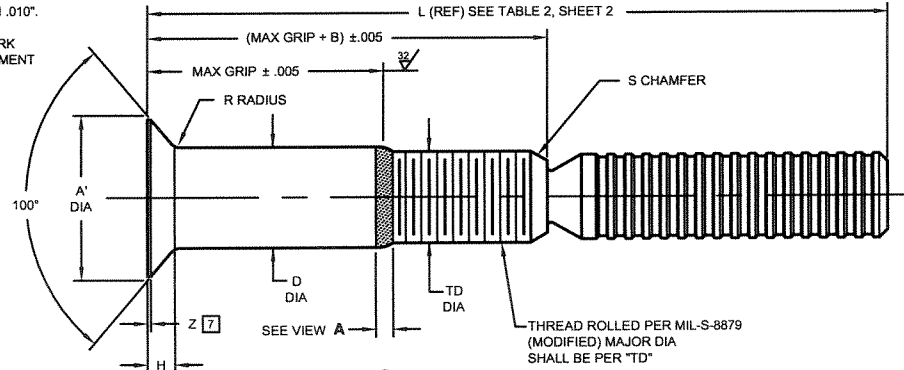
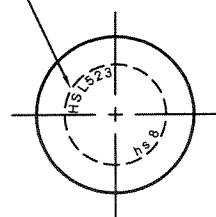
hi-shear
CORPORATION

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HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
a LISI AEROSPACE Company
AIR INDUSTRIES CO., INC., U.S.A. (Licensee - U.S.A. & Canada) CAGE No. 06725
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878
FAIRCHILD - SIMMONDS S.A. France (Licensee) CAGE No. 92215

BLANC AERO INDUSTRIES UK LIMITED (Licensee) CAGE No. 0LB68
a LISI AEROSPACE Company
BLANC AERO S.A. France (Licensee - ECC Countries)
a LISI AEROSPACE Company
TOKYO SCREW COMPANY, Japan (Licensee - Japan)

INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER. ARRANGEMENT
OPTIONAL.



HI-LITE® ST™ PIN

TABLE 1

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	F	TD DIA	H	R RAD	Z MAX	S CHAMFER REF	THREAD	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	5/32	.2292 .2874	.280	.1635 .1625	.004	.1595 .1570	.0538 .0518	.025 .015	.010	1/32" x 37°	8-32UNJC-3A Modified	4,010	1,730
6	3/16	.3536 .3486	.290	.1895 .1885	.005	.1840 .1810	.0688 .0667	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	5,380	2,590
8	1/4	.4732 .4682	.320	.2495 .2485	.006	.2440 .2410	.0939 .0918	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	9,300	4,760
10	5/16	.5619 .5569	.380	.3120 .3110	.007	.3060 .3020	.1048 .1027	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	14,600	7,100
12	3/8	.6912 .6862	.420	.3745 .3735	.008	.3680 .3640	.1329 .1308	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	21,000	10,600
14	7/16	.8041 .7969	.485	.4370 .4360	.009	.4310 .4260	.1540 .1510	.050 .040	.022	3/64" x 37°	7/16-20UNJF-3A Modified	28,600	14,450
16	1/2	.9166 .9095	.525	.4995 .4985	.010	.4930 .4880	.1750 .1720	.050 .040	.022	3/64" x 37°	1/2-20UNJF-3A Modified	37,300	19,550

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - This HI-Lite ST pin is to be used in combination with a HI-Lite ST collar.
 - This HI-Lite ST pin is to be used in interference fit holes only.

MATERIAL: 6AL-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

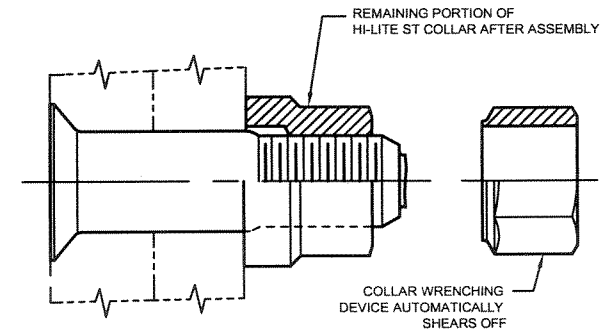
FINISH: HSL523AG (-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305, with color code orange on the thread end.

SPECIFICATION: Hi-Lite Product Specification 380-2.

CODE: First dash number indicates nominal diameter in 1/32nds.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

**HOW TO ORDER
EXAMPLE:**

Pin Part Number Only
HSL523AG8-8
└── 8/16 or 1/2 Maximum Grip Length
└── 8/32 or 1/4 Nominal Diameter Pin
└── Finish
└── Pin Part Number



HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

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

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 international patents pending.
"Hi-Lite" and "HST" are registered trademarks and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.

DRAWN J.F.Obispo	DATE 11-25-02	TITLE HI-LITE® ST™ PIN 100° FLUSH MS20426 SHEAR HEAD BREAK STEM, INTERFERENCE FIT TITANIUM 1/16" GRIP VARIATION
APPROVED <i>[Signature]</i>	DATE 11/25/02	DRAWING NUMBER HSL523
REVISION 1	DATE	Sheet 1 of 2

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TABLE 2

SECOND DASH NUMBER	L (REF)						
	-5 DIA.	-6 DIA.	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.
1	-	-	-	-	-	-	-
2	.935	.945	.927	-	-	-	-
3	1.060	1.070	1.052	1.160	-	-	-
4	1.185	1.195	1.177	1.285	1.265	-	-
5	1.310	1.320	1.302	1.410	1.390	1.500	-
6	1.435	1.445	1.427	1.535	1.515	1.625	1.610
7	1.560	1.570	1.552	1.660	1.640	1.750	1.735
8	1.685	1.695	1.677	1.785	1.765	1.875	1.860
9	1.810	1.820	1.802	1.910	1.890	2.000	1.985
10	1.935	1.945	1.927	2.035	2.015	2.125	2.110
11	2.060	2.070	2.052	2.160	2.140	2.250	2.235
12	2.185	2.195	2.177	2.285	2.265	2.375	2.360
13	2.310	2.320	2.302	2.410	2.390	2.500	2.485
14	2.435	2.445	2.427	2.535	2.515	2.625	2.610
15	2.560	2.570	2.552	2.660	2.640	2.750	2.735
16	2.685	2.695	2.677	2.785	2.765	2.875	2.860
17	2.810	2.820	2.802	2.910	2.890	3.000	2.985
18	2.935	2.945	2.927	3.035	3.015	3.125	3.110
19	3.060	3.070	3.052	3.160	3.140	3.250	3.235
20	3.185	3.195	3.177	3.285	3.265	3.375	3.360
21	-	3.320	3.302	3.410	3.390	3.500	3.485
22	-	3.445	3.427	3.535	3.515	3.625	3.610
23	-	3.570	3.552	3.660	3.640	3.750	3.735
24	-	3.695	3.677	3.785	3.765	3.875	3.860
25	-	-	-	3.910	3.890	4.000	3.985
26	-	-	-	4.035	4.015	4.125	4.110
27	-	-	-	4.160	4.140	4.250	4.235
28	-	-	-	4.285	4.265	4.375	4.360
29	-	-	-	-	-	4.500	4.485
30	-	-	-	-	-	4.625	4.610
31	-	-	-	-	-	4.750	4.735
32	-	-	-	-	-	4.875	4.860

DRAWING NUMBER

HSL523

Sheet 2 of 2