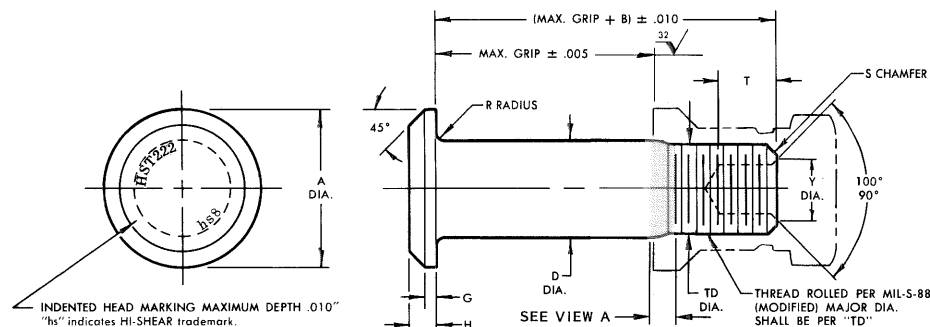
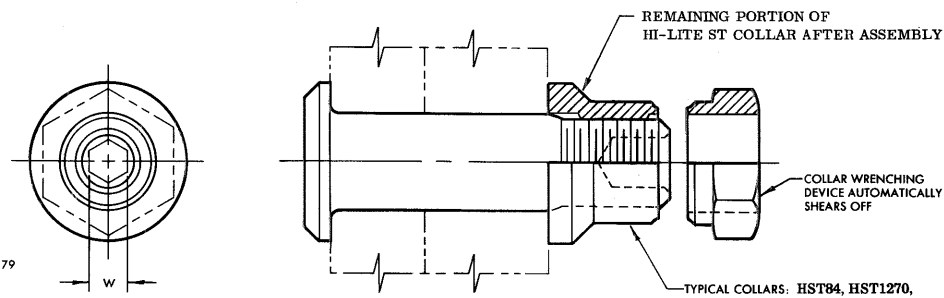


hi-shear
CORPORATION

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



HI-LITE® ST™ PIN



HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	G REF.	H	R RAD.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											W HEX.	T DEPTH	Y DIA.		
- 5										NOTE: USE HST22-6					
- 6	7/32	.315 .295	.290	.2182 .2172	.1840 .1810	.035	.074 .055	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	3,400	1,240
- 8	9/32	.412 .387	.320	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	5,600	2,170
- 10	11/32	.505 .475	.380	.3432 .3422	.3060 .3020	.055	.110 .100	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	3,300	3,020
- 12	13/32	.600 .565	.420	.4057 .4047	.3680 .3640	.065	.135 .125	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	11,700	4,370
- 14	15/32	.676 .641	.485	.4682 .4672	.4310 .4260	.075	.155 .145	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	15,500	6,000
- 16	17/32	.770 .735	.525	.5307 .5297	.4930 .4880	.085	.180 .170	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	19,900	7,600
						</									

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.

- GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIR.
 2. Dimensions to be met after finish.
 3. Surface texture per ANSI B46.1.
 4. Hole preparation per NAS618.

MATERIAL: 7075 aluminum alloy per QQ-A-225/9 or QQ-A-430.

HEAT TREAT: Age to T6 condition per MIL-H-6088.

FINISH:

- HST222-() () = Anodize per MIL-A-8625, dye color natural, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST222DU-() () = Anodize per MIL-A-8625, and solid film lube per MIL-L-46010, Type I.
- HST222EY-() () = Anodize per MIL-A-8625, dye color yellow, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST222TT-() () = Anodize per MIL-A-8625, dye color natural, and transluube.

SPECIFICATION: Hi-Lite Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds which HST222 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

HOW TO ORDER

EXAMPLES:

Pin Part Number Only

HST222DU8-8

8/16 or 1/2 Maximum Grip Length

Replaces 8/32 or 1/4 Nominal Diameter Pin

Solid Film Lubricant

Pin Part Number

Pin and Collar Assembly Part Number Combination

HST222DU84-8-8

8-Size and Grip Length, See Above Example

Collar Part Number

Pin Finish

Pin Part Number

U.S. Patents 4,326,825 and 4,485,510. 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 Dept. 104	DATE 8-3-90
APPROVED [Signature]	DATE 8-3-90
REVISION	DATE
HI-LITE ST™ PIN PROTRUDING SHEAR HEAD ALUMINUM ALLOY 1/16" GRIP VARIATION, 1/32" OVERSIZE	
DRAWING NUMBER HST222	