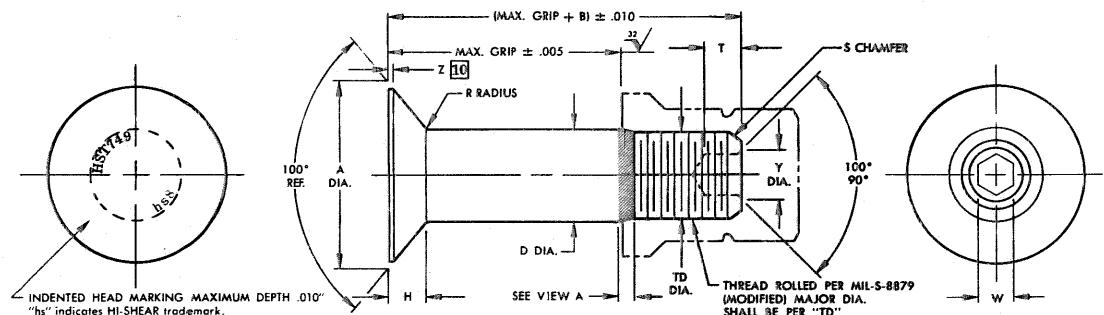
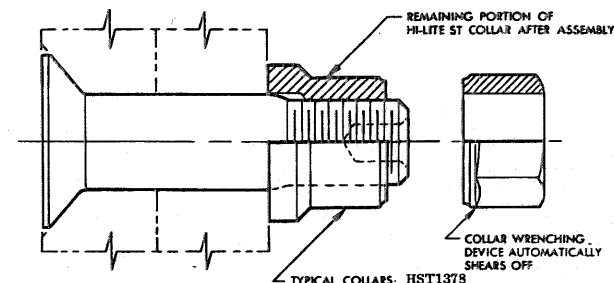


hi-shear
CORPORATION

2500 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 773-3181 • 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.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE								W HEX.	T DEPTH	Y DIA.		
- 5				NOTE: USE HST49-6													
- 6	3/16	.3813 .3765	.290	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0680 .0660	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,100	3,180
- 8	1/4	.5066 .5018	.320	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0950 .0930	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	11,800	5,820
- 10	5/16	.6335 .6287	.380	.3432 .3427	.3432 .3422	.3060 .3020	.007	.1220 .1200	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	17,600	9,200
- 12	3/8	.7604 .7556	.420	.4057 .4052	.4057 .4047	.3680 .3640	.008	.1490 .1470	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	24,600	14,000
- 14	7/16	.8884 .8812	.485	.4682 .4677	.4682 .4672	.4310 .4280	.009	.1760 .1730	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	32,700	18,900
- 16	1/2	1.0139 1.0068	.525	.5307 .5302	.5307 .5297	.4930 .4880	.010	.2030 .2000	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	42,000	25,600

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:
- Head edge out of roundness shall not exceed "F."
 - Concentricity: Conical surface of head to "D" diameter within .005 FIR.
 - "H" dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Non-lubed pins must be used with lubed collars.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Maximum "D" diameter may be increased by .0002 to allow for solid film or plating application.
 - Evidence of broken edge across points.
 - Curved or flat edge manufacturer's option.

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

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum) at 70°F.

FINISH: HST749-(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HST749DU-(-)(-) = Solid film lube per MIL-L-8937.
[5] HST749GU-(-)(-) = Silver plate per AMS2410.
[5] HST749PY-(-)(-) = Passivate per Hi-Shear Spec. 258.
HST749TF-(-)(-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.

SPECIFICATION: Hi-Lite Product Specification 350.

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 EXAMPLES:

Pin Part Number Only
HST749-5-5
— 5/16 or 1/2 Maximum Grip Length
— 5/32 or 1/4 Nominal Diameter Pin
— Pin Part Number

Pin and Collar Assembly Part Number Combination
HST7491378-8-8

— Size and Grip Length, See Above Example
— Collar Part Number
— Pin Part Number

U.S. Patents 4,326,925 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 D.P.S.	DATE 11-7-55	HI-LITE ST™ PIN 100° FLUSH MS24694 TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1/16" GRIP VARIATION - 1/32" OVERSIZE
APPROVED E.E.B.	DATE 11-7-55	
REVISION	DATE	DRAWING NUMBER HST749