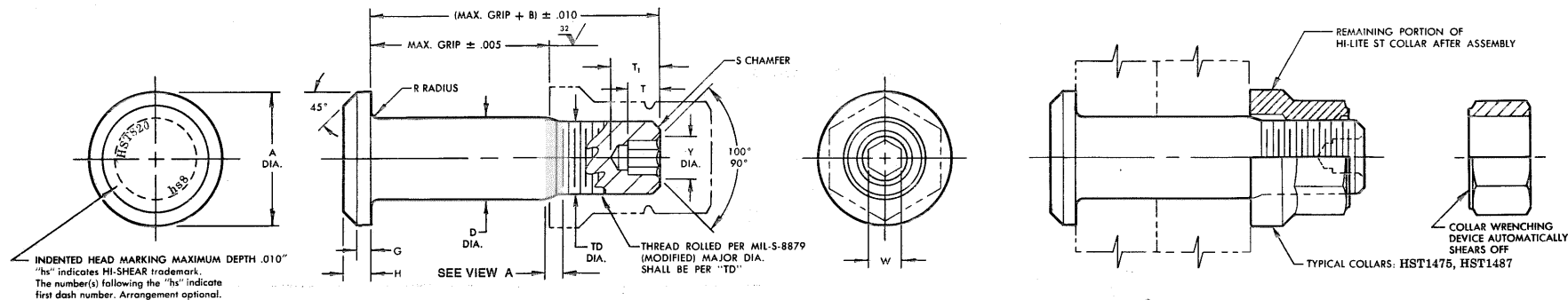


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CAGE = Commercial And Government Entity

HI-SHEAR CORPORATION, U.S.A. (Patent Holder)	CAGE No. 73197	KAMAY-WERKE Germany (Licensee-EEC Countries)
Division of HI-Shear Industries, Inc., U.S.A.		Rudolph Kollmann GmbH & Co.
AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada)	CAGE No. 06725	SIMMONDS S.A. France (Licensee-EEC Countries)
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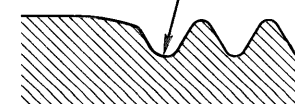
HI-LITE[®] ST[™] PIN

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 MIN.	T _i DEPTH	Y DIA.		
-5	3/16			NOTE: Use HST720-6												
-6	7/32	.390 .370	.300	.2182 .2172	.1840 .1810	.035	.074 .064	.025 .015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.080	.135	.119 .104	8,070	3,850
-8	9/32	.460 .435	.330	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.090	.160	.142 .122	13,400	6,550
-10	11/32	.520 .490	.390	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.110	.200	.180 .160	20,000	10,350
-12	13/32	.620 .585	.430	.4057 .4047	.3680 .3640	.075	.140 .130	.030 .020	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.140	.235	.217 .197	28,000	15,750
-14	15/32	.695 .660	.495	.4682 .4672	.4310 .4260	.095	.160 .150	.030 .020	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.170	.275	.253 .233	37,200	21,200
-16	17/32	.790 .755	.535	.5307 .5297	.4930 .4880	.095	.188 .178	.030 .020	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.200	.315	.289 .269	47,700	28,800
-18	19/32	.900 .865	.610	.5927 .5917	.5550 .5500	.125	.210 .200	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.240	.365	.326 .306	59,600	36,400
-20	21/32	.970 .935	.650	.6552 .6542	.6180 .6120	.140	.238 .228	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.240	.365	.326 .306	72,900	46,100
-24	25/32	1.185 1.145	.905	.7802 .7792	.7430 .7370	.200	.335 .320	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.3185 .3150	.300	.440	.398 .378	103,000	66,900

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.
5. Oversize replacement for HST720 and HST764.

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626 or MIL-S-6049.

HEAT TREAT: 180,000 - 200,000 psi tensile per Spec. MIL-H-6875.

FINISH:

HST820-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, with color black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

HST820BJ-()-() = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST820BL-()-() = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, with color black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

HST820CG-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, with color green on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which this HST820 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
HST820-8-8

8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Pin Part Number with Type II Cadmium Plate

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. 11/3/92	TITLE HI-LITE[®] ST[™] PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16" GRIP VARIATION - 1/32" OVERSIZE
APPROVED DATE ABROWN 11-3-92	DRAWING NUMBER HST820
REVISION DATE	