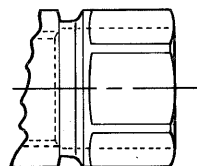
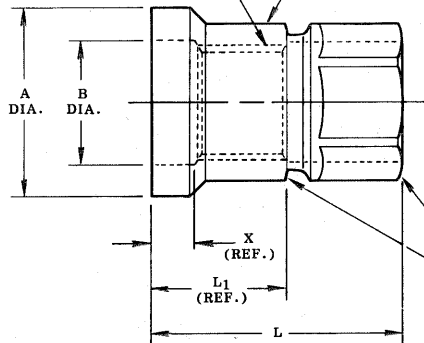




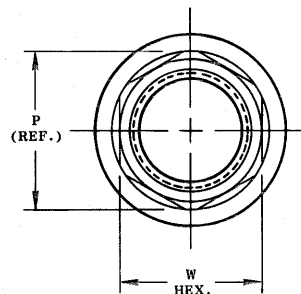
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110

THREAD PER
BRITISH STD 3643 (ISO METRIC)

THIS AREA PROVIDED WITH A PREVAILING
TORQUE LOCKING FEATURE



OPTIONAL CONFIGURATION



DASH NO. (METRIC)	PIN NOM. DIA.	THREAD	A DIA.	B DIA.		L	L1 (REF.)		P (REF.)		W HEX.		X (REF.)	TORQUE-OFF NEWTON-METER	ULT TNSN STR NEWTONS MINIMUM
-04	4	M4 x 0.7-4H5H	7.49 7.24	4.78 4.62		11.05 10.54	5.58		5.54		5.00 4.78		1.7	1.7 - 2.9	5800
-05	5	M5 x 0.8-4H5H	8.24 7.99	5.78 5.62		11.30 10.80	5.84		6.65		6.00 5.78		1.7	2.8 - 4.6	7300
-06	6	M6 x 1.0-4H5H	10.77 10.52	6.78 6.62		13.34 12.83	6.60		7.82		7.00 6.78		2.3	5.6 - 9.1	12000
-08	8	M8 x 1.0-4H5H	13.45 13.20	8.82 8.62		16.13 15.62	8.12		10.72		9.50 9.28		2.4	14.6 - 18.1	22200
-10	10	M10 x 1.0-4H5H	16.63 16.33	10.89 10.63		17.90 17.40	9.52		13.54		12.00 11.73		2.4	23.7 - 28.3	33300
-12	12	M12 x 1.25-4H5H	21.85 21.55	12.88 12.63		19.94 19.43	10.92		18.16		16.00 15.73		2.5	36.1 - 43.0	48900

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
2. Dimensions apply after finish.
3. Burrs from cutoff process and cutting torque-off groove allowed.
4. Use HSTM1270 for oversize replacement.

MATERIAL: 7050 aluminum alloy per QQ-A-430 or
7075 aluminum alloy per QQ-A-225/9.

HEAT TREAT: Age to T73 condition per MIL-H-6088.

FINISH: HSTM1070CK-() = Anodize per MIL-A-8625, dye color black, and
cetyl alcohol lube per Hi-Shear Spec. 305.
HSTM1070CY-() = Anodize per MIL-A-8625, dye color orange, and
cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification M381.

CODE: Dash number indicates nominal thread size in 1 mm.
See "Finish" note for explanation of code letters.

EXAMPLE: HSTM1070-08 = M8 x 1.0 Hi-Lite ST collar.

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.

			TITLE										DRAWING NUMBER		
	DATE	BY	HI-LITE[®] ST[™] COLLAR (METRIC SERIES) ALUMINUM ALLOY 1 mm GRIP VARIATION – SHEAR APPLICATION FOR USE ON STANDARD AND 0.5 mm OVERSIZE HI-LITE ST PINS										HSTM1070		
DRAWN	4-24-87	D.P.S.													
APPROVED	4-27-87	<i>N. Pote</i>													
① REVISION	12-12-89	D.P.S.													