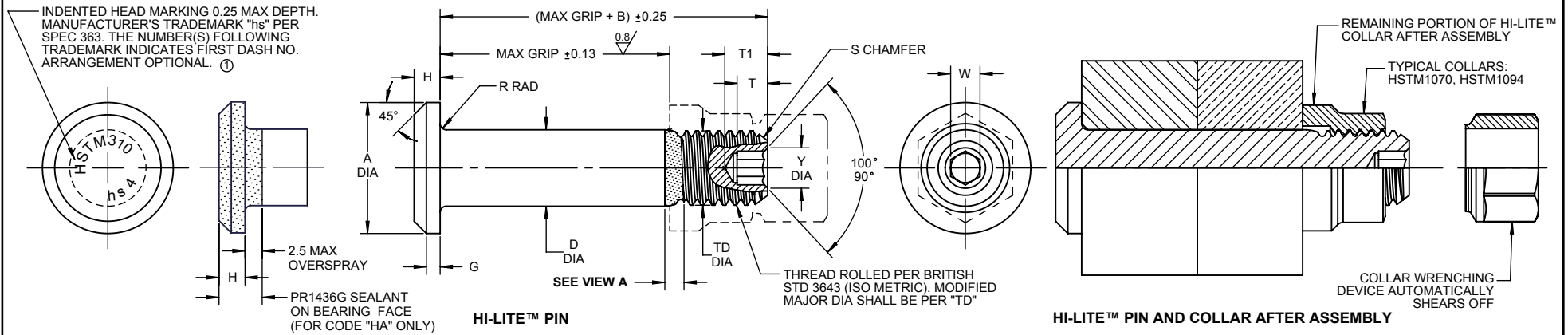




FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
				HSTM310	HSTM310AZ AND HSTM310HA							* W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA		
04	4	6.65 6.25	7.11	4.490 4.478	4.490 4.465	3.91 3.86	0.6	1.20 0.95	0.65 0.40	0.8 x 37°	M4 x 0.7-4h	1.64 1.61	1.63	2.90	2.30 1.90	20800	7800
05	5	8.15 7.65	7.65	5.490 5.478	5.490 5.465	4.90 4.84	0.8	1.40 1.15	0.65 0.40	0.8 x 37°	M5 x 0.8-4h	2.05 2.01	2.00	3.43	3.05 2.60	31100	11800
06	6	10.20 9.70	8.65	6.490 6.478	6.490 6.465	5.88 5.81	0.9	1.75 1.50	0.65 0.40	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.25	4.06	3.60 3.10	43500	18200
08	8	12.85 12.25	9.65	8.487 8.472	8.487 8.462	7.88 7.80	1.0	2.20 1.95	0.75 0.50	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	2.75	5.08	4.60 4.05	74300	31600
10	10	16.20 15.40	11.82	10.487 10.472	10.487 10.462	9.88 9.80	1.3	2.65 2.40	0.75 0.50	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	3.50	5.97	5.55 5.00	113400	48900
12	12	18.80 18.00	13.33	12.484 12.466	12.484 12.459	11.87 11.76	1.5	2.95 2.70	0.75 0.50	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	4.30	6.99	6.45 5.90	160800	66700

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 0.25 FIR.
 2. Surface texture per ISO/R468.
 3. Dimensions are in millimeters and to be met after finish.
 - 4 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: 6Al-4V titanium alloy per AMS4928 or AMS4967 for all sizes.
 6Al-6V-2Sn titanium alloy per AMS4971 is acceptable for -10 and larger sizes.

HEAT TREAT: 655 MPa shear minimum.

- FINISH:** HSTM310(-)(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet (equivalent to LN9368 Blatt 4), with color black on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.
- ① ④ HSTM310AZ(-)(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, with color code black on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.
- ① ④ HSTM310HA(-)(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, apply precoat No. PR1436G sealant (.051-.127 mm thick) with color code black on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification M380.

CODE: First dash number indicates nominal diameter in 1 mm.
 Second dash number indicates maximum grip in 1 mm.
 See Finish note for explanation of code letters.

HOW TO ORDER
 ① **EXAMPLE:**

Pin Part Number
 HSTM310AZ 04-8
 — 8 mm Maximum Grip Length
 — 4 mm Nominal Diameter Pin
 — Finish Code
 — Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
 HSTM3104070-04-8
 — Size and Grip Length. See Above Example
 — Collar Part Number
 — Pin Part Number

* INCH STANDARD HEX

"HI-LITE", "HST", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY D.P.S.	DATE 1987-01-28	TITLE HI-LITE™ PIN (METRIC SERIES) PROTRUDING SHEAR HEAD TITANIUM 1mm GRIP VARIATION - 0.5mm OVERSIZE
APPROVED E.E.B.	DATE 1987-01-28	
REVISION ①	DATE F.CARINGELLA 2017-12-14	DRAWING NUMBER HSTM310