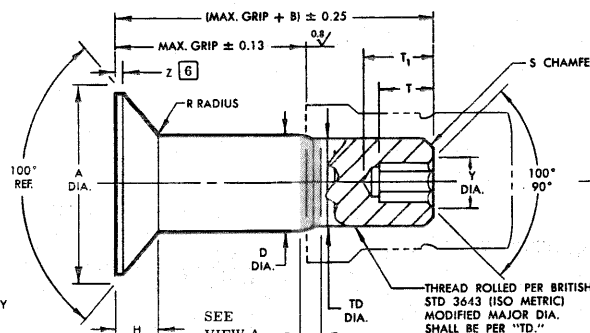
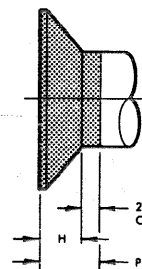
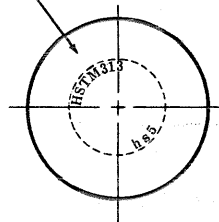
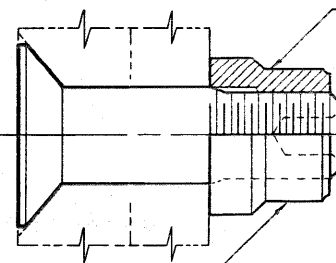
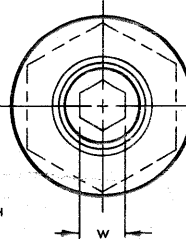


INDENTED HEAD MARKING MAXIMUM DEPTH 0.25.
"hs" indicates HI-SHEAR trademark.
The number(s) following the trademark indicate first dash number. Arrangement optional.



HI-LITE[®] ST™ PIN (METRIC)



REMAINING PORTION OF
HI-LITE ST COLLAR AFTER ASSEMBLY

COLLAR WRENCHING
DEVICE AUTOMATICALLY
SHEARS OFF

TYPICAL COLLARS: HSTM1087

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 (MODIFIED)	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
				HSTM313	HSTM313AU HSTM313AZ AND HSTM313HA								* W HEX.	T HEX DEPTH MIN.	T1 DEPTH MAX.	Y DIA.		
-04	4	8.63	7.11	4.490	4.490	3.91	0.11	1.74	0.65	0.25	0.8 x 37°	M4 x 0.7-4h	1.64	1.63	2.90	2.30	20800	9800
		8.49		4.478	4.465	3.86		1.68	0.40				1.61					
-05	5	10.63	7.65	5.490	5.490	4.90	0.13	2.16	0.75	0.38	0.8 x 37°	M5 x 0.8-4h	2.05	2.00	3.43	3.05	31100	15600
		10.49		5.478	5.465	4.84		2.10	0.50				2.01					
-06	6	12.63	8.65	6.490	6.490	5.88	0.16	2.58	0.75	0.38	0.8 x 37°	M6 x 1.0-4h	2.46	2.25	4.06	3.60	43500	22200
		12.49		6.478	6.465	5.81		2.52	0.50				2.40					
-08	8	16.63	9.65	8.487	8.487	7.88	0.18	3.42	1.00	0.38	1.2 x 37°	M8 x 1.0-4h	3.29	2.75	5.08	4.60	74300	42000
		16.49		8.472	8.462	7.80		3.36	0.75				3.22					

* INCH STANDARD HEX.

SEE COLLAR STANDARDS
FOR COLLAR STRENGTHS.
LOWER STRENGTH (PIN
OR COLLAR) DETERMINES
SYSTEM STRENGTH.

- GENERAL NOTES: 1. Head edge out of roundness shall not exceed "F."
2. Concentricity: Conical surface of head to "D" diameter within 0.08 FIR.
3. "H" is dimensioned from maximum "D" diameter.
4. Surface texture per ISO/R468.
5. Dimensions to be met after finish.
6. Curved or flat edge manufacturer's option.

MATERIAL: 6Al-4V titanium alloy per Spec. AMS 4928 or AMS 4967 for all sizes.
6Al-6V-2Sn titanium alloy per Spec. AMS 4971 is acceptable for -10 size and larger.

HEAT TREAT: 655 N/mm² minimum.

FINISH: HSTM313-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet (equivalent to LN9368 Blatt 4), with color code black on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.
HSTM313AU-()-() = Solid film lube per "Electrofilm" XSF-104.
HSTM313AZ-()-() = 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.
HSTM313HA-()-() = 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 No. 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
EXAMPLES:

Pin Part Number Only

HSTM313-04-8

8 mm Maximum Grip Length

4 mm Nominal Diameter Pin

Pin Part Number

Pin and Collar Assembly Part Number Combination

HSTM3131087-04-8

Size and Grip Length, See Above Example

Collar Part Number

Pin Part Number

THIS AREA OF SPECIAL CONFIGURATION
AND COLD WORKING TO MEET PHYSICAL
REQUIREMENTS.



VIEW A
HI-LITE THREAD TRANSITION AREA.
SEE SPECIFICATION FOR INSPECTION.

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	DATE	TITLE
D.P.S.	1-28-87	HI-LITE [®] ST™ PIN (METRIC SERIES)
APPROVED	DATE	100° FLUSH TENSION HEAD
E.E.B.	1-28-87	TITANIUM
REVISION	DATE	1 mm GRIP VARIATION-0.5 mm OVERSIZE
		DRAWING NUMBER
		HSTM313