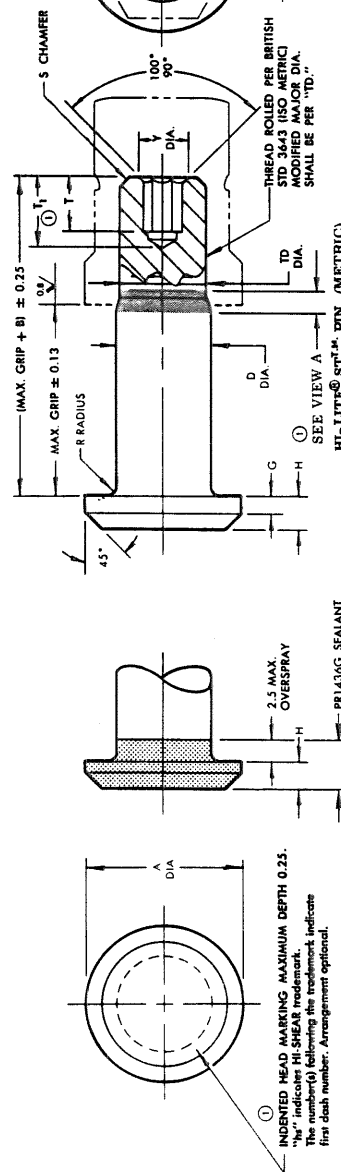




HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

SEE COLLAR STANDARDS FOR COLLAR STRENGTH, LOWER STRENGTH OF COLLAR DETERMINES SYSTEM STRENGTH.

FIRST DASH NO.	①	NOM. DIA.	A	B	D DIA.	①	D DIA.	①	HSTM12AU HSTM12AZ AND HSTM12HA	TD DIA.	G	H	R	S	CHAMFER REF.	THREAD (MODIFIED)	# T HEX W HEX.	T1 DEPTH MAX.	Y DIA.	DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
-04	①	NOTE: USE HSTM12-05																			
-05	①	NOTE: USE HSTM12-06																			
-06			6	11.90	8.90	6.990	6.990	5.88	2.30	0.65	1.3	2.05	0.40	0.8 x 37°		M6 x 1.0-4h	2.46	4.06	3.60	50400	22200
-08			8	13.85	9.90	8.987	8.987	7.88	3.05	0.75	1.6	2.80	0.50	1.2 x 37°		M8 x 1.0-4h	3.29	5.08	4.60	83300	42000
				13.25		8.972	8.962	7.80									3.22		4.05		

GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within 0.25 FIR.

2. Surface texture per ISO/R469.

3. Dimensions to be met after finish.

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

① HEAT TREAT: 655 N/mm² shear minimum.

① FINISH: HSTM612-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet (equivalent to IN9388 Blatt 4), with color code black on thread end plus cetyl alcohol lube per Hi-Shear Spec. 305.
HSTM612AU-()-() = Solid film lube per Hi-Shear Spec. 305.
HSTM612AZ-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294 with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HSTM612HA-()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, apply precoat No. PR1436G sealant (0.051-.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.

① THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS.



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

Pin Part Number Only
HSTM612-04-8
8 mm Maximum Grip Length
4 mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HSTM6123000-04-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

HOW TO ORDER
EXAMPLES: