

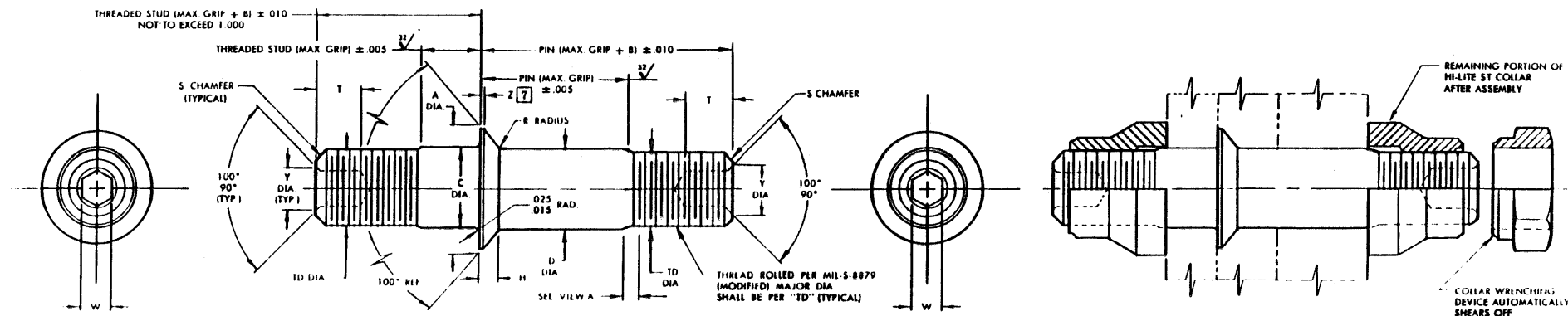
hi-shear
CORPORATION

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"CAGE" = Commercial And Government Entity

HI-SHEAR CORPORATION, U.S.A.(Patent Holder).....CAGE No. 73197
A Subsidiary of GFI Industries, France
AIR INDUSTRIES CO., INC. (Licensee-U.S.A. & Canada).....CAGE No. 06725
SPS TECHNOLOGIES, U.S.A. (Licensee).....CAGE No. 56878
HI-SHEAR FASTENERS EUROPE LTD., U.K. (Licensee).....CAGE No. 0LB66
A Subsidiary of GFI Industries, France

SIMMONDS S.A. France(Licensee - EEC Countries-Collars)
SI-CHAMOND GRANAT S.A. France (Licensee - EEC Countries)
TOKYO SCREW COMPANY, Japan.....(Licensee-Japan)



HI-LITE ST THREADED STUD PIN

HI-LITE ST THREADED STUD PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	C DIA.		D DIA.		TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING	WITH COATING	WITHOUT COATING	WITH COATING [8]								W HEX.	T DEPTH	Y DIA.		
6	3/16	.3536 .3486	.290	.1895 .1890	.1895 .1885	.2182 .2177	.2182 .2172	.1840 .1810	.005 .005	.0568 .0547	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	7,100	2,590
8	1/4	.4732 .4682	.320	.2495 .2490	.2495 .2485	.2807 .2802	.2807 .2797	.2440 .2410	.006 .006	.0807 .0786	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	11,800	4,760
10	5/16	.5619 .5569	.380	.3120 .3115	.3120 .3110	.3432 .3427	.3432 .3422	.3060 .3020	.007 .007	.0917 .0896	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	17,600	7,100
12	3/8	.6912 .6862	.420	.3745 .3740	.3745 .3735	.4057 .4052	.4057 .4047	.3680 .3640	.008 .008	.1198 .1177	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	24,600	10,600

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:

- Head edge out of roundness shall not exceed "F".
- Concentricity: Conical surface of head to "D" diameter within .005 FIM. Threaded stud size to pin within .010 FIM.
- "H" dimension from maximum "D" diameter.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- [7] Curved or flat edge manufacturer's option.
- [8] Maximum "D" diameter may be increased by .0002 to allow for aluminum coating application.
- "D" diameter may increase by .0005 inch after application of solid film lube.

MATERIAL: 6Al-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

② FINISH: HST345-(-)(-)(-) = Cetyl alcohol lube per Hi-Shear Spec. 305.
HST345AG(-)(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HST345AP(-)(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

HST345DL(-)(-) = Kalgard FA or EM6200 solid film lube per AS5272, Type I and cetyl alcohol lube per MIL-L-87132.

SPECIFICATION: Hi-Lite Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds. Second dash number indicates maximum grip in 1/16ths. Third dash number indicates threaded stud maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER
EXAMPLES:

Pin Part Number Only
HST345-8-8-8
8/16 or 1/2 Threaded Stud Maximum Grip Length
8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Pin Part Number

U.S. Patents 4,326,825; 4,485,510 and 4,957,401. Other U.S. and international patents pending. "Hi-Lite" and "HST" are registered trademarks and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.	
DRAWN D.P.S.	DATE 7-20-98
APPROVED D.A.W.	DATE 7-20-98
REVISION ②	DATE J.R.H. 4-21-99
TITLE HI-LITE*ST™ THREADED STUD PIN 100° FLUSH MS 20426 SHEAR HEAD TITANIUM 1/16" GRIP VARIATION - 1/32" OVERSIZE DRAWING NUMBER HST345	