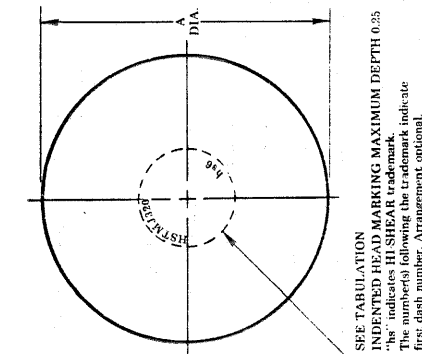
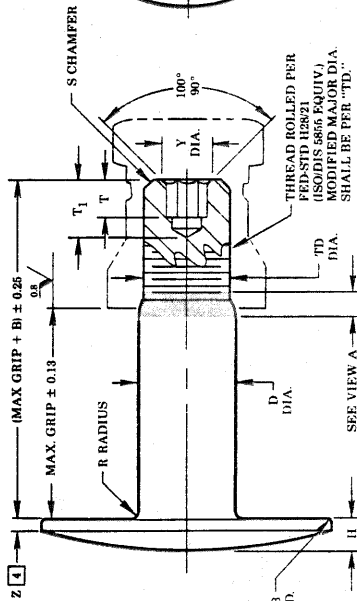
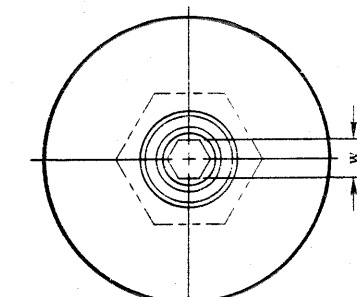




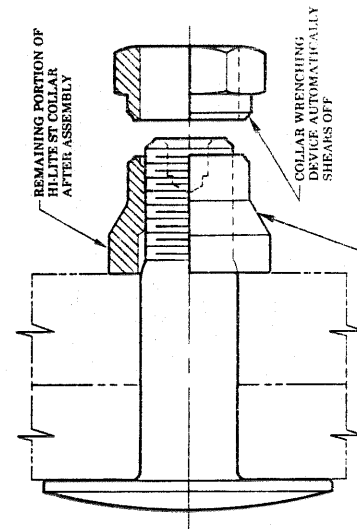
SEE TABULATION
INDENTED HEAD MARKING MAXIMUM DEPTH 0.25
The "A" indicates HI-SHEAR trademark.
The numbers following the trademark indicate
first dash number. Arrangement optional.



HI-LITE® ST™ PIN (METRIC)



HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY



TYPICAL COLLARS: HSTMJ70
HSTMJ084

1

FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	H DIA.	R RAD.	Z MAX.	S CHAMFER REF.	THREAD (MODIFIED)	# W HEX.	SOCKET			DOUBLE SHEAR TENSION MINIMUM	TENSION MINIMUM
													T1 HEX DIA.	T1 HEX DIA.	Y DIA.		
-04	MJ320 hs4	4	12.45	7.11	3.990	3.990	1.20	0.65	0.65	0.8 x 45°	M14 x 0.7-4h	1.64	1.63	2.90	2.90	16,400	7,330
-05	MJ320 hs5	5	15.49	7.65	4.990	4.990	1.37	0.65	0.65	0.8 x 45°	M15 x 0.8-4h	2.05	2.00	3.43	3.05	25,700	11,100
-06	HSTMJ320 hs6	6	18.41	8.65	5.990	5.990	1.78	0.65	0.75	0.8 x 45°	M16 x 1.0-4h	2.46	2.25	4.06	3.60	37,000	17,100
-08	HSTMJ320 hs8	8	24.64	9.65	7.987	7.987	2.16	0.75	0.75	1.2 x 45°	M18 x 1.0-4h	3.29	2.75	5.08	3.10	65,800	29,700
			23.11		7.972	7.972	1.91	0.50				3.22			4.05		

* INCH STANDARD HEX

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

2. Dimensions to be met after finish.

3. Surface texture per ISO/DR221.

4. Curved or flat edge manufacturer's option.

MATERIAL: A-286 high temperature alloy per Spec. AMS5737 or AMS5731.

HEAT TREAT: 655 N/mm² shear minimum at room temperature.

FINISH: HSTMJ320 (H) = Passivate per Hi-Shear Spec. 258 with color black on thread

and end and cetyl alcohol lube per Hi-Shear Spec. 305.

HSTMJ320TR (H) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl

alcohol lube per Hi-Shear Spec. 305.

HSTMJ320TF (H) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.

SPECIFICATION: Hi-Lite Product Specification No. M380.

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



VIEW A

HI-LITE THREAD TRANSITION AREA.

SEE SPECIFICATION FOR INSPECTION.

Pin and Collar Assembly Part Number Combination
HSTMJ320TR-04-8

Size and Grip Length. See Above Example

Collar Part Number

Pin Part Number

Pin and Collar Assembly Part Number Combination
HSTMJ320TR-04-8

Size and Grip Length. See Above Example

Collar Part Number

Pin Part Number

U.S. Patents 4,326,825 and 4,455,510. 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	HSTMJ320
Despl. 104	3-8-88	HI-LITE ST™ PIN (MJ METRIC SERIES) PROTRUDING SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY COMPOSITE APPLICATION 1 mm GRIP VARIATION	
APPROVED	DATE		
E.E.B.	3/7/88		
REVISION	DATE		