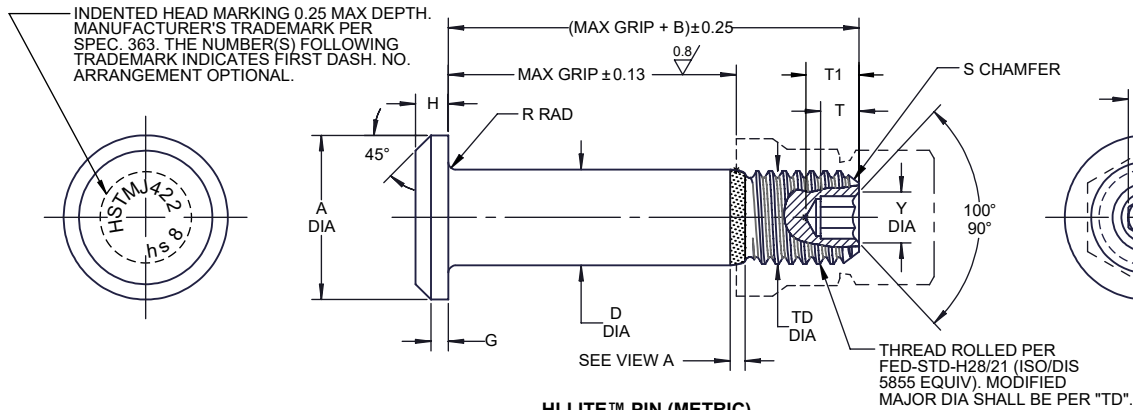
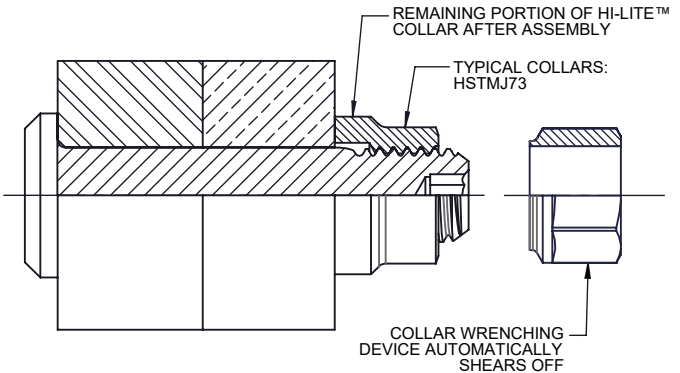




HI-LITE™ PIN (METRIC)

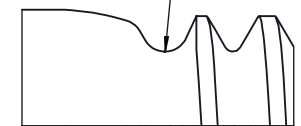


HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	HEAD MARKING	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					WITHOUT COATING	WITH COATING							* W HEX	T HEX DEPTH MIN	T1 DEPTH MAX	Y DIA		
04	MJ422 hs 4	4	8.15 7.75	7.11	3.990 3.978	3.990 3.965	3.91 3.86	0.9	1.60 1.40	0.65 0.40	0.8 x 37°	MJ4 x 0.7-4h	1.64 1.61	1.63	2.90	2.30 1.90	21,600	13,600
05	MJ422 hs 5	5	9.75 9.25	7.65	4.990 4.978	4.990 4.965	4.90 4.84	1.0	1.90 1.65	0.65 0.40	0.8 x 37°	MJ5 x 0.8-4h	2.05 2.01	2.00	3.43	3.05 2.60	33,800	22,000
06	HSTMJ422 hs 6	6	10.90 10.40	8.65	5.990 5.978	5.990 5.965	5.88 5.81	1.3	2.30 2.05	0.65 0.40	0.8 x 37°	MJ6 x 1.0-4h	2.46 2.40	2.25	4.06	3.60 3.10	48,600	31,100
08	HSTMJ422 hs 8	8	12.85 12.25	9.65	7.987 7.972	7.987 7.962	7.88 7.80	1.6	3.05 2.80	0.75 0.50	1.2 x 37°	MJ8 x 1.0-4h	3.29 3.22	2.75	5.08	4.60 4.05	86,500	58,000
10	HSTMJ422 hs 10	10	16.20 15.40	11.82	9.987 9.972	9.987 9.962	9.88 9.80	1.9	3.75 3.50	0.75 0.50	1.2 x 37°	MJ10 x 1.25-4h	4.11 4.02	3.50	5.97	5.50 5.00	135,100	90,800

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 FIM.
 2. Dimensions are in millimeters and to be met after finish.
 3. Surface texture per ISO/R468.

- ④ After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 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: Nickel base alloy per AMS5662.

HEAT TREAT: 860 N/mm² shear minimum.

FINISH: HSTMJ422-()-() = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.

- ④ HSTMJ422AZ()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification No. M380, except thread as noted.

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
 EXAMPLE:**

Pin Part Number
 HSTMJ422AZ04-8

8mm Maximum Grip Length
 4mm Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
 HSTMJ42270-04-8

Size and Grip Length, See Above Example
 Collar Part Number
 Pin Part Number

"HI-LITE", "HST", AND "HI-KOTE"
 ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY D.P.S.	DATE 1989-10-13	TITLE HI-LITE™ PIN (MJ METRIC SERIES) PROTRUDING TENSION HEAD INCONEL 718 NICKEL ALLOY 1mm GRIP VARIATION
APPROVED D.A.W.	DATE 1989-10-16	
REVISION 6	DATE D. PEÑA 2020-06-26	DRAWING NUMBER HSTMJ422