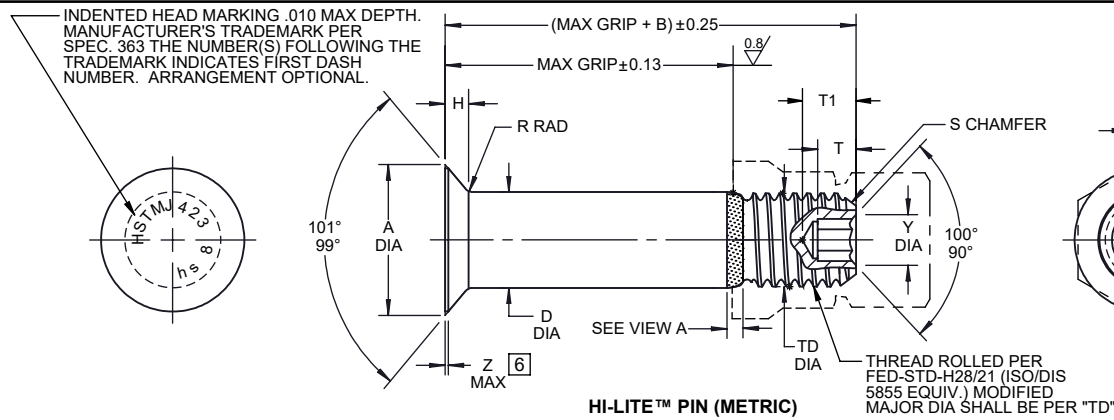
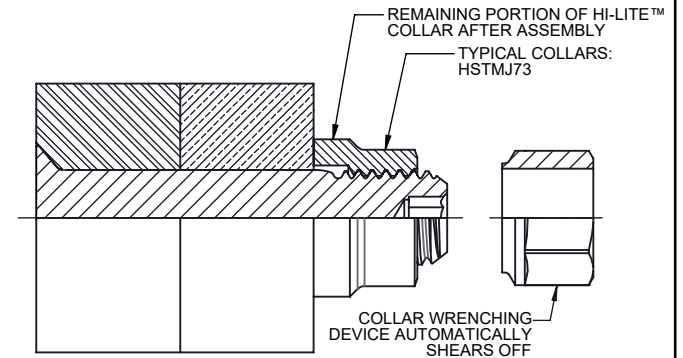




HI-LITE™ PIN (METRIC)



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	HEAD MARKING	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					WITHOUT COATING	WITH COATING								* W HEX	T HEX DEPTH MIN	T1 DEPTH MAX	Y DIA		
04	MJ423 hs 4	4	8.00 7.88	7.11	3.990 3.978	3.990 3.965	3.91 3.86	0.11	1.68 1.62	0.65 0.40	0.25	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	MJ423 hs 5	5	10.00 9.88	7.65	4.990 4.978	4.990 4.965	4.90 4.84	0.13	2.11 2.05	0.75 0.50	0.38	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	HSTMJ423 hs 6	6	12.00 11.88	8.65	5.990 5.978	5.990 5.965	5.88 5.81	0.16	2.53 2.47	0.75 0.50	0.38	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	HSTMJ423 hs 8	8	16.00 15.88	9.65	7.987 7.972	7.987 7.962	7.88 7.80	0.18	3.38 3.32	1.00 0.75	0.38	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	HSTMJ423 hs 10	10	20.00 19.88	11.82	9.987 9.972	9.987 9.962	9.88 9.80	0.21	4.23 4.17	1.00 0.75	0.38	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

* INCH STANDARD HEX

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .08 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions are in millimeters and to be met after finish.
 - Surface texture per ISO/R468.
 - Curved or flat edge manufacturer's option.

- ⑦ 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: HSTMJ423-(-)(-) = Passivate per Hi-Shear Spec. 258, and cetyl alcohol lube per Hi-Shear Spec. 305.

- ⑦ HSTMJ423AZ(-)(-) = 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.

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
HSTMJ423-AZ-04-8
 8 mm Maximum Grip Length
 4 mm Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

Pin and Collar Assembly Part Number Combination

HSTMJ423-04-8
 Size and Grip Length, see Above Example
 Collar Part Number
 Basic 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

"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) 100° FLUSH TENSION HEAD INCONEL 718 NICKEL ALLOY 1 mm GRIP VARIATION
APPROVED D.A.W.	DATE 1989-10-15	
REVISION 6	DATE D. PEÑA 2020-06-26	DRAWING NUMBER HSTMJ423