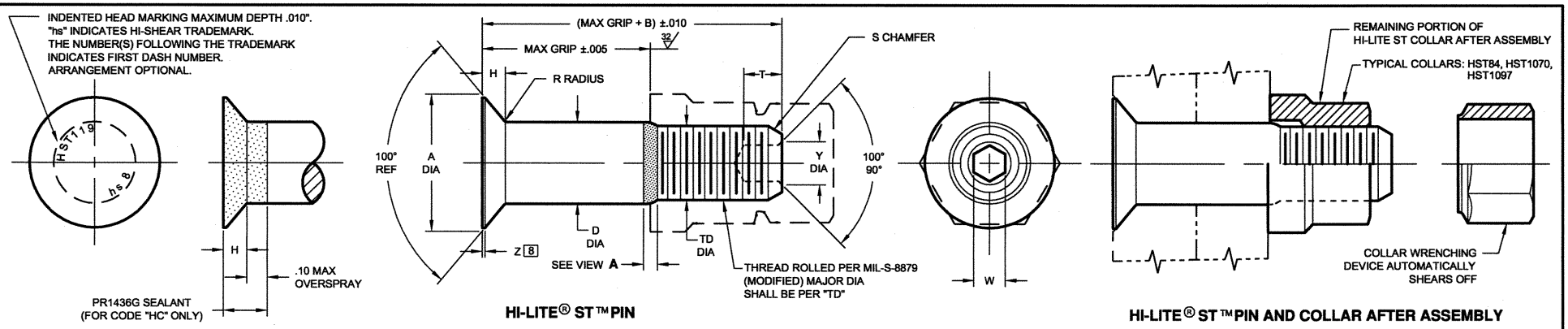
hi-shear CORPORATION
2600 Skypark Drive
Torrance, California 90509 U.S.A.
Telephone (310) 326-8110
FAX (310) 784-4144

HI-SHEAR CORPORATION, U.S.A. ——(Patent Holder)—— CAGE No. 73197 a LISI AEROSPACE Company AIR INDUSTRIES CO., INC., U.S.A. ——(Licensee - U.S.A & Canada) –CAGE No. 06725 SPS TECHNOLOGIES, U.S.A. ——(Licensee)—— CAGE No. 56878 FAIRCHILD - SIMMONDS S.A. France ——(Licensee)—— CAGE No. 92215	BLANC AERO INDUSTRIES UK LIMITED ——(Licensee)—— CAGE No. OLB68 a LISI AEROSPACE Company BLANC AERO S.A. France ——(Licensee - ECC Countries) a GFI AEROSPACE Company TOKYO SCREW COMPANY, Japan ——(Licensee - Japan)

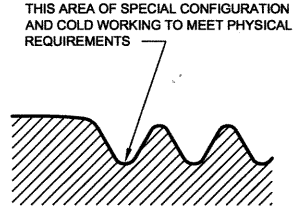


HI-LITE® ST™ PIN

HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	DIA DIA	TD DIA	F [1] REF	H	R RAD	Z [7] MAX	S CHAMFER REF	THREAD	SOCKET W HEX	SOCKET T DEPTH	SOCKET Y DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5				NOTE: USE HST19-6-( ) ④												
6	13/64	.3016 .2966	.300	.2026 .2016	.1840 .1810	.005	.0415 .0394	.030 .020	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.119 .104	6,130	2,000
8	17/64	.3948 .3898	.330	.2651 .2641	.2440 .2410	.006	.0544 .0523	.030 .020	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.142 .122	10,490	3,700
10	21/64	.4739 .4689	.390	.3276 .3266	.3060 .3020	.007	.0614 .0593	.040 .030	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.180 .160	16,000	5,000
12	25/64	.5604 .5554	.430	.3901 .3891	.3680 .3640	.008	.0714 .0693	.040 .030	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.217 .197	22,700	7,200
14	29/64	.6680 .6620	.510	.4526 .4516	.4310 .4260	.009	.0904 .0879	.050 .040	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.253 .233	30,600	10,000
16	33/64	.7540 .7480	.610	.5151 .5141	.4930 .4880	.010	.1002 .0977	.050 .040	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.289 .269	39,600	13,500

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.



VIEW A

HI-LITE THREAD TRANSITION AREA
SEE SPECIFICATION FOR INSPECTION

GENERAL NOTES:
1. Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
3. "H" is dimensioned from maximum "D" diameter.
4. Dimensions to be met after finish.
5. Surface texture per ANSI B46.1.
6. Hole preparation per NAS618.
7. Curved or flat edge manufacturer's option.
8. Non-lubed pins must be used with wet sealant or with lubed collars.
9. Use HST219 for oversize replacement.

MATERIAL: Alloy steel per AMS6415, AMS6349, or AMS-S-6049.

HEAT TREAT: 95,000 psi shear minimum (160,000 psi tensile per AMS-H-6875).

FINISH:
- HST119-( )-( ) = Cadmium plate per AMS-QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST119PB( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST119HC( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and apply Precoat No. PR1436G sealant (.002-.005 thick), and cetyl alcohol lube per Hi-Shear Spec. 305.
- [8] HST119PN( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
- HST119RZ( )-( ) = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HST119TF( )-( ) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.
- HST119TP( )-( ) = Cadmium plate per AMS-QQ-P-416, Type III, Class 2, and Hi-Kote 2 solid film lube per Hi-Shear Spec. 292, color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HST119 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLE:

Pin Part Number Only
HST119PB8-8
- 8/16 or 1/2 Maximum Grip Length
- 8/32 or 1/4 Nominal Diameter Pin
- Pin Part Number

Pin and Collar Assembly Part Number Combination
HST119PB84-8-8
- Size and Grip Length, See Above Example
- Collar Part Number
- 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	DATE	TITLE
D.P.S.	8-3-90	**HI-LITE® ST™ PIN** 100° FLUSH SHEAR HEAD ALLOY STEEL, 1/64" OVERSIZE 1/16" GRIP VARIATION
APPROVED	DATE	
JGWilcox	8-3-90	
REVISION	DATE	DRAWING NUMBER
④	J.F.Obispo 3-28-06	**HST119**

HST119

JFO-STD/HSTPIN