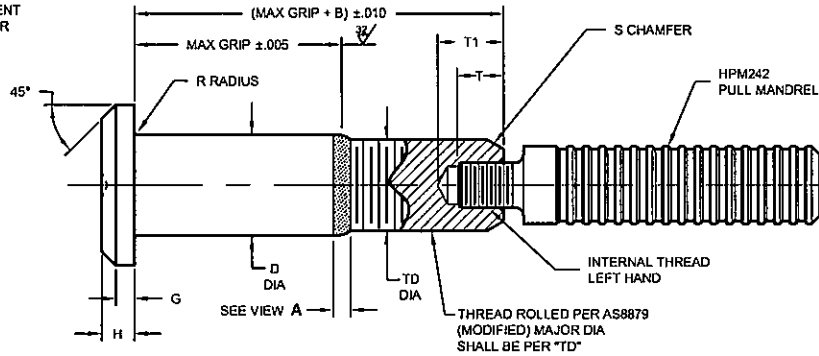
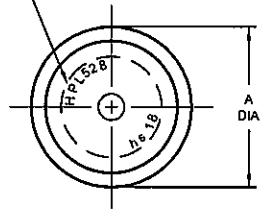
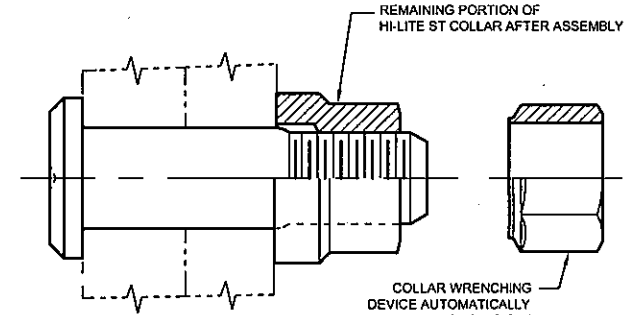


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
 hs INDICATES HI-SHEAR TRADEMARK.
 THE NUMBER(S) FOLLOWING THE TRADEMARK
 INDICATES FIRST DASH NUMBER, ARRANGEMENT
 OPTIONAL. INDENTATION IS .020-.030 DIAMETER
 x .020-.030 DEPTH.



HI-LITE® ST™ PIN



HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

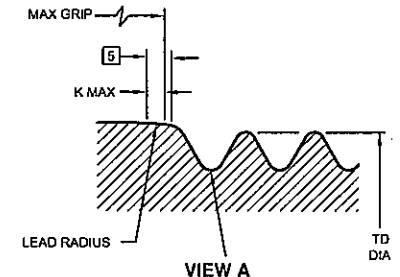
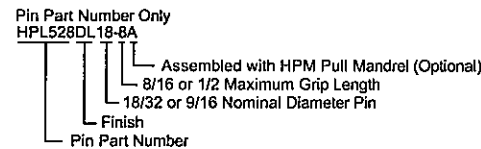
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA WITHOUT COATING OR SOLID FILM	TD DIA	G REF	H	K MAX	R RAD	S CHAMFER REF	THREAD	INTERNAL THREAD LEFT HAND			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
												T MIN	T1 MAX	THREAD SIZE		
18	9/16	.877	.770	.5615	.5550	.115	.210	.039	.040	1/16" x 37°	9/16-18UNJF-3A Modified	.280	.456	.312-24UNJF-2B	53,700	32,400
		.842	.5610	.5500	.200	.025	.025									
20	5/8	.953	.825	.6240	.6180	.130	.238	.044	.040	1/16" x 37°	5/8-18UNJF-3A Modified	.280	.456	.312-24UNJF-2B	66,300	41,000
		.905	.6235	.6120	.228	.025	.025									
24	3/4	1.150	1.050	.7490	.7430	.200	.335	.044	.045	1/16" x 37°	3/4-16UNJF-3A Modified	.305	.480	.375-24UNJF-2B	95,200	59,500
		1.110	.7485	.7370	.320	.030	.030									

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions to be met after finish, except as noted.
 3. Surface texture per ANSI B46.1.
 4. Hole preparation per NAS618.
 5. Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
 6. "D" diameter may increase by .0005" after application of solid film lube and .001" after aluminum coating.
 7. Use HPL628 for oversize replacement.

CODE: First dash number indicates nominal diameter in 1/32nds. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters. Code letter "A" following second dash number indicates assembly with HPM pull mandrel.

HOW TO ORDER EXAMPLE:



HI-LITE THREAD TRANSITION AREA. THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS. SEE SPECIFICATION FOR INSPECTION.

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

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HPL528AP()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HPL528DL()-() = Kalgard FA or EM620C solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 391.

6 U.S. Patents 4,326,825; 4,485,510, 4,957,401 and 6,665,922 Other U.S. and international patents pending. "Hi-Lite" and "Pull-In" are registered trademarks and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.											
<table border="1"> <tr> <th>DRAWN</th> <th>DATE</th> <th>TITLE</th> </tr> <tr> <td>J.F.O.</td> <td>11-25-91</td> <td rowspan="3">6 PULL-IN® HI-LITE® ST™ PIN PROTRUDING TENSION HEAD TITANIUM, SPECIAL THREAD 1/16" GRIP VARIATION</td> </tr> <tr> <th>APPROVED</th> <th>DATE</th> </tr> <tr> <td>DAW</td> <td>11-25-91</td> </tr> </table>	DRAWN	DATE	TITLE	J.F.O.	11-25-91	6 PULL-IN® HI-LITE® ST™ PIN PROTRUDING TENSION HEAD TITANIUM, SPECIAL THREAD 1/16" GRIP VARIATION	APPROVED	DATE	DAW	11-25-91	DRAWING NUMBER HPL528
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HPL528