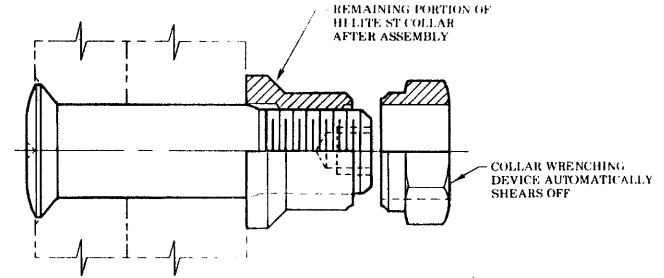
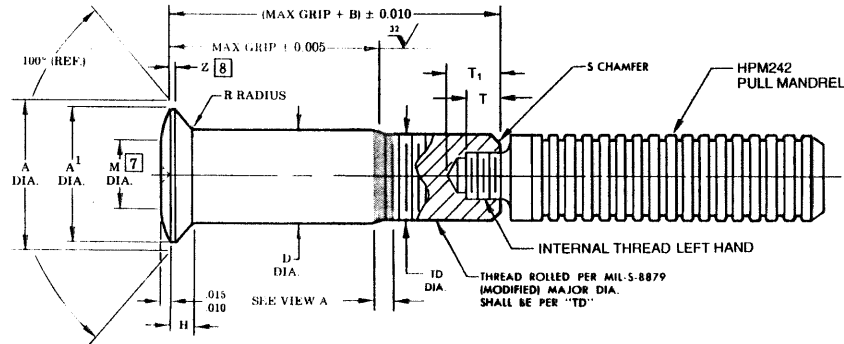


hi-shear
CORPORATION

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



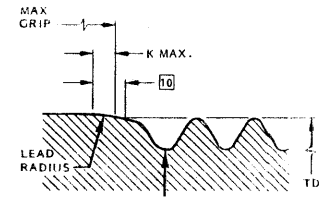
INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK. THE NUMBER(S) FOLLOWING THE TRADEMARK INDICATE FIRST DASH NUMBER. ARRANGEMENT OPTIONAL. INDENTATION IS .050-.060 DIAMETER x .020-.030 DEPTH.

HI-LITE® ST™ PIN

HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	A' DIA.	B REF.	D DIA BEFORE SOLID FILM LUBE	TD DIA.	F	H	K MAX	M DIA. FLAT	R RAD.	Z MAX.	S CHAMFER REF.	THREAD	INTERNAL THREAD LEFT HAND		DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	
															T MAX	T1 MAX			THREAD SIZE
18	9/16	1.0337 1.0266	1.027 1.002	.770	.5615 .5610	.5550 .5500	.010	.1981 .1951	.039	.505 .475	.050 .040	.022	1/16" x 37°	9/16-18UNJF-3A Modified	.300	.456	.312-24UNJF-2B	53,700 47,200	24,700
20	5/8	1.1230 1.1158	1.116 1.091	.825	.6240 .6235	.6180 .6120	.010	.2094 .2064	.044	.565 .535	.050 .040	.022	1/16" x 37°	5/8-18UNJF-3A Modified	.300	.456	.312-24UNJF-2B	66,300 58,300	29,600
24	3/4	1.3500 1.3428	1.343 1.313	1.050	.7490 .7485	.7430 .7370	.012	.2521 .2491	.044	.680 .650	.050 .040	.025	1/16" x 37°	3/4-16UNJF-3A Modified	.350	.480	.375-24UNJF-2B	95,200 83,900	42,900

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



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

GENERAL NOTES:

- Head edge out of roundness shall not exceed "F".
- Concentricity: Conical surface of head to "D" diameter within .005 FIR.
- "H" is dimensioned from maximum "D" diameter.
- Dimensions to be met after finish, except as noted.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Flat permissible within "M" diameter.
- Curved or flat edge manufacturer's option.
- Use HPL629 for oversize replacement.
- Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
- "D" diameter may increase by .0005 after application of solid film lube.

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 EXAMPLES:

Pin Part Number Only
HPL529DL18-8A
Assembled with HPM Pull Mandrel (Optional)
8/16 or 1/2 Maximum Grip Length
18/32 or 9/16 Nominal Diameter Pin
Finish
Pin Part Number

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

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HPL529DL(-) = Kalgard FA or EM620C solid film lube per MIL-L-46010, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL529AP(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 391.

U.S. Patents 4,326,825; 4,485,510 and 4,957,401.
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
D.P.S	12-12-91	HI-LITE® ST™ PIN 100° FLUSH CROWN (MS20426) HEAD TITANIUM SPECIAL THREAD 1/16" GRIP VARIATION
APPROVED	DATE	DRAWING NUMBER
DAW	2-6-92	HPL529
REVISION	DATE	
③	J. Henderson 9-15-98	