

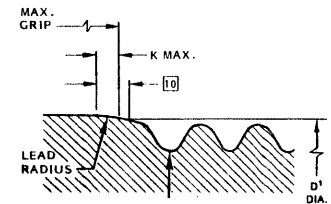
INDENTED HEAD MARKING MAXIMUM DEPTH .010".  
"hs" INDICATES HI-SHEAR TRADEMARK. THE NUMBER(S) FOLLOWING THE TRADEMARK INDICATE FIRST DASH NUMBER. ARRANGEMENT OPTIONAL. INDENTATION IS .050-.060 DIAMETER x .020-.030 DEPTH.

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	D' DIA REF.	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	T <sub>1</sub> MAX			THREAD SIZE
18	37/64	.8380 .8310	.830 .806	.770	.5771 .5786	.571	.5550 .5500	.010	.1094 .1065	.039	.505 .475	.050 .040	.022	1/16" x 37°	9/16-18UNJF-3A Modified	.300	.456	.312-24UNJF-2B	57,000 49,700	17,000
20	41/64	.9250 .9180	.917 .893	.825	.6396 .6391	.634	.6180 .6120	.010	.1197 .1168	.044	.565 .535	.050 .040	.022	1/16" x 37°	5/8-18UNJF-3A Modified	.300	.456	.312-24UNJF-2B	70,050 61,000	21,000

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 HPL727 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 of the pin which HPL627 oversize pin replaces.  
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  
HPL627DL-18-8A  
├── 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:** HPL627DL(-)(-) = Kalgard FA or EM620C solid film lube per MIL-L-46201, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.  
② HPL627AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

② **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	7-29-92	<b>HI-LITE® ST™ PIN</b> 100° FLUSH SHEAR CROWN HEAD TITANIUM SPECIAL THREAD 1/16" GRIP VARIATION, 1/64" OVERSIZE
APPROVED	DATE	DRAWING NUMBER
DAW	7-30-92	<b>HPL627</b>
REVISION	DATE	
②	J.F. Obispo 11-30-94	