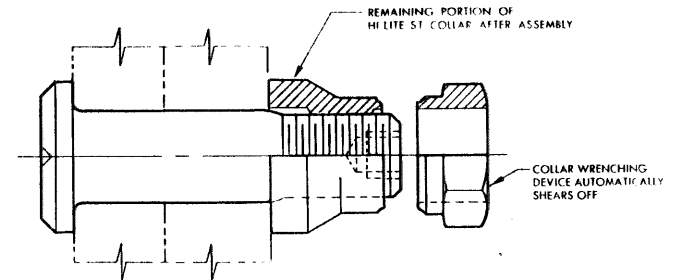


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"he" INDICATES HI-SHEAR TRADEMARK. THE
NUMBER(S) FOLLOWING THE TRADEMARK INDICATE
FIRST DASH NUMBER. ARRANGEMENT OPTIONAL.
INDENTATION IS .050-.060 DIAMETER x .020-.030 DEPTH.

SEE VIEW A

HI-LITE® ST™ PIN

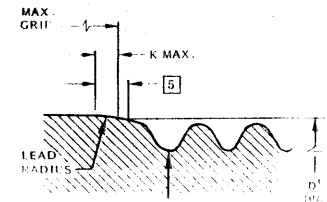


HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

6

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA BEFORE SOLID FILM LUBE	D' DIA REF.	TD DIA.	G REF.	H	K MAX	R RAD.	S CHAMFER REF.	THREAD	INTERNAL THREAD LEFT HAND		DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	
													T MAX	T ₁ MAX			
18	37/64	.877 .842	.770	.5771 .5766	.571	.5550 .5500	.115	.210 .200	.039	.040 .025	1/16" x 37°	9/16-18UNJF-3A Modified	.300	.456	.312-24UNJF-2B	57,000 49,700	32,400
20	41/64	.953 .905	.825	.6396 .6391	.634	.6180 .6120	.130	.238 .228	.044	.040 .025	1/16" x 37°	5/8-18UNJF-3A Modified	.300	.456	.312-24UNJF-2B	70,050 61,000	41,000
24	49/64	1.150 1.110	1.050	.7646 .7941	.759	.7430 .7370	.200	.335 .320	.044	.045 .030	1/16" x 37°	3/4-16UNJF-3A Modified	.350	.480	.375-24UNJF-2B	95,200 83,900	59,500

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:

1. Concentricity: "A" to "D" diameter within .010 FIR.
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 inch after application of solid film lube.
7. Use HPL728 for oversize replacement.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HPL628 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
HPL628DL-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:

HPL628DL(-) = Kalgard FA or EM620C solid film lube per MIL-L-4610, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL628AP(-) = 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 HI-LITE® ST™ PIN PROTRUDING TENSION HEAD TITANIUM SPECIAL THREAD 1/16" GRIP VARIATION, 1/64" OVERSIZE
D.P.S	7-29-92	
APPROVED	DATE	DRAWING NUMBER HPL628
DAW	7-30-92	
REVISION	DATE	
③	J.R.H. 10-08-98	