

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 ₁ MAX			THREAD SIZE
18	37/64	1.0337 1.0268	1.027 1.002	.770	5771 .5786	.571	.5550 .5500	.010	.1916 .1886	.039	.505 .475	.050 .040	.022	1/16" x 37°	9/16-18UNJF-3A Modified	.300	.456	.312-24UNJF-2B	57,000 49,700	24,700
20	41/64	1.1230 1.1158	1.116 1.091	.825	.6396 .6391	.634	.6180 .6120	.010	.2028 .1998	.044	.565 .535	.050 .040	.022	1/16" x 37°	5/8-18UNJF-3A Modified	.300	.456	.312-24UNJF-2B	70,050 61,000	29,600

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

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 HPL729 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 HPL629 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:

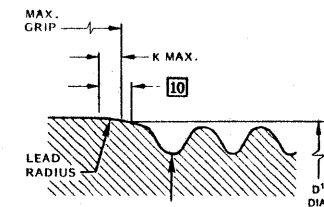
Pin Part Number Only
HPL629DL-18-8A
├── Assembled with HPM Pull Mandrel (Optional)
├── 8/16 or 1/2 Maximum Grip Length
├── 18/32 or 9/16 Nominal Diameter Pin
└── Finish
Pin Part Number

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

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HPL629DL-()-() = Kalgard FA or EM620C solid film lube per MIL-L-46010, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.
② HPL629AP-()-() = 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.



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

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 D.P.S 7-29-92	TITLE HI-LITE® ST™ PIN 100° FLUSH CROWN (MS20426) HEAD TITANIUM SPECIAL THREAD 1/16" GRIP VARIATION, 1/64" OVERSIZE
APPROVED DATE DAW 7-30-92	DRAWING NUMBER HPL629
REVISION DATE ② J.F. Oblispo 11-30-94	