

INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK. THE NUMBER(8) 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 ₁ MAX			THREAD SIZE
18	19/32	.8692 .8622	.862 .838	.770	.5927 .5922	.587	.5550 .5500	.010	.1160 .1131	.039	.505 .475	.050 .040	.022	1/16" x 37°	9/16-18UNJF-3A Modified	.300	.456	.312-24UNJF-2B	60,200 52,400	17,000
20	21/32	.9562 .9492	.949 .925	.825	.6552 .6547	.649	.6180 .6120	.010	.1260 .1230	.044	.565 .535	.050 .040	.022	1/16" x 37°	5/8-18UNJF-3A Modified	.300	.456	.312-24UNJF-2B	73,500 64,100	21,000

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

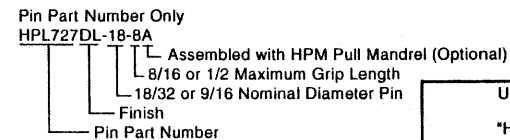
GENERAL NOTES:

- 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.
- Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
- Oversize replacement for HPL527 and HPL627.
- "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 HPL727 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:

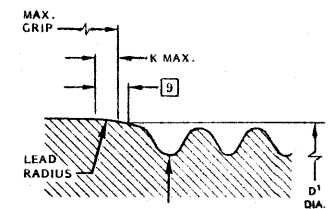


MATERIAL: 6Al-4V titanium alloy per Spec. AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HPL727DL-(-)(-) = Kalgard FA or EM620C solid film lube per MIL-L-46010, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.
② HPL727AP-(-)(-) = 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 SHEAR CROWN HEAD TITANIUM SPECIAL THREAD 1/16" GRIP VARIATION, 1/32" OVERSIZE
APPROVED DATE DAW 7-30-92	DRAWING NUMBER HPL727
REVISION DATE ② J.F.Obispo 11-30-94	

HPL727