

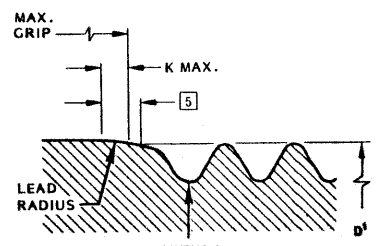
INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK. THE NUMBER(S) FOLLOWING THE TRADEMARK INDICATE FIRST DASH NUMBER. ARRANGEMENT OPTIONAL. INDENTATION IS .060-.080 DIAMETER x .020-.030 DEPTH.

HI-LITE® ST™ PIN

HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

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	T1 MAX			THREAD SIZE
18	19/32	.905 .870	.770	.5927 .5922	.587	.5550 .5500	.115	.210 .200	.039	.040 .025	1/16" x 37°	9/16-18UNJF-3A Modified	.300	.456	.312-24UNJF-2B	62,000 52,400	32,400
20	21/32	.975 .940	.825	.6552 .6547	.649	.6180 .6120	.130	.238 .228	.044	.040 .025	1/16" x 37°	5/8-18UNJF-3A Modified	.300	.456	.312-24UNJF-2B	73,500 64,100	41,000

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



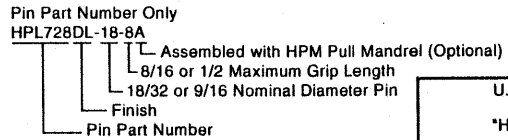
GENERAL NOTES:

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. Oversize replacement for HPL528 and HPL628.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HPL728 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:

- HPL728DL-(-) = Kalgard FA or EM620C solid film lube per MIL-L-46010, Type 1 and cetyl alcohol lube per Hi-Shear Spec. 305.
- ② HPL728AP-(-) = 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 D.P.S 7-29-92	TITLE HI-LITE® ST™ PIN PROTRUDING TENSION HEAD TITANIUM SPECIAL THREAD 1/16" GRIP VARIATION, 1/32" OVERSIZE
APPROVED DATE DAW 7-30-92	DRAWING NUMBER HPL728
REVISION DATE ② J.F.Obispo 12-01-94	

HPL728