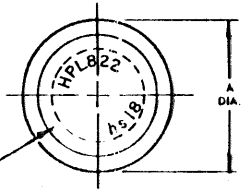
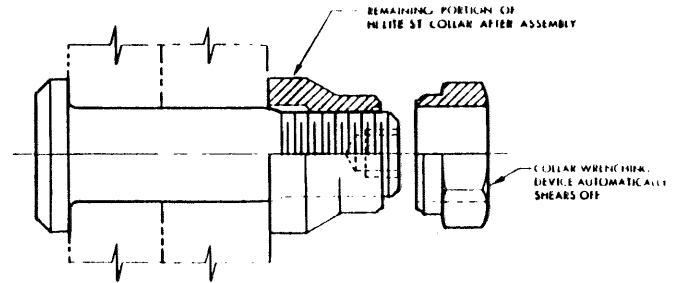
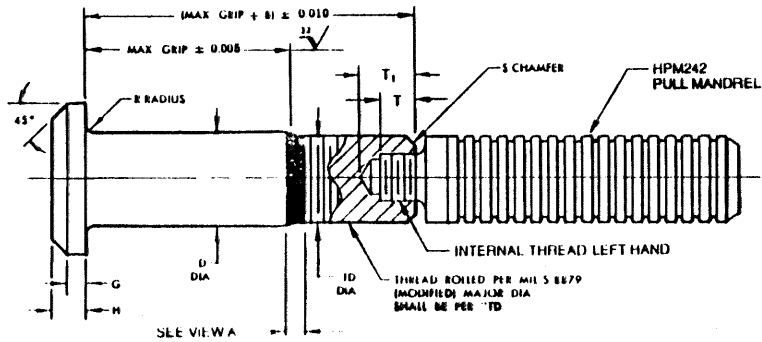


**hi-shear**  
CORPORATION

2600 Skypark Drive  
Torrance, California 90509 U.S.A.  
Telephone (310) 326-8110  
FAX (310) 784-4144



INDENTED HEAD MARKING MAXIMUM DEPTH .010".  
"hi" INDICATES HI-SHEAR TRADEMARK. THE  
NUMBER(S) FOLLOWING THE TRADEMARK INDICATE  
FIRST DASH NUMBER. ARRANGEMENT OPTIONAL.

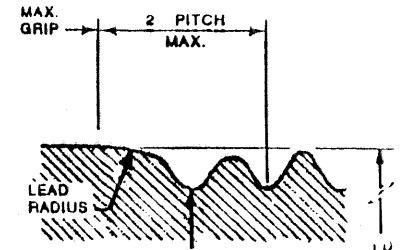


HI-LITE® ST™ PIN

HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	G REF.	H	R RAD.	S CHAMFER REF.	THREAD	INTERNAL THREAD LEFT HAND			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											T MIN	T, MAX	THREAD SIZE		
18	9/16	.877 .842	.770	.5615 .5605	.5550 .5500	.115	.210 .200	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.280	.456	.312-24UNJF-2B	62,100	43,500
20	5/8	.953 .905	.825	.8240 .8230	.8180 .8120	.130	.238 .228	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.280	.456	.312-24UNJF-2B	76,700	54,600

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.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
5. Lead radius must be tangent to "D" diameter at max grip.
6. Use HPL832 for oversize replacement.

**CODE:**

First dash number indicates nominal diameter in 1/32nds.  
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.

**MATERIAL:**

Nickel Base Alloy per AMS5662.

**HEAT TREAT:**

125,000 psi shear minimum.

**FINISH:**

HPL822DL(-) = Kalgard FA or EM620C solid film lube per MIL-L-46010, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.  
HPL822AG(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color code orange on the thread end and cetyl alcohol lube per Hi-Shear Spec. 305.  
HPL822AP(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

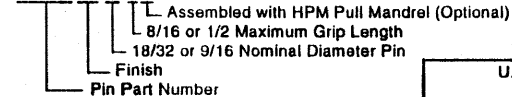
**SPECIFICATION:**

Hi-Lite Product Specification 391.

**HOW TO ORDER EXAMPLES:**

Pin Part Number Only

HPL822DL 18-8A



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 J.F. Obispo 8-8-95	TITLE <b>HI-LITE® ST™ PIN</b> PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) SPECIAL THREAD 1/16" GRIP VARIATION
APPROVED DATE J. Rausch 8-9-95	
REVISION DATE ③ J.R.H. 2-17-99	DRAWING NUMBER <b>HPL822</b>

HPL822

STDNPL