



UNDELETED HEAD MARKING MAXIMUM DEPTH .010".
78 INDICATES HI-SHEAR TRADEMARK. THE
NUMBERS FOLLOWING THE TRADEMARK INDICATE
FIRST DASH NUMBER. ARRANGEMENT OPTIONAL.

HI-LITE® ST™ PIN

HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	A DIA.	B REF. DIA.	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		
18	.877 .842	.770	.5771	.5650 .5500	.125	.210 .200	.040 .025	1/16" x 37°	9/16-18UNJF-3A Modified	.280	.456	15,100	65,600 43,500
20	.953 .905	.825	.6386	.6180 .6120	.140 .228	.230 .228	.040 .025	1/16" x 37°	5/8-18UNJF-3A Modified	.280	.456	15,100	80,600 54,600
24	1.150 1.110	1.050	.7646 .7370	.7430 .7370	.200 .320	.335 .320	.045 .030	1/16" x 37°	3/4-16UNJF-3A Modified	.305	.480	23,500	115,000 79,200
28	1.320 1.290	1.210	.8996 .8986	.8660 .8610	.250 .370	.395 .370	.050 .035	5/64" x 37°	7/8-14UNJF-3A Modified	.325	.500	23,500	156,000 117,000
32	1.510 1.470	1.390	1.0146 1.0136	.9930 .9860	.300 .420	.435 .420	.060 .045	5/64" x 37°	1-12UNJF-3A Modified	.380	.575	23,500	202,000 143,000

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

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS



VIEW A

HI-LITE THREAD TRANSITION AREA. SEE SPECIFICATION FOR INSPECTION.

First dash number indicates nominal diameter in 1/32nds of the pin which HPL832 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.

CODE:

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 HPL842 for oversize replacement.
7. The maximum allowable installation load must not exceed the maximum load value in table on threads failure may occur.

HOW TO ORDER EXAMPLES:

- Nickel Base Alloy per AMS6662.
125,000 psi shear minimum.
HPL832DL(-)(-) = Kalgard FA or EM620C solid film lube AS5272
Type I and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL832AG(-)(-) = 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.
HPL832AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

MATERIAL:

Nickel Base Alloy per AMS6662.

HEAT TREAT:

125,000 psi shear minimum.

FINISH:

- HPL832DL(-)(-) = Kalgard FA or EM620C solid film lube AS5272
Type I and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL832AG(-)(-) = 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.
HPL832AP(-)(-) = 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.

Pin Part Number Only

HPL832DL 18-8A

Assembled with HPM Pull Mandrel (Optional)

18/32 or 9/16 Nominal Diameter Pin

Finish

Pin Part Number

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.	DATE 8-8-95	DATE 9-24-96	DATE 4-20-99
DRAWN J.F. Obispo	DATE 8-8-95	DATE 9-24-96	DATE 4-20-99
APPROVED J. Rausch	DATE 9-24-96	DATE 9-24-96	DATE 4-20-99
REVISION ③	DATE 4-20-99	DATE 4-20-99	DATE 4-20-99
TITLE HI-LITE® ST™ PIN		DRAWING NUMBER HPL832	
PROTRUDING TENSION HEAD		NICKEL BASE ALLOY (INCONEL 718)	
SPECIAL THREAD		1/16" GRIP VARIATION, 1/64" OVERSIZE	