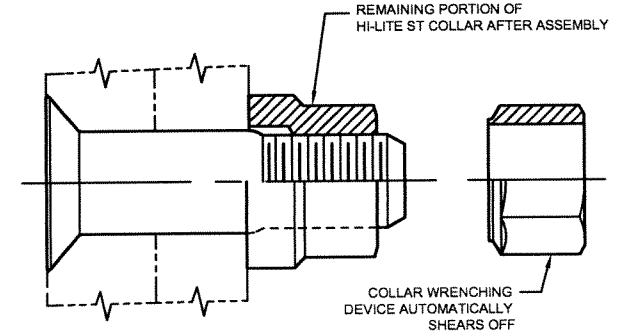
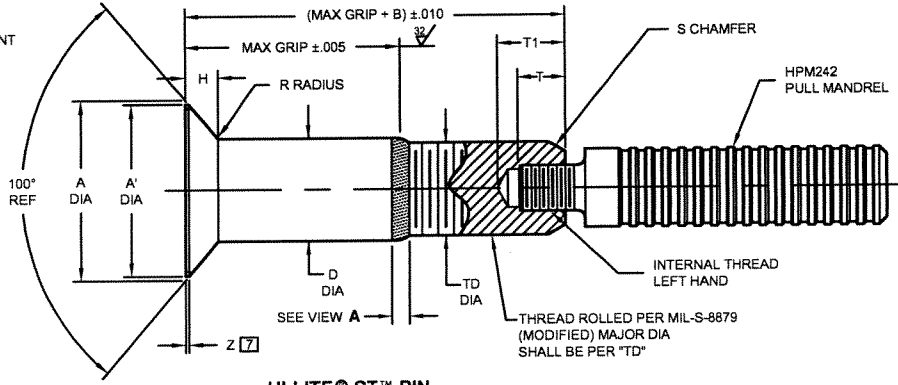
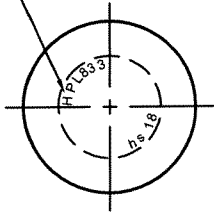


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER. ARRANGEMENT
OPTIONAL.

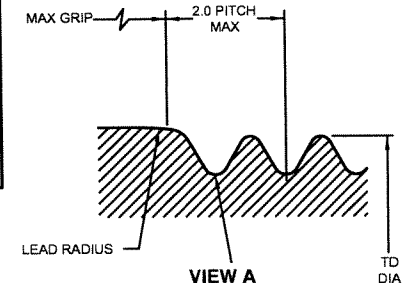


HI-LITE® ST™ PIN

HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	A1 DIA	B REF	D DIA	TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD	INTERNAL THREAD LEFT HAND		DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	
													T MIN	T1 MAX			THREAD SIZE
18	37/64	1.1408 1.1337	1.133 1.085	.770	.5771 .5766	.5550 .5500	.010	.2365 .2335	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.280	.456	.312-24UNJF-2B	65,600	43,500
20	41/64	1.2723 1.2651	1.265 1.217	.825	.6396 .6391	.6180 .6120	.010	.2654 .2624	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.280	.456	.312-24UNJF-2B	80,600	54,600

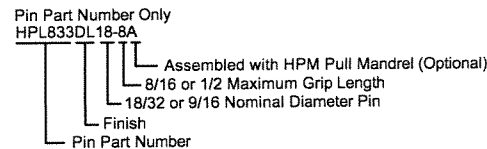
SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.



- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Hole preparation per NAS618.
 - Dimensions to be met after finish.
 - Surface texture per ANSI B46.1.
 - Curved or flat edge manufacturer's option.
 - Lead radius must be tangent to "D" diameter at maximum grip.
 - Use HPL843 for oversize replacement.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HPL833 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 EXAMPLE:



MATERIAL: Nickel Base Alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HPL833AP(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL833AG(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL833DL(-) = Kalgard FA or EM620C solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 391.

U.S. Patents 4,326,825; 4,485,510 and 4,957,401.
Other U.S. and international patents pending.
"Hi-Lite" and "HST" are registered trademarks and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.

DRAWN		DATE		TITLE	
J.F.O.		4-17-96		HI-LITE® ST™ PIN	
APPROVED		DATE		100° FLUSH (MS24694) TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) SPECIAL THREAD	
J.Rausch		4-22-96		1/16" GRIP VARIATION, 1/64" OVERSIZE	
REVISION		DATE		DRAWING NUMBER	
1		J.F.Obispo	10-16-01	HPL833	