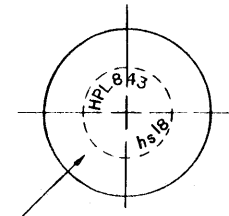
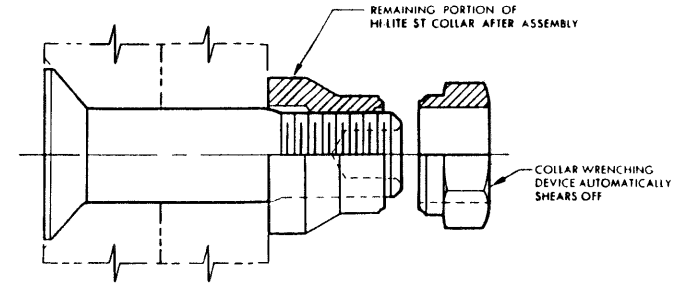
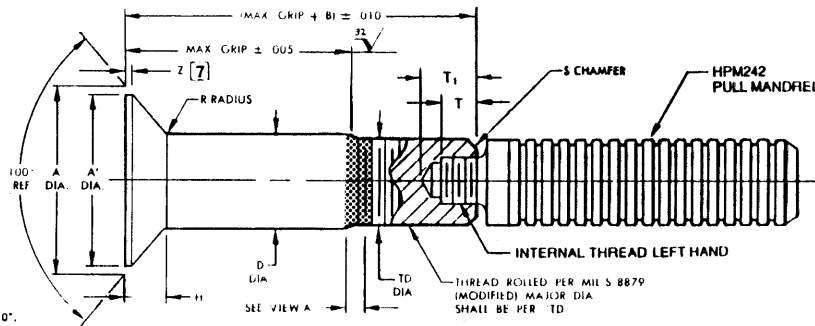


**hi-shear**  
CORPORATION

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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.	A' 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 MAX	T <sub>1</sub> MAX	THREAD SIZE		
18	37/64	1.1408 1.1337	1.133 1.085	.770	.5927 .5917	.5550 .5500	.010	.2300 .2270	.050 .040	.025	1/16" x 45°	9/16-18UNJF-3A Modified	.300	.456	.312-24UNJF-2B	69,200	43,500
20	41/64	1.2723 1.2651	1.265 1.217	.825	.6552 .6542	.6180 .6120	.010	.2589 .2559	.050 .040	.025	1/16" x 45°	5/8-18UNJF-3A Modified	.300	.456	.312-24UNJF-2B	84,500	54,600

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

**GENERAL NOTES:**

- 1 Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
3. "H" is dimensioned from maximum "D" diameter.
4. Dimensions to be met after finish.
5. Surface texture per ANSI B46.1.
6. Hole preparation per NAS618.
- 7 Curved or flat edge manufacturer's option.
8. Lead radius must be tangent to "D" diameter at maximum grip.
9. Oversize pin for HPL823 and HPL833.

**CODE:**

First dash number indicates nominal diameter in 1/32nds of the pin which HPL843 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:**

Pin Part Number Only  
HPL843DL 18-8A  
    └─ Assembled with HPM Pull Mandrel (Optional)  
    └─ 8/16 or 1/2 Maximum Grip Length  
    └─ Replaces 18/32 or 9/16 Nominal Diameter Pin  
    └─ Finish  
    └─ Pin Part Number

**MATERIAL:**

Nickel Base Alloy per AMS5662.

**HEAT TREAT:**

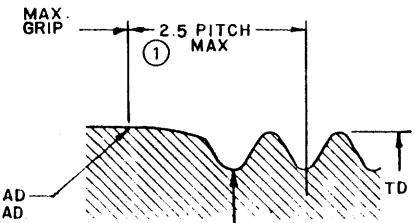
125,000 psi shear minimum.

**FINISH:**

HPL843DL (-)(-) = Kalgard FA or EM620C solid film lube per MIL-L-46010, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.  
HPL843AG (-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color code orange on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.  
HPL843AP (-)(-) = 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.



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 4-17-96		TITLE <b>HI-LITE® ST™ PIN</b> 100° FLUSH (MS24694) TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) SPECIAL THREAD 1/16" GRIP VARIATION, 1/32 OVERSIZE	
APPROVED DATE <i>J. Obispo</i> 4/24/96		DRAWING NUMBER <b>HPL843</b>	
REVISION DATE ① J.F. Obispo 12-5-96		DRAWING NUMBER	

HPL843