

HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

TABLE 1

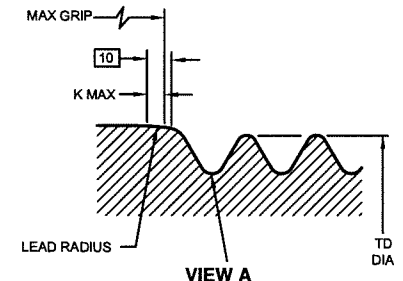
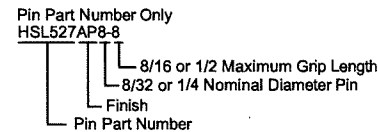
FIRST DASH NO.	PIN NOM DIA	A DIA	A1 DIA	B REF	D DIA BEFORE FINISH	F	TD DIA	H	K MAX	M DIA FLAT	R RAD	Z MAX	S CHAMFER REF	THREAD	DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
5	5/32	.2612 .2564	.254 .242	.312	.1640 .1635	.004	.1595 .1570	.0410 .0390	.013	.140 .120	.025 .015	.010	1/32" x 37°	8-32UNJF-3A Modified	4,600 4,010	1,650
6	3/16	.3016 .2966	.294 .282	.325	.1895 .1890	.005	.1840 .1810	.0470 .0450	.016	.155 .135	.030 .020	.015	1/32" x 37°	10-32UNJF-3A Modified	6,200 5,380	2,000
8	1/4	.3948 .3898	.387 .375	.395	.2495 .2490	.006	.2440 .2410	.0610 .0590	.021	.200 .180	.030 .020	.015	1/32" x 37°	1/4-28UNJF-3A Modified	10,600 9,300	3,700
10	5/16	.4739 .4689	.466 .454	.500	.3120 .3115	.007	.3060 .3020	.0680 .0660	.026	.265 .245	.040 .030	.015	3/64" x 37°	5/16-24UNJF-3A Modified	16,600 14,600	5,000
12	3/8	.5604 .5554	.553 .541	.545	.3745 .3740	.008	.3680 .3640	.0780 .0760	.030	.325 .300	.040 .030	.015	3/64" x 37°	3/8-24UNJF-3A Modified	23,900 21,000	7,200
14	7/16	.6680 .6620	.660 .636	.635	.4370 .4365	.009	.4310 .4260	.0969 .0944	.035	.380 .355	.050 .040	.022	3/64" x 37°	7/16-20UNJF-3A Modified	32,500 28,600	10,000
16	1/2	.7540 .7480	.746 .722	.685	.4995 .4990	.010	.4930 .4880	.1068 .1043	.039	.445 .415	.050 .040	.022	3/64" x 37°	1/2-20UNJF-3A Modified	42,400 37,300	13,500

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.
 - Dimensions to be met after finish, except as noted.
 - Surface texture per ANSI B46.1.
 - Hole preparation per NAS618.
 - Flat permissible within "M" diameter.
 - Curved or flat edge manufacturer's option.
 - "D" diameter may increase by .0005" after application of solid film lube and .001" after application of aluminum coating.
 - Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
 - Use HSL627 for oversize replacement.
 - Shorter or longer grips than those listed may be available as specials.

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.

HOW TO ORDER EXAMPLE:



HI-LITE THREAD TRANSITION AREA. THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS. SEE SPECIFICATION FOR INSPECTION.

- MATERIAL:** 6AL-4V titanium alloy per AMS4928 or AMS4967.
- HEAT TREAT:** 95,000 psi shear minimum.
- FINISH:** HSL527DL(-) = Kalgard FA or EM620C solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HSL527AP(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- SPECIFICATION:** Hi-Lite Product Specification 380-2.

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 J.F.Obispo	DATE 11-27-91	TITLE HI-LITE® ST™ PIN 100° FLUSH SHEAR CROWN HEAD BREAK STEM, SPECIAL THREAD TITANIUM 1/16" GRIP VARIATION
APPROVED DAW	DATE 12-9-91	DRAWING NUMBER HSL527
REVISION 5	DATE JFO 9-2-08	Sheet 1 of 2

TABLE 2

SECOND DASH NUMBER	L (REF) 12						
	-5 DIA.	-6 DIA.	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.
1	-	-	-	-	-	-	-
2	.835	.955	.940	-	-	-	-
3	.960	1.080	1.065	1.185	-	-	-
4	1.085	1.205	1.190	1.310	1.300	-	-
5	1.210	1.330	1.315	1.435	1.425	1.530	-
6	1.335	1.455	1.440	1.560	1.550	1.655	1.645
7	1.460	1.580	1.565	1.685	1.675	1.780	1.770
8	1.585	1.705	1.690	1.810	1.800	1.905	1.895
9	1.710	1.830	1.815	1.935	1.925	2.030	2.020
10	1.835	1.955	1.940	2.060	2.050	2.155	2.145
11	1.960	2.080	2.065	2.185	2.175	2.280	2.270
12	2.085	2.205	2.190	2.310	2.300	2.405	2.395
13	2.210	2.330	2.315	2.435	2.425	2.530	2.520
14	2.335	2.455	2.440	2.560	2.550	2.655	2.645
15	2.460	2.580	2.565	2.685	2.675	2.780	2.770
16	2.585	2.705	2.690	2.810	2.800	2.905	2.895
17	2.710	2.830	2.815	2.935	2.925	3.030	3.020
18	2.835	2.955	2.940	3.060	3.050	3.155	3.145
19	2.960	3.080	3.065	3.185	3.175	3.280	3.270
20	3.085	3.205	3.190	3.310	3.300	3.405	3.395
21	-	3.330	3.315	3.435	3.425	3.530	3.520
22	-	3.455	3.440	3.560	3.550	3.655	3.645
23	-	3.580	3.565	3.685	3.675	3.780	3.770
24	-	3.705	3.690	3.810	3.800	3.905	3.895
25	-	-	-	3.935	3.925	4.030	4.020
26	-	-	-	4.060	4.050	4.155	4.145
27	-	-	-	4.185	4.175	4.280	4.270
28	-	-	-	4.310	4.300	4.405	4.395
29	-	-	-	-	-	4.530	4.520
30	-	-	-	-	-	4.655	4.645
31	-	-	-	-	-	4.780	4.770
32	-	-	-	-	-	4.905	4.895

HSL527

DRAWING NUMBER
HSL527