

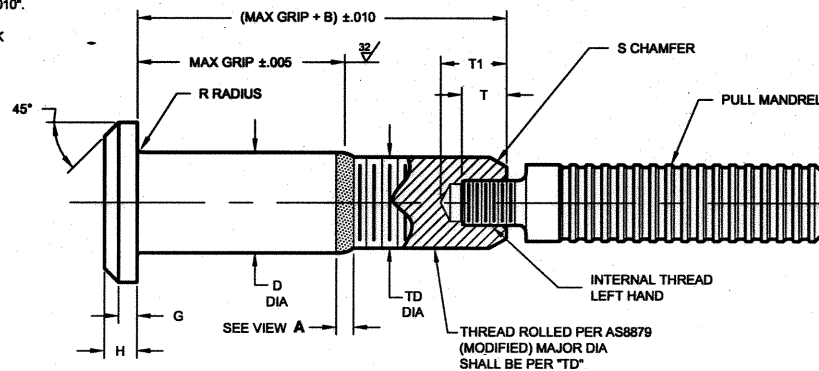
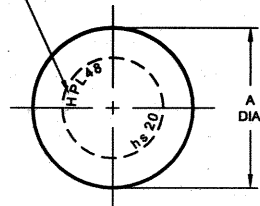
hi-shear
CORPORATION

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

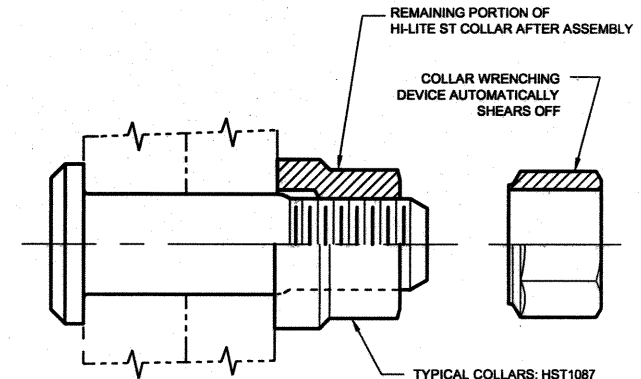
HI-SHEAR CORPORATION, U.S.A. (Patent Holder) CAGE No. 73197
a LISI AEROSPACE Company
BLANC AERO INDUSTRIES, FRANCE (Licensee-ECC Countries)
a LISI AEROSPACE Company

BLANC AERO INDUSTRIES, U.K. (Licensee) CAGE No. 0LB68
a LISI AEROSPACE Company
SPS TECHNOLOGIES, U.S.A. (Licensee) CAGE No. 56878

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



HI-LITE ST PIN



HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD ROLLED	S CHAMFER REF	THREAD	INTERNAL THREAD LEFT HAND		LOAD MAX	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT COATING	WITH COATING							T MIN	T1			
18	9/16	.877 .842	.770	.5615 .5610	.5615 .5605	.5550	.125	.210 .200	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.240	.340 .320	1/4-28UNJF-2B	9,450	47,200
20	5/8	.953 .918	.825	.6240 .6235	.6240 .6230	.6180	.140	.238 .228	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.240	.340 .320	1/4-28UNJF-2B	9,450	58,300
24	3/4	1.150 1.110	1.050	.7490 .7485	.7490 .7480	.7430	.200	.335 .320	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.260	.385 .365	3/8-24UNJF-2B	14,175	83,900
28	7/8	1.330 1.290	1.210	.8740 .8735	.8740 .8730	.8680	.250	.385 .370	.050 .035	5/64" x 45°	7/8-14UNJF-3A Modified	.370	.500 .480	3/8-24UNJF-2B	21,600	114,000

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions in inches and to be met after finish.
3. Surface texture per ANSI B46.1.
4. Hole preparation per NAS618.
5. The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.

MATERIAL: A-286 high temperature alloy per AMS5737 or AMS5731.

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum) at 70°F.

FINISH: HPL48-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL48AP()-() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL48AG()-() = 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.
HPL48EC()-() = Solid film lube Dicronite DL-5 per DOD-L-85645A, Type I. (For LOX compatibility coating).
HPL48ES()-() = Solid film lube Tiodize Tiotube 1175 per AS1701, Class VI. (For LOX compatibility coating).

SPECIFICATION: Hi-Lite Product Specification 380-2.

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.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HPL48AP18-8A
Assembled with HPM Pull Mandrel (Optional)
8/16 or 1/2 Maximum Grip Length
18/32 or 9/16 Nominal Diameter Pin
Finish
Pin Part Number

Pin and Collar Assembly Part Number Combination
HPL48AP1087-18-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

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.
THIS AREA OF SPECIAL CONFIGURATION.

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.		TITLE HI-LITE® ST™ PIN PROTRUDING TENSION HEAD A-286 HIGH TEMPERATURE ALLOY (SPECIAL THREAD) 1/16" GRIP VARIATION	
DRAWN J. Obispo	DATE 9-6-05	REVISION 2	
APPROVED L. Nguyen	DATE 9-14-05	DRAWING NUMBER HPL48	