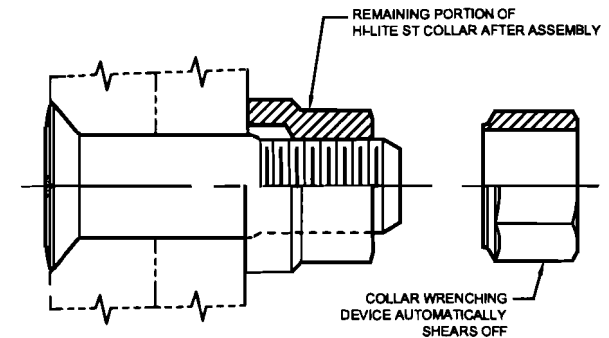
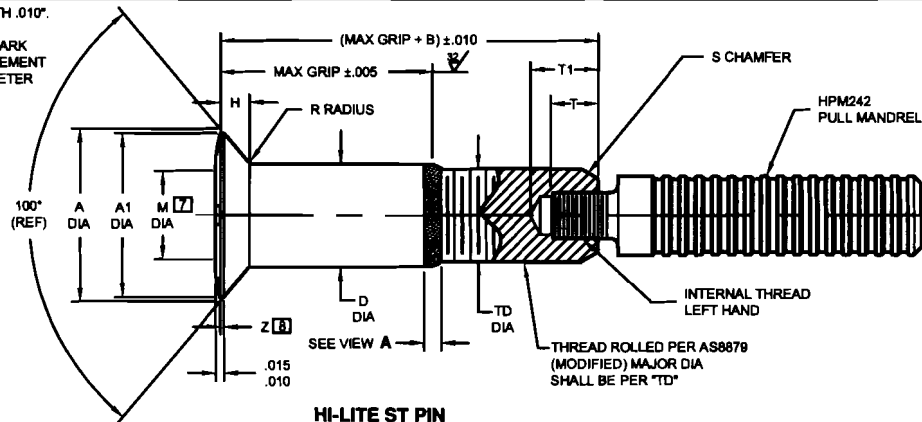
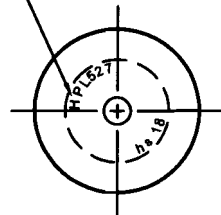


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER, ARRANGEMENT
OPTIONAL. INDENTATION IS .050-.060 DIAMETER
x .020-.030 DEPTH.



HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

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

FIRST DASH NO.	PIN NOM DIA	A DIA	A1 DIA	B REF	D DIA WITHOUT COATING OR SOLID FILM	TD DIA	F	H	K MAX	M DIA FLAT	R RAD	Z MAX	S CHAMFER REF	THREAD	INTERNAL THREAD LEFT HAND ③			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
															T MIN	T1 MAX	THREAD SIZE		
18	9/16	.8380 .8310	.830 .806	.770	.5615 .5610	.5550 .5500	.010	.1160 .1131	.039	.505 .475	.050 .040	.022	1/16" x 37"	9/16-18UNJF-3A Modified	.280	.456	.312-24UNJF-3B	53,700 47,200	17,000
20	5/8	.9250 .9180	.917 .893	.825	.6240 .6235	.6180 .6120	.010	.1260 .1230	.044	.565 .535	.050 .040	.022	1/16" x 37"	5/8-18UNJF-3A Modified	.280	.456	.312-24UNJF-3B	66,300 58,300	21,000

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, except as noted.
- Surface texture per ANSI B46.1.
- Flat permissible within "M" diameter.
- Curved or flat edge manufacturer's option.
- Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
- Use HPL629 for oversize replacement.
- "D" diameter may increase by .0005 after application of solid film lube.

MATERIAL: 6AL-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HPL527AP() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL527DL() = Kalgard FA or EM620C solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.

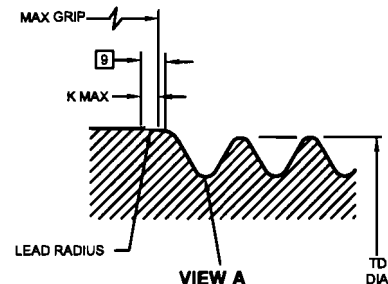
SPECIFICATION: Hi-Lite Product Specification 391.

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 mandrell.

**HOW TO ORDER
EXAMPLE:**

Pin Part Number Only
HPL527DL18-8A
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



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

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.O.	DATE 12-12-91
APPROVED DAW	DATE 12-19-91
REVISION 3	DATE J.F. Obispo 3-3-14
TITLE HI-LITE® ST™ PIN 100° FLUSH SHEAR CROWN HEAD TITANIUM, SPECIAL THREAD 1/16 GRIP VARIATION DRAWING NUMBER HPL527	