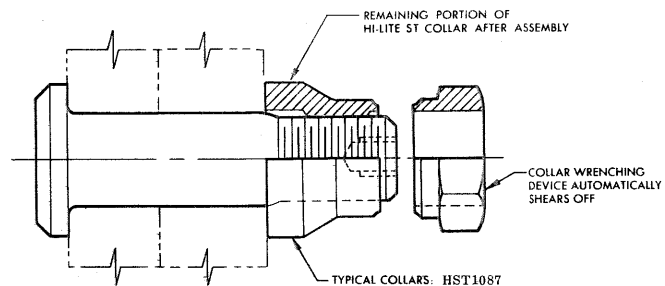
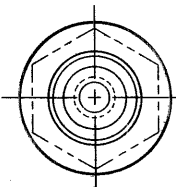
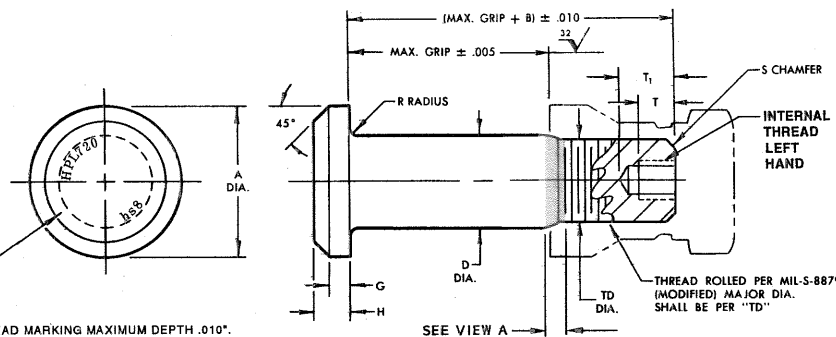


hi-shear
CORPORATION

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HI-LITE® ST™ PIN

HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA.	B REF.	D DIA.	TD DIA.	G REF.	H	R RAD. COLD WORKED	S CHAMFER REF.	THREAD	INTERNAL THREAD LEFT HAND		LOAD MAX.	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											T MIN.	T ₁			
18	9/16	.877 .842	.600	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16" x 45°	9/16-18UNJF-3A Modified	.240	.340 .320	1/4-28UNJF-2B	9,450	53,700
20	5/8	.953 .918	.640	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16" x 45°	5/8-18UNJF-3A Modified	.240	.340 .320	1/4-28UNJF-2B	9,450	66,300
24	3/4	1.150 1.110	.895	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16" x 45°	3/4-16UNJF-3A Modified	.260	.385 .365	3/8-24UNJF-2B	14,175	95,400
28	7/8	1.330 1.290	1.000	.8740 .8730	.8680 .8610	.250	.385 .370	.050 .035	5/64" x 45°	7/8-14UNJF-3A Modified	.380	.500 .480	3/8-24UNJF-2B	21,600	129,000
32	1	1.510 1.470	1.160	.9990 .9980	.9930 .9860	.300	.435 .420	.060 .045	5/64" x 45°	1-12UNJF-3A Modified	.450	.575 .555	3/8-24UNJF-2B	21,600	168,500
36	1-1/8	1.695 1.655	1.305	1.1240 1.1230	1.1170 1.1100	.350	.490 .475	.070 .055	5/64" x 45°	1-1/8-12UNJF-3A Modified	.450	.575 .555	3/8-24UNJF-2B	21,600	214,000

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.
SEE SPECIFICATION FOR INSPECTION.

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIR.
- Dimensions in inches and to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.

- 5 The maximum allowable installation load must not exceed the maximum load values in table or thread failure may occur.

MATERIAL:

Alloy steel per MIL-S-5000, MIL-S-5626 or MIL-S-6049.

HEAT TREAT:

180,000-200,000 psi tensile per MIL-H-6875.

FINISH:

HPL720-(-)(-) = Cadmium plate per QQ-P-416, Type II, Class 2, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL720BJ-(-)(-) = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL720BL-(-)(-) = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL720CG-(-)(-) = Cadmium plate per QQ-P-416, Type II, Class 2, with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

Hi-Lite Product Specification 391, except as noted.

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 EXAMPLES:

Pin Part Number Only
HPL720BJ-18-8
└ 8/16 or 1/2 Maximum Grip Length
└ 18/32 or 9/16 Nominal Diameter Pin
└ Finish
└ Pin Part Number

HOW TO ORDER EXAMPLES:

Pin and Collar Assembly Part Number Combination
HPL720BJ1087-18-8
└ Size and Grip Length, See Above Example
└ Collar Part Number
└ Pin Part Number

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 D.P.S 11-20-91	TITLE HI-LITE® ST™ PIN PROTRUDING TENSION HEAD ALLOY STEEL 1/16" GRIP VARIATION
APPROVED DATE DAW 11-21-91	
REVISION DATE ③ J.F.Obispo 10-10-95	DRAWING NUMBER HPL720

HPL720