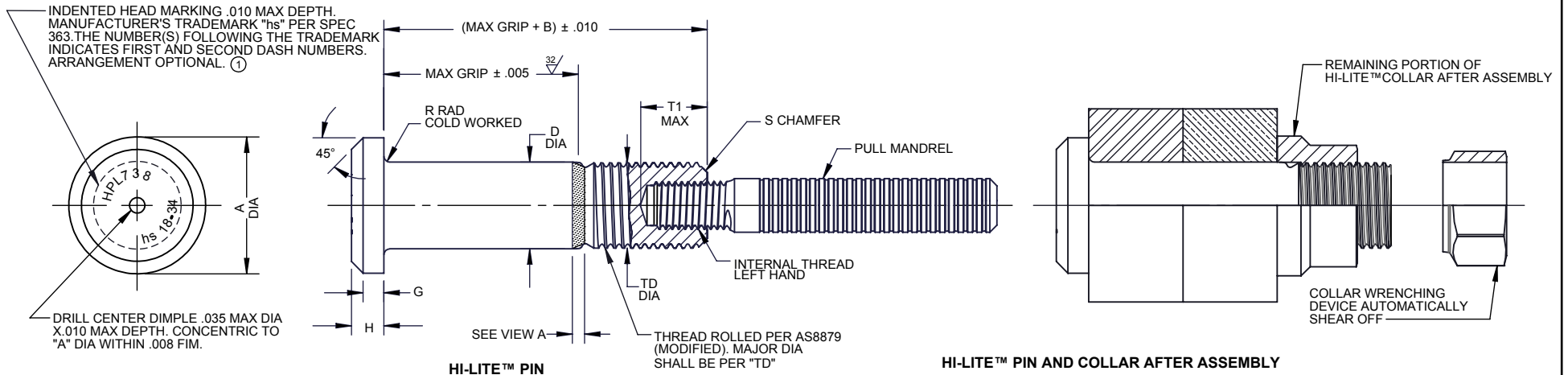




FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-FATIGUE POUNDS
											T1 MAX	THREAD SIZE UNJF-2B	LOAD MAX			
18	9/16	.877 .842	.844	.5615 .5605	.5537 .5500	.125	.210 .200	.040 .025	1/16" x 45°	.5625-18 UNJF-3A	.465	5/16-SP	11,500	62,100	35,400	13,100
20	5/8	.953 .918	.935	.6240 .6230	.6165 .6120	.140	.238 .228	.040 .025	1/16" x 45°	.6250-18 UNJF-3A	.520	3/8-SP	14,200	76,700	44,800	16,600
24	3/4	1.150 1.110	1.125	.7490 .7480	.7415 .7370	.200	.335 .320	.045 .030	1/16" x 45°	.7500-16 UNJF-3A	.625	7/16-SP	19,100	110,400	75,500	27,900
28	7/8	1.330 1.290	1.315	.8740 .8730	.8663 .8610	.250	.385 .370	.050 .035	5/64" x 45°	.8750-14 UNJF-3A	.725	1/2-SP	31,500	149,300	101,800	37,700
32	1	1.510 1.470	1.500	.9990 .9980	.9913 .9860	.300	.435 .420	.060 .045	5/64" x 45°	1.0000-12 UNJF-3A	.830	9/16-SP	38,200	195,000	132,100	48,900

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.

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions in inches and to be met after finish.
 - ① 3. Surface texture per ASME 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.
 6. Use HPL838 for oversize replacement.

MATERIAL: Nickel Base Alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HPL738BP(-)(-) = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, with color blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 391, except fatigue loads as tabulated.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin
 Second dash number indicates maximum grip in 1/16ths.
 See "Finish" note for explanation of code letters.

HOW TO ORDER
 ① **EXAMPLE:**

Pin Part Number
 HPL738BP18-34
 —————
 ————— 34/16 or 17/8 Maximum Grip Length
 ————— 18/32 or 9/16 Nominal Diameter Pin
 ————— Finish Code
 ————— Pin Basic Part Number

"HI-LITE", "HPL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION	
DRAWN BY J.F. OBISPO	DATE 2004-03-15
APPROVED M. CAWLEY	DATE 2004-03-15
REVISION ①	DATE 2017-12-11
TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) SPECIAL THREAD, 1/16 GRIP VARIATION SPECIAL HIGH INTERFERENCE FIT DRAWING NUMBER HPL738	