

FIRST DASH NO.	PIN NOM DIA	A DIA	A' A4 DIA	B REF	D DIA	TD DIA	F	H REF	M GAGE PROT.	R RAD ROLLED	V GAGE DIA	Z MAX	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND (8)				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS
															T MIN	T1 MAX	THREAD SIZE	LOAD MAX			
18	9/16	.9300	.881	.600	.5615 .5605	.5550 .5500	.010	.153	.0533 .0485	.050 .040	.8012 .8010	.022	1/16" x 37°	.5625-18 UNJF-3A	.240	.340 .320	1/4-28UNJF-2B	9,450	47,200	22,500	7,875
20	5/8	1.0440	.995	.640	.6240 .6230	.6180 .6120	.010	.174	.0633 .0589	.050 .040	.8902 .8900	.022	1/16" x 37°	.6250-18 UNJF-3A	.240	.340 .320	1/4-28UNJF-2B	9,450	58,300	29,200	10,200
24	3/4	1.3000	1.251	.895	.7490 .7480	.7430 .7370	.012	.229	.0776 .0716	.050 .040	1.1124 1.1122	.022	1/16" x 37°	.7500-16 UNJF-3A	.260	.385 .365	3/8-24UNJF-2B	14,175	83,900	46,000	16,100
28	7/8	1.5091	1.461	1.000	.8740 .8730	.8680 .8610	.014	.263	.0694 .0622	.050 .040	1.3440 1.3438	.022	5/64" x 37°	.8750-14 UNJF-3A	.380	.500 .480	3/8-24UNJF-2B	21,600	107,000	55,000	19,250
32	1	1.7201	1.671	1.160	.9990 .9980	.9930 .9860	.014	.298	.0617 .0536	.050 .040	1.5732 1.5730	.022	5/64" x 37°	1.0000-12 UNJF-3A	.450	.575 .555	3/8-24UNJF-2B	21,600	140,000	71,000	24,850
36	1-1/8	1.9350	1.887	1.305	1.1240 1.1230	1.1170 1.1100	.015	.340	.0560 .0475	.060 .050	1.8026 1.8024	.022	5/64" x 37°	1.1250-12 UNJF-3A	.450	.575 .555	3/8-24UNJF-2B	21,600	178,000	91,000	31,850

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.
  - Hole preparation per NAS618.
  - Dimensions in inches and to be met after finish.
  - Surface texture per ASME B46.1.
  - Curved or flat edge manufacture's option.
  - The maximum allowable installation load must not exceed the maximum load values in table or thread failure may occur.
  - Use HPL855 for oversize replacement.
  - After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

**MATERIAL:** 6AL-4V titanium alloy per AMS4928, AMS4967 or British Standard 2TA 28.

**HEAT TREAT:** 95,000 psi shear minimum for sizes up to 3/4.  
90,000 psi shear minimum for 7/8 and larger.

**FINISH:** (9) (10) HPL755KM(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

(9) (10) HPL755AP(-) = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, 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 of the pin  
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

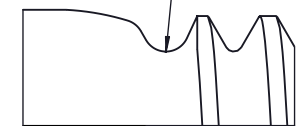
##### (9) EXAMPLE:

Pin Part Number  
HPL755KM18-8A  
Assembled with HPM Pull mandrel (Optional)  
8/16 or 1/2 Maximum Grip Length  
18/32 or 9/16 Nominal Diameter Pin  
Finish Code  
Pin Basic Part Number

Pin and Collar Assembly Part Number Combination  
HPL755KM79-18-8

Size and Grip Length,  
See Above Example  
Collar Part Number  
Pin Part Number

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS



VIEW A

HI-LITE™ THREAD TRANSITION AREA  
SEE SPECIFICATION FOR INSPECTION

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F.O	DATE 1991-11-08	TITLE HI-LITE™ PIN 100° FLUSH SPECIAL SHEAR HEAD TITANIUM 1/16 GRIP VARIATION	
APPROVED DAW	DATE 1991-11-10	DRAWING NUMBER <b>HPL755</b>	
REVISION (9)	DATE K. TRAN 2017-12-11	1 OF 1	