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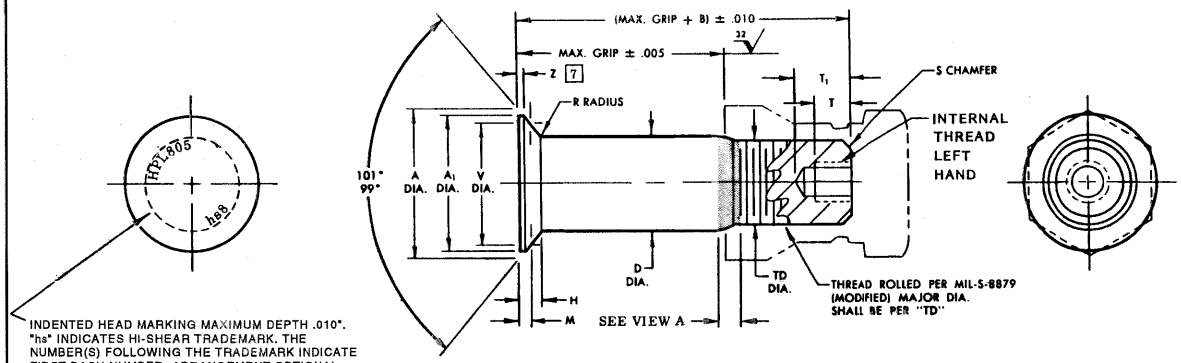
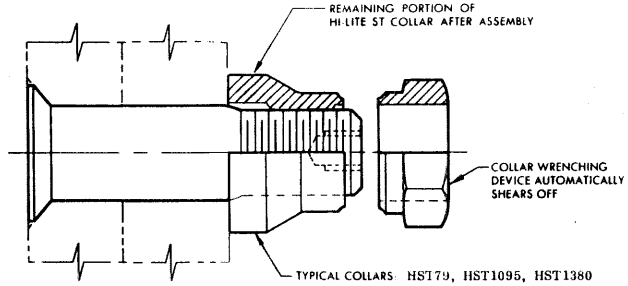


HI-LITE® ST™ PIN



HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA. MAX.	A' DIA. MIN.	B REF.	D DIA.	TD DIA.	[1] F	H REF.	M GAGE PROT.	R RAD. COLD WORKED	V GAGE DIA.	[7] Z MAX.	S CHAMFER REF.	THREAD	INTERNAL THREAD LEFT HAND [8] T MIN.	T_1	THREAD SIZE	LOAD MAX.	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS MAXIMUM
18	9/16	.9300	.881	.610	.5771 .5761	.5550 .5500	.010	.147	.0533 .0485	.050 .040	.8012 .8010	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.240	.340 .320	1/4-28UNJF-2B	9,450	56,500	24,600	8,600
20	5/8	1.0440	.995	.650	.6396 .6386	.6180 .6120	.010	.168	.0633 .0589	.050 .040	.8902 .8900	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.240	.340 .320	1/4-28UNJF-2B	9,450	69,300	31,000	10,850
24	3/4	1.3000	1.251	.905	.7646 .7636	.7430 .7370	.012	.222	.0776 .0716	.050 .040	1.1124 1.1122	.022	1/16" x 45°	3/4-16UNJF-3A Modified	.260	.385 .365	3/8-24UNJF-2B	14,175	99,100	48,000	16,800
28	7/8	1.5091	1.461	1.010	.8896 .8886	.8680 .8610	.014	.257	.0694 .0622	.050 .040	1.3440 1.3438	.022	5/64" x 45°	7/8-14UNJF-3A Modified	.380	.500 .480	3/8-24UNJF-2B	21,600	134,000	65,000	22,750
32	1	1.7201	1.671	1.170	1.0146 1.0136	.9930 .9860	.014	.292	.0617 .0536	.050 .040	1.5732 1.5730	.022	5/64" x 45°	1-12UNJF-3A Modified	.450	.575 .555	3/8-24UNJF-2B	21,600	175,000	85,000	29,750

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

GENERAL NOTES:

[1] Head edge out of roundness shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
3. "H" is dimensioned from maximum "D" diameter.
4. Dimensions in inches and to be met after finish.
5. Surface texture per ANSI B46.1.
6. Hole preparation per NAS618.
[7] Curved or flat edge manufacturer's option.
[8] 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-H-6049.

HEAT TREAT: 108,000 psi shear minimum (180,000-200,000 psi tensile per MIL-H-6875).

FINISH:
HPL805-( )-( ) = Cadmium plate per QQ-P-416, Type II, Class 2, with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL805BJ( )-( ) = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL805CE( )-( ) = I.V.D. aluminum coating per MIL-C-83488, Type II (.00015-.00045 thick), with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL805CG( )-( ) = 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.

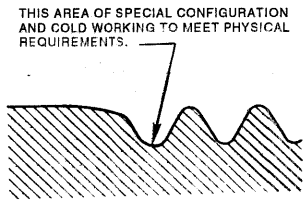
CODE: First dash number indicates nominal diameter in 1/32nds. Which HPL805 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HPL805CE-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
HPL805CE79-18-8
- Size and Grip Length, See Above Example
- Collar Part Number
- Pin Part Number



VIEW A
HI-LITE THREAD TRANSITION AREA. SEE SPECIFICATION FOR INSPECTION.

DRAWN	DATE	TITLE
JRH	12-9-97	HI-LITE® ST™ PIN 100° FLUSH SPECIAL SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION; 1/64" OVS
APPROVED	DATE	
mc	12-9-97	
REVISION	DATE	DRAWING NUMBER
		HPL805

HPL805

STD/HLPIN