

1

FIRST DASH NO.	PIN NOM DIA	A DIA	A' DIA	B REF	D DIA	TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND		DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	
													T MIN	T1 MAX			THREAD SIZE
18	9/16	1.1408	1.133	.770	.5615	.5550	.010	.2430	.050	.025	1/16 x 45°	.5625-18 UNJF-3A	.280	.456	.312-24UNJF-2B	62,100	43,500
		1.1337	1.085		.5605	.5500		.2400									
20	5/8	1.2723	1.265	.825	.6240	.6180	.010	.2720	.050	.025	1/16 x 45°	.6250-18 UNJF-3A	.280	.456	.312-24UNJF-2B	76,700	54,600
		1.2651	1.217		.6230	.6120		.2690									

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

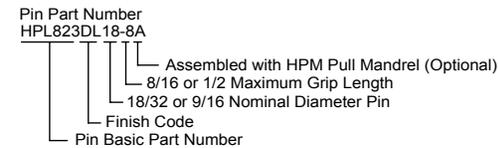
GENERAL NOTES:

- 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 are in inches and to be met after finish.
- Surface texture per ASME B46.1.
- Curved or flat edge manufacturer's option.
- Lead radius must be tangent to "D" diameter at maximum grip.
- Use HPL833 for oversize replacement.
- After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

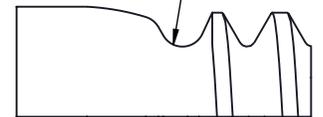
CODE:

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 mandrel.

HOW TO ORDER EXAMPLE:



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



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

MATERIAL: Nickel Base Alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HPL823AP(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL823AG(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HPL823DL(-) = 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.

"HI-KOTE", "HI-LITE", "PULL-IN" AND "HPL" ARE TRADEMARKS OF HI-SHEAR CORPORATION	
DRAWN BY J.F. OBISPO	DATE 1996-04-01
APPROVED J. RAUSCH	DATE 1996-04-02
REVISION 8	DATE F.CARINGELLA 2019-10-31
TITLE PULL-IN™ PIN 100° FLUSH (MS24694) TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) SPECIAL THREAD 1/16 GRIP VARIATION	
DRAWING NUMBER HPL823	