2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A

HI-SHEAR Corporation, USA a LISI AEROSPACE Company

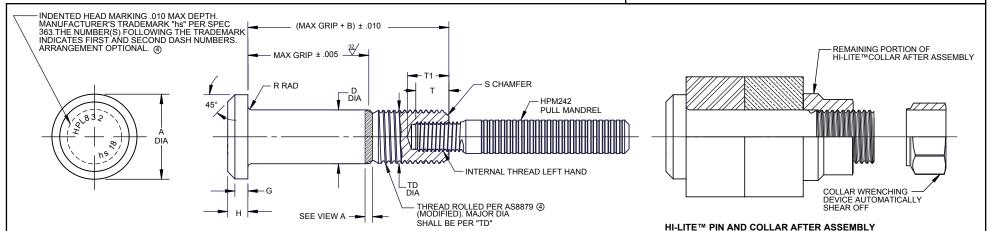
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Design Holder

CAGE No. 73197

For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:

HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



	fil-Life ··· Pin															
FIRST	PIN NOM	A DIA	B REF	D DIA	TD DIA	G REF	н	R RAD	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND			7	DOUBLE SHEAR	TENSION POUNDS
	DIA										T MIN	T1 MAX	THREAD SIZE	LOAD MAX	POUNDS MINIMUM	MINIMUM
18	37/64	.877 .842	.770	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.280	.456	.312-24UNJF-2B	15,100	65,600	43,500
20	41/64	.953 .905	.825	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.280	.456	.312-24UNJF-2B	15,100	80,600	54,600
24	49/64	1.150 1.110	1.050	.7646 .7636	.7430 .7370	.200	.335 .320	.045 030	1/16 x 45°	.7500-16 UNJF-3A	.305	.480	.375-24UNJF-2B	23,500	115,000	79,200
28	57/64	1.330 1.290	1.210	.8896 .8886	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 45°	.8750-14 UNJF-3A	.325	.500	.375-24UNJF-2B	23,500	156,000	117,000
32	1-1/64	1.510 1.470	1.390	1.0146 1.0136	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 45°	1.000-12 UNJF-3A	.380	.575	.375-24UNJF-2B	23,500	202,000	143,000

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 THIS AREA OF SPECIAL CONFIGURATION

GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within .010 FIR.

- ④ 2. Dimensions are in inches and to be met after finish.
- @ 3. Surface texture per ASME B46.1.
 - 4. Hole preparation per NAS618.
 - 5. Lead radius must be tangent to "D" diameter at max grip.
 - 6. Use HPL842 for oversize replacement.
- [7] The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.
- ④ B 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.

(4)

MATERIAL: Nickel Base Alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

(4)

FINISH: HPL832DL()-() = KALGARD FA or EM620C solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.

⊕ B HPL832AG()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per

LILITETH DIN

Hi-Shear Spec. 305.

④ B HPL832AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

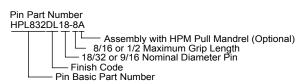
SPECIFICATION: HI-LITE™ Product Specification 391.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin

Hirst dash number indicates nominal diameter in 1/32/lus which HPL832 oversize pin replaces. 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 (4) EXAMPLE:



"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPÓRATION

DRAWN BY	DATE	TITLE
J.F.OBISPO	1995-08-08	HI-LITE™ PIN PROTRUDING TENSION HEAD
APPROVED	DATE	NICKEL BASE ALLOY (INCONEL 718)
J.RAUSCH	1996-09-24	SPECIAL THREAD 1/16 GRIP VARIATION, 1/64 OVERSIZE
REVISION	DATE	DRAWING NUMBER

F.CARINGELL 2017-12-11

HPL832

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