



HI-LITE™ PIN

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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 ⑦				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											T MIN	T1 MAX	THREAD SIZE	LOAD MAX		
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

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- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIR.
  - ④ 2. Dimensions are in inches and to be met after finish.
  - ④ 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 ⑧ 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.

**MATERIAL:** Nickel Base Alloy per AMS5662.

**HEAT TREAT:** 125,000 psi shear minimum.

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

- ④ ⑧ HPL832AG( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

- ④ ⑧ 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 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:**

Pin Part Number  
 HPL832DL18-8A

Assembly 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

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.

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F.OBISPO	DATE 1995-08-08	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) SPECIAL THREAD 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED J.RAUSCH	DATE 1996-09-24	DRAWING NUMBER <b>HPL832</b>	
REVISION ④	DATE F.CARINGELLA 2017-12-11	1 OF 1	