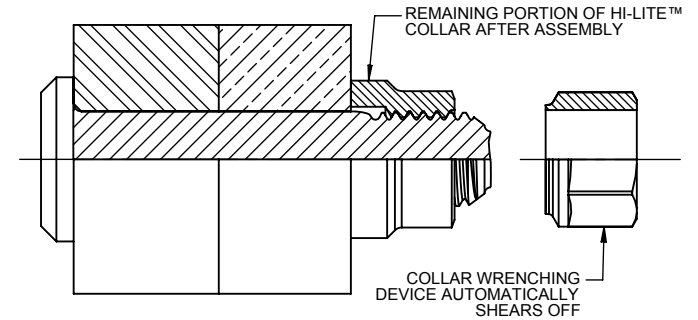
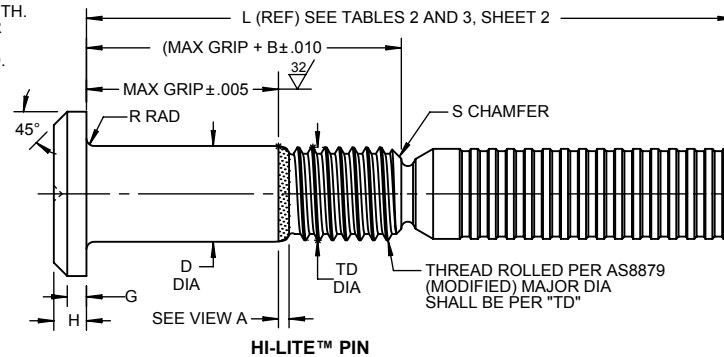
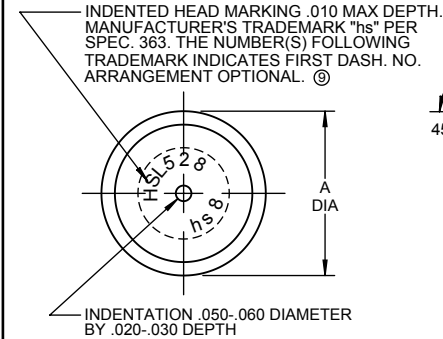




HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

⑥

TABLE 1

⑨

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA BEFORE FINISH	TD DIA	G REF	H	K MAX	R RAD	S CHAMFER REF	THREAD MODIFIED	DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
5	5/32	.322 .306	.312	.1640 .1635	.1595 .1570	.030	.065 .055	.013	.025 .015	1/32 x 37°	.1640-32 UNJF-3A	4,600 4,010	2,180
6	3/16	.377 .357	.325	.1895 .1890	.1840 .1810	.035	.074 .064	.016	.025 .015	1/32 x 37°	.1900-32 UNJF-3A	6,200 5,380	3,180
8	1/4	.440 .415	.395	.2495 .2490	.2440 .2410	.045	.090 .080	.021	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	10,600 9,300	5,820
10	5/16	.505 .472	.500	.3120 .3115	.3060 .3020	.055	.112 .102	.026	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	16,600 14,600	9,200
12	3/8	.600 .530	.545	.3745 .3740	.3680 .3640	.075	.140 .130	.030	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	23,900 21,000	14,000
14	7/16	.676 .592	.635	.4370 .4365	.4310 .4260	.095	.160 .150	.035	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	32,500 28,600	18,900
16	1/2	.770 .717	.685	.4995 .4990	.4930 .4880	.095	.188 .178	.039	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	42,400 37,300	25,500

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIM.
- Dimensions are in inches and to be met after finish, except as noted.
- Surface texture per ASME B46.1.
- Hole preparation per NAS618.
- Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
- "D" diameter may increase by .0005" after application of solid film lube and .001" after application of aluminum coating.
- Use HSL628 for oversize replacement.
- Shorter or longer grips than those listed may be available as specials.
- Pin tails for "L" coded part shall be painted with white. See Table 3, Sheet 2 for "L" dimensions.

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.
 "L" after second dash number indicates "L" reduced length, see Table 3.

HOW TO ORDER

⑨ **EXAMPLE:**

Pin Part Number
 HSL528AP8-8L

— "L" code indicates reduced length (Table 3)
 — 8/16 or 1/2 Maximum Grip Length
 — 8/32 or 1/4 Nominal Diameter Pin
 — Finish Code
 — Pin Basic Part Number

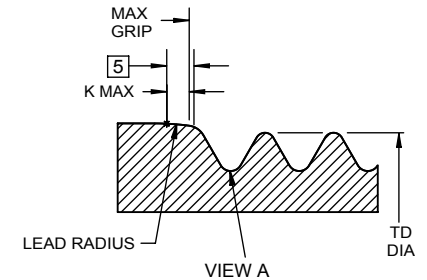
MATERIAL: 6AL-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HSL528DL()-() = KALGARD FA or EM620C solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305. ⑨
 HSL528AP()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305. ⑨

SPECIFICATION: HI-LITE™ Product Specification 380-2.

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



HI-LITE™ THREAD TRANSITION AREA.
 THIS AREA OF SPECIAL CONFIGURATION
 AND COLD WORKING TO MEET PHYSICAL
 REQUIREMENTS. SEE SPECIFICATION
 FOR INSPECTION.

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F.OBISPO	DATE 1991-11-27	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD BREAK STEM, SPECIAL THREAD TITANIUM 1/16 GRIP VARIATION	
APPROVED DAW	DATE 1991-12-09		
REVISION 9	DATE F.CARINGELLA 2017-12-12	DRAWING NUMBER HSL528	

FOR HSL528() () ONLY
 TABLE 2

SECOND DASH NUMBER	L (REF) [8]						
	-5 DIA.	-6 DIA.	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.
1	-	-	-	-	-	-	-
2	.875	1.000	1.000	-	-	-	-
3	1.000	1.125	1.125	1.250	-	-	-
4	1.125	1.250	1.250	1.375	1.375	-	-
5	1.250	1.375	1.375	1.500	1.500	1.625	-
6	1.375	1.500	1.500	1.625	1.625	1.750	1.750
7	1.500	1.625	1.625	1.750	1.750	1.875	1.875
8	1.625	1.750	1.750	1.875	1.875	2.000	2.000
9	1.750	1.875	1.875	2.000	2.000	2.125	2.125
10	1.875	2.000	2.000	2.125	2.125	2.250	2.250
11	2.000	2.125	2.125	2.250	2.250	2.375	2.375
12	2.125	2.250	2.250	2.375	2.375	2.500	2.500
13	2.250	2.375	2.375	2.500	2.500	2.625	2.625
14	2.375	2.500	2.500	2.625	2.625	2.750	2.750
15	2.500	2.625	2.625	2.750	2.750	2.875	2.875
16	2.625	2.750	2.750	2.875	2.875	3.000	3.000
17	2.750	2.875	2.875	3.000	3.000	3.125	3.125
18	2.875	3.000	3.000	3.125	3.125	3.250	3.250
19	3.000	3.125	3.125	3.250	3.250	3.375	3.375
20	3.125	3.250	3.250	3.375	3.375	3.500	3.500
21	-	3.375	3.375	3.500	3.500	3.625	3.625
22	-	3.500	3.500	3.625	3.625	3.750	3.750
23	-	3.625	3.625	3.750	3.750	3.875	3.875
24	-	3.750	3.750	3.875	3.875	4.000	4.000
25	-	-	-	4.000	4.000	4.125	4.125
26	-	-	-	4.125	4.125	4.250	4.250
27	-	-	-	4.250	4.250	4.375	4.375
28	-	-	-	4.375	4.375	4.500	4.500
29	-	-	-	-	4.500	4.625	4.625
30	-	-	-	-	4.625	4.750	4.750
31	-	-	-	-	4.750	4.875	4.875
32	-	-	-	-	4.875	5.000	5.000
33	-	-	-	-	5.000	5.125	5.125
34	-	-	-	-	5.125	5.250	5.250
35	-	-	-	-	5.250	5.375	5.375
36	-	-	-	-	5.375	5.500	5.500
37	-	-	-	-	5.500	5.625	5.625
38	-	-	-	-	5.625	5.750	5.750
39	-	-	-	-	5.750	5.875	5.875
40	-	-	-	-	5.875	6.000	6.000
41	-	-	-	-	6.000	6.125	6.125
42	-	-	-	-	6.125	6.250	6.250
43	-	-	-	-	6.250	6.375	6.375
44	-	-	-	-	6.375	6.500	6.500

FOR HSL528() () L ONLY
 TABLE 3

SECOND DASH NUMBER	L (REF) [8]						
	-5 DIA.	-6 DIA.	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.
1	-	-	-	-	-	-	-
2	.563	.675	.605	-	-	-	-
3	.688	.800	.730	.750	-	-	-
4	.813	.925	.855	.875	.830	-	-
5	.938	1.050	.980	1.000	.955	.990	-
6	1.063	1.175	1.105	1.125	1.080	1.115	1.065
7	1.188	1.300	1.230	1.250	1.205	1.240	1.190
8	1.313	1.425	1.355	1.375	1.330	1.365	1.315
9	1.438	1.550	1.480	1.500	1.455	1.490	1.440
10	1.563	1.675	1.605	1.625	1.580	1.615	1.565
11	1.688	1.800	1.730	1.750	1.705	1.740	1.690
12	1.813	1.925	1.855	1.875	1.830	1.865	1.815
13	1.938	2.050	1.980	2.000	1.955	1.990	1.940
14	2.063	2.175	2.105	2.125	2.080	2.115	2.065
15	2.188	2.300	2.230	2.250	2.205	2.240	2.190
16	2.313	2.425	2.355	2.375	2.330	2.365	2.315
17	2.438	2.550	2.480	2.500	2.455	2.490	2.440
18	2.563	2.675	2.605	2.625	2.580	2.615	2.565
19	2.688	2.800	2.730	2.750	2.705	2.740	2.690
20	2.813	2.925	2.855	2.875	2.830	2.865	2.815
21	-	3.050	2.980	3.000	2.955	2.990	2.940
22	-	3.175	3.105	3.125	3.080	3.115	3.065
23	-	3.300	3.230	3.250	3.205	3.240	3.190
24	-	3.425	3.355	3.375	3.330	3.365	3.315
25	-	-	-	3.500	3.455	3.490	3.440
26	-	-	-	3.625	3.580	3.615	3.565
27	-	-	-	3.750	3.705	3.740	3.690
28	-	-	-	3.875	3.830	3.865	3.815
29	-	-	-	-	-	3.990	3.940
30	-	-	-	-	-	4.115	4.065
31	-	-	-	-	-	4.240	4.190
32	-	-	-	-	-	4.365	4.315

HSL528

DRAWING NUMBER

HSL528

2 OF 2