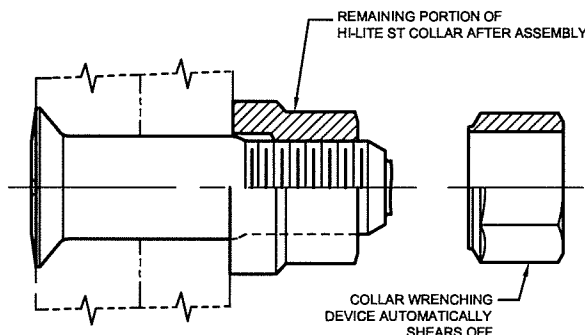
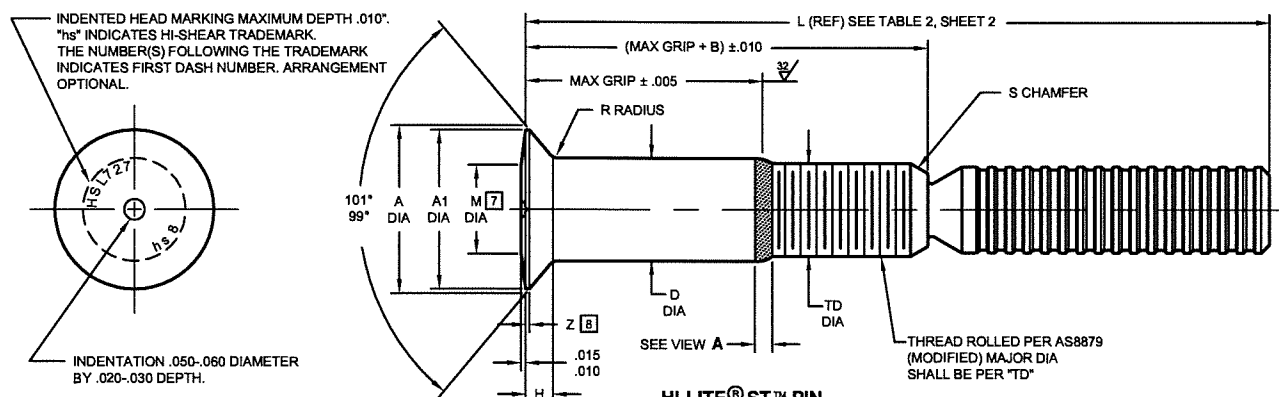




HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	A1 DIA	B REF	D DIA BEFORE FINISH	D1 DIA MAX	F	TD DIA	H	K MAX	M DIA FLAT	R RAD	Z MAX	S CHAMFER REF	THREAD	DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
5	5/32																
NOTE: USE HSL627-6(-)																	
6	7/32	.3303 .3253	.323 .311	.325	.2182 .2177	.212	.005	.1840 .1810	.0470 .0450	.016	.155 .135	.030 .020	.015	1/32" x 37"	10-32UNJF-3A Modified	8,200 7,100	2,000
8	9/32	.4260 .4210	.418 .407	.395	.2807 .2802	.275	.006	.2440 .2410	.0610 .0590	.021	.200 .180	.030 .020	.015	1/32" x 37"	1/4-28UNJF-3A Modified	13,500 11,800	3,700
10	11/32	.5051 .5001	.498 .486	.500	.3432 .3427	.337	.007	.3060 .3020	.0680 .0660	.026	.265 .245	.040 .030	.015	3/64" x 37"	5/16-24UNJF-3A Modified	20,200 17,600	5,000
12	13/32	.5916 .5866	.584 .572	.545	.4057 .4052	.400	.008	.3680 .3640	.0780 .0760	.030	.325 .300	.040 .030	.015	3/64" x 37"	3/8-24UNJF-3A Modified	28,200 24,600	7,200
14	15/32	.6992 .6932	.692 .668	.635	.4682 .4677	.462	.009	.4310 .4260	.0970 .0945	.035	.380 .355	.050 .040	.022	3/64" x 37"	7/16-20UNJF-3A Modified	37,600 32,700	10,000
16	17/32	.7852 .7792	.778 .754	.685	.5307 .5302	.525	.010	.4930 .4880	.1070 .1045	.039	.445 .415	.050 .040	.022	3/64" x 37"	1/2-20UNJF-3A Modified	48,250 42,000	13,500

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.
- Dimensions to be met after finish, except as noted.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Flat permissible within "M" diameter.
- Curved or flat edge manufacturer's option.
- "D" diameter may increase by .0005" after application of solid film lube and .001" after application of aluminum coating.
- Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
- Oversize replacement for HSL527 and HSL627.
- Shorter or longer grips than those listed may be available as specials.

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

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HSL727DL(-) = Kalgard FA or EM620C solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.
HSL727AP(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

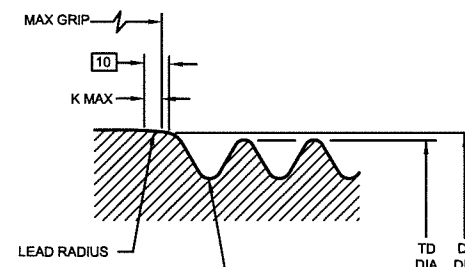
SPECIFICATION: Hi-Lite Product Specification 380-2.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HSL727 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

**HOW TO ORDER
EXAMPLE:**

Pin Part Number Only
HSL727AP8-8
8/16 or 1/2 Maximum Grip Length
Replaces 8/32 or 1/4 Nominal Diameter Pin
Finish
Pin Part Number



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

U.S. Patents 4,326,825; 4,485,510 and 4,957,401. Other U.S. and international patents pending. "Hi-Lite" and "HST" are registered trademarks and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.	
DRAWN J.F.Obispo	DATE 7-29-92
APPROVED DAW	DATE 7-30-92
REVISION (4)	DATE 9-2-2008
TITLE HI-LITE® ST™ PIN 100° FLUSH SHEAR CROWN HEAD BREAK STEM, SPECIAL THREAD TITANIUM 1/16" GRIP VARIATION, 1/32" OVERSIZE DRAWING NUMBER HSL727	

TABLE 2

SECOND DASH NUMBER	L (REF) 12					
	-6 DIA.	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.
1	-	-	-	-	-	-
2	.955	.940	-	-	-	-
3	1.080	1.065	1.185	-	-	-
4	1.205	1.190	1.310	1.300	-	-
5	1.330	1.315	1.435	1.425	1.530	-
6	1.455	1.440	1.560	1.550	1.655	1.645
7	1.580	1.565	1.685	1.675	1.780	1.770
8	1.705	1.690	1.810	1.800	1.905	1.895
9	1.830	1.815	1.935	1.925	2.030	2.020
10	1.955	1.940	2.060	2.050	2.155	2.145
11	2.080	2.065	2.185	2.175	2.280	2.270
12	2.205	2.190	2.310	2.300	2.405	2.395
13	2.330	2.315	2.435	2.425	2.530	2.520
14	2.455	2.440	2.560	2.550	2.655	2.645
15	2.580	2.565	2.685	2.675	2.780	2.770
16	2.705	2.690	2.810	2.800	2.905	2.895
17	2.830	2.815	2.935	2.925	3.030	3.020
18	2.955	2.940	3.060	3.050	3.155	3.145
19	3.080	3.065	3.185	3.175	3.280	3.270
20	3.205	3.190	3.310	3.300	3.405	3.395
21	3.330	3.315	3.435	3.425	3.530	3.520
22	3.455	3.440	3.560	3.550	3.655	3.645
23	3.580	3.565	3.685	3.675	3.780	3.770
24	3.705	3.690	3.810	3.800	3.905	3.895
25	-	-	3.935	3.925	4.030	4.020
26	-	-	4.060	4.050	4.155	4.145
27	-	-	4.185	4.175	4.280	4.270
28	-	-	4.310	4.300	4.405	4.395
29	-	-	-	-	4.530	4.520
30	-	-	-	-	4.655	4.645
31	-	-	-	-	4.780	4.770
32	-	-	-	-	4.905	4.895