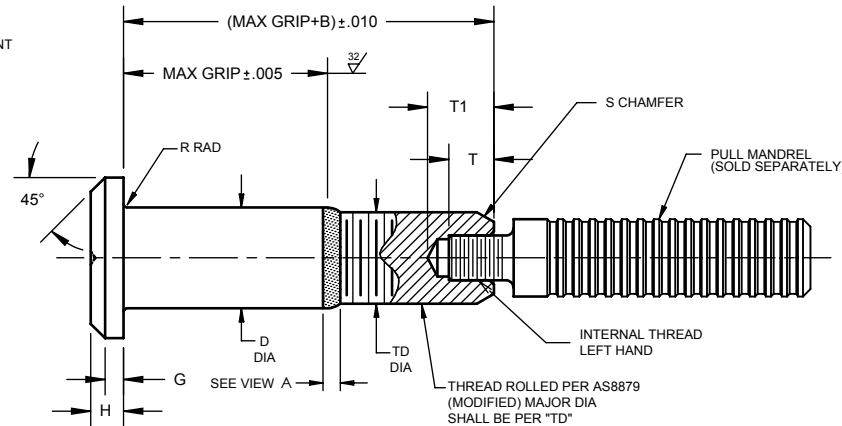
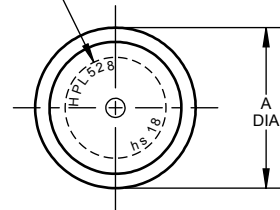
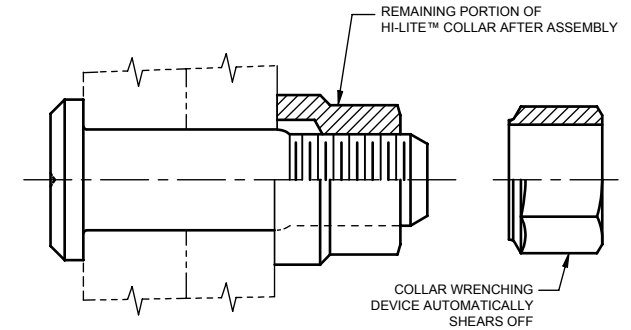


(8)

INDENTED HEAD MARKING MAXIMUM DEPTH .010".
 "hs" INDICATES HI-SHEAR TRADEMARK.
 THE NUMBER(S) FOLLOWING THE TRADEMARK
 INDICATES FIRST DASH NUMBERS ARRANGEMENT
 OPTIONAL IDENTATION IS .050-.060 DIAMETER
 x .020-.030 DEPTH.



HI-LITE™ PIN



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA WITHOUT COATING OR SOLID FILM	TD DIA	G REF	H	K MAX	R RAD	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
												T MIN	T1 MAX	THREAD SIZE		
18	9/16	.877 .842	.770	.5615 .5610	.5550 .5500	.115	.210 .200	.039	.040 .025	1/16" x 37°	.5625-18 UNJF-3A	.280	.456	.312-24UNJF-3B	53,700 47,200	32,400
20	5/8	.953 .905	.825	.6240 .6235	.6180 .6120	.130	.238 .228	.044	.040 .025	1/16" x 37°	.6875-18 UNJF-3A	.280	.456	.312-24UNJF-3B	66,300 58,300	41,000
24	3/4	1.150 1.110	1.050	.7490 .7485	.7430 .7370	.200	.335 .320	.044	.045 .030	1/16" x 37°	.7500-16 UNJF-3A	.305	.480	.375-24UNJF-3B	95,200 83,900	59,500

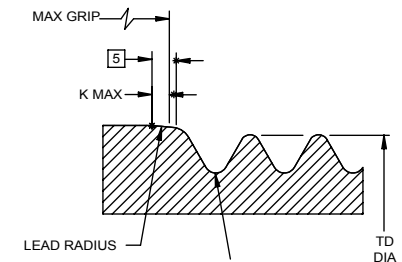
SEE COLLAR STANDARDS
 FOR COLLAR STRENGTHS.
 LOWER STRENGTH (PIN OR
 COLLAR) DETERMINES
 SYSTEM STRENGTH.

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions are in inches and to be met after finish, except as noted.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 5. Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
 6. "D" diameter may increase by .0005" after application of solid film lube and .001" after aluminum coating.
 7. Use HPL628 for oversize replacement.

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:

Pin Part Number
 HPL528DL18-8A
 — Assembled 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



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

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

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HPL528AP()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294,
 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HPL528DL()-() = 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.

"PULL-IN", "HI-LITE", AND "HI-KOTE",
 ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY J.F.O.	DATE 1991-11-25	TITLE PULL-IN™ HI-LITE™ PIN PROTRUDING TENSION HEAD TITANIUM,, SPECIAL THREAD 1/16 GRIP VARIATION
APPROVED DAW	DATE 1991-11-25	
REVISION (8)	DATE K. TRAN 2017-10-30	DRAWING NUMBER HPL528