

HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

HI-LITE™ PIN

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			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											T MAX	T1 MAX	THREAD SIZE		
18	19/32	.905 .870	.770	.5927 .5917	.5550 .5500	.115	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.300	.456	.312-24UNJF-2B	69,200	43,500
20	21/32	.975 .940	.825	.6552 .6542	.6180 .6120	.130	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.300	.456	.312-24UNJF-2B	84,500	54,600

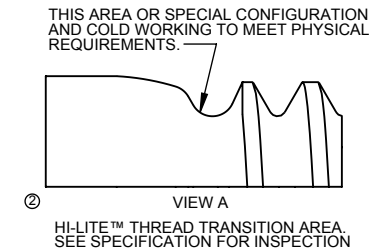
SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIR.
 - Dimensions are in inches and to be met after finish.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Lead radius must be tangent to "D" diameter at max grip.
 - Oversize replacement for HPL822 and HPL832.
 - 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.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HPL842 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
 ② **EXAMPLE:**

Pin Part Number
 HPL842DL18-8A
 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



MATERIAL: Nickel Base Alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: ② HPL842DL()-() = KALGARD FA or EM620C solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.

② HPL842AG()-() = 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.

② HPL842AP()-() = 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.

"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, 1/32 OVERSIZE	
APPROVED J.RAUSCH	DATE 1995-08-09		
REVISION ②	DATE F.CARINGELLA 2017-12-11	DRAWING NUMBER HPL842	