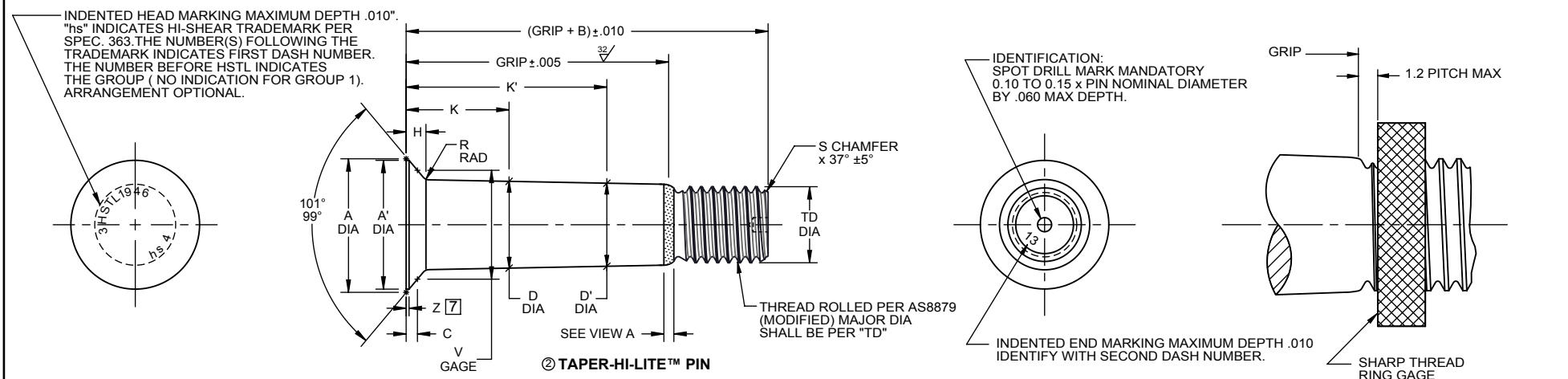




① ⑨ TABLE 1 ⑦

FIRST DASH NO.	PIN NOM DIA	GROUP NO.	A DIA MAX	A' DIA MIN	B (REF)	C		F	H MAX	K +.040 -.000	R RAD +.010 -.000	S MAX	V GAGE +.0002 -.0000	X	Y	Z MAX	THREAD	TD DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION- TENSION FATIGUE LBS. MAX.
						NOM	TOL.														
3	3/16	-	-	-	.290	-	±.0020	.007	.063	.0885	.020	.027	.2592	.002	.0045	.015	.1900-32 UNJF-3A	.1840 .1810	7100	3000	1000
		2	.356	.308		.0377															
		3	.366	.318		.0419															
		4	.377	.328		.0464															
4	1/4	-	-	-	.320	-	±.0023	.008	.079	.1075	.020	.031	.3776	.002	.0045	.015	.2500-28 UNJF-3A	.2440 .2410	12300	5700	2000
		2	.462	.413		.0326															
		3	.476	.426		.0381															
		4	.489	.439		.0435															
5	5/16	-	-	-	.380	-	±.0025	.009	.094	.1245	.030	.035	.4788	.002	.0045	.015	.3125-24 UNJF-3A	.3060 .3020	19100	8600	3000
		2	.564	.514		.0325															
		3	.578	.528		.0384															
		4	.592	.541		.0440															
6	3/8	-	-	-	.420	-	±.0028	.010	.112	.1415	.030	.035	.5696	.003	.0060	.015	.3750-24 UNJF-3A	.3680 .3640	27600	12600	4400
		2	.672	.620		.0393															
		3	.687	.635		.0456															
		4	.702	.649		.0517															
7	7/16	-	-	-	.485	-	±.0030	.011	.133	.1700	.040	.040	.6580	.004	.0060	.022	.4375-20 UNJF-3A	.4310 .4260	37600	16400	5700
		2	.790	.720		.0514															
		3	.808	.737		.0587															
		4	.826	.755		.0663															
8	1/2	-	-	-	.525	-	±.0033	.012	.144	.1790	.040	.040	.7198	.004	.0060	.022	.5000-20 UNJF-3A	.4930 .4880	49100	22800	8000
		2	.885	.813		.0649															
		3	.906	.833		.0735															
		4	.927	.853		.0821															
9	9/16	-	-	-	.600	-	±.0035	.014	.162	.2175	.060	.045	.8900	.005	.0060	.024	.5625-18 UNJF-3A	.5550 .5500	62100	28300	9900
		2	1.009	.932		.0454															
		3	1.040	.962		.0582															
		4	1.071	.992		.0710															
10	5/8	-	-	-	.640	-	±.0038	.014	.181	.2175	.060	.045	1.0026	.005	.0060	.026	.6250-18 UNJF-3A	.6180 .6120	76700	35600	12500
		2	1.124	1.041		.0462															
		3	1.158	1.073		.0600															
		4	1.192	1.107		.0743															
12	3/4	-	-	-	.895	-	±.0040	.016	.239	.3050	.070	.045	1.1122	.005	.0060	.030	.7500-16 UNJF-3A	.7430 .7370	110400	55200	19300
		2	1.397	1.298		.1133															
		3	1.436	1.336		.1295															
		4	1.475	1.374		.1456															

THREAD FUNCTIONALITY

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS



VIEW A

HI-LITE™ THREAD TRANSITION AREA
 SEE SPECIFICATION FOR INSPECTION

② "TAPER-HI-LITE", AND "HI-KOTE", ARE TRADEMARKS OF LISI AEROSPACE	
DRAWN BY J.F.OBISPO	DATE 2004-04-13
APPROVED M.CAWLEY	DATE 2004-04-28
REVISION ②	DATE F.CARINGELLA 2019-05-30
TITLE TAPER-HI-LITE™ PIN 100° FLUSH SHEAR HEAD TAPER SHANK, INCONEL 718 1/16 GRIP VARIATION, 1st OVERSIZE DRAWING NUMBER HSTL1946	

TABLE 1 (CONTINUED)

FIRST DASH NO.	PIN NOM DIA	GROUP NO.	A DIA MAX	A' DIA MIN	B (REF)	C		F	H MAX	K +.040 -.000	R RAD +.010 -.000	S MAX	V GAGE +.0002 -.0000	X	Y	Z MAX	THREAD	TD DIA	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION- TENSION FATIGUE LBS. MAX.
						NOM	TOL.														
14	7/8	-	-	-	1.000	-	±.0045	.016	.273	.3205	.070	.050	1.3600	.006	.0080	.034	.8750-14 UNJF-3A	.8680 .8610	149300	74700	26200
		2	1.622	1.512		.1034															
		3	1.669	1.558		.1229															
		4	1.716	1.604		.1426															
16	1	-	-	-	1.160	-	±.0048	.016	.280	.3050	.070	.050	1.5730	.006	.0080	.034	1.0000-12 UNJF-3A	.9930 .9860	195000	97700	34200
		2	1.7722	1.7235		.0781															
		3	1.8242	1.7755		.0995															
		4	1.8763	1.8276		.1212															

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed F.
 - Concentricity: Conical surface of head to and taper shank at K to be within X values FIM.
Taper shank at K' and thread pitch diameter to be within Y values FIM.
 - H is dimensioned from maximum D diameter.
 - Dimensions are in inches and to be met after finish and prior to application of lubricant.
 - Surface texture per ASME B46.1.
 - Top of head to be flat to .0025 max convex. Concave condition not allowed.
 - Curved or flat edge manufacturer's option.
 - Use HSTL1947 for oversize replacement.
 - For -3 grip length the tolerance on "K" and "K' " is -.000/+.030, and for -4 grip length the tolerance on "K" and "K' " is -.000/+.035.

MATERIAL: Nickel Base Alloy per AMS5962

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HSTL1946BP()-() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, with color blue on the thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 414. ②

CODE: First dash number indicates nominal diameter in 1/16ths.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER

EXAMPLE: Pin Part Number
 HSTL1946BP4-13

13/16 Maximum Grip Length
 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

HSTL1946

DRAWING NUMBER

HSTL1946

2 OF 6

9					9					TABLE 2					9					9												
SECOND DASH NO.	3/16"				1/4"				5/16"				3/8"				7/16"				SECOND DASH NO.											
	D DIA	K' +.040 -.000	D' DIA	GROUP NO.	D DIA	K' +.040 -.000	D' DIA	GROUP NO.	D DIA	K' +.040 -.000	D' DIA	GROUP NO.	D DIA	K' +.040 -.000	D' DIA	GROUP NO.	D DIA	K' +.040 -.000	D' DIA	GROUP NO.												
1	.2105	-	-	2	.2754	-	-	2	.3403	-	-	2	.4053	-	-	2	.4726	-	-	2	1											
2		-	-			-	-			-	-			-	-			-	-			-	-	-	-	-	-	-	-	-	2	
3		.1300	.2096			.1300	.2749			.1300	.3402			.1300	.4016			.1300	.4695			.1300	.5368	.1300	.6040	.1300	.6712	.1300	.7384	.1300	.8056	3
4		.1925	.2083			.1925	.2736			.1925	.3389			.1925	.4042			.1925	.4695			.1925	.5348	.1925	.6001	.1925	.6654	.1925	.7307	.1925	.7960	4
5		.2550	.2070			.2550	.2723			.2550	.3376			.2550	.4029			.2550	.4682			.2550	.5335	.2550	.6001	.2550	.6654	.2550	.7307	.2550	.7960	5
6		.3175	.2057			.3175	.2710			.3175	.3363			.3175	.4016			.3175	.4669			.3175	.5322	.3175	.5975	.3175	.6628	.3175	.7281	.3175	.7934	6
7		.3800	.2044			.3800	.2697			.3800	.3350			.3800	.4003			.3800	.4669			.3800	.5322	.3800	.5975	.3800	.6628	.3800	.7281	.3800	.7934	7
8		.4425	.2031			.4425	.2684			.4425	.3337			.4425	.3990			.4425	.4656			.4425	.5311	.4425	.5964	.4425	.6617	.4425	.7270	.4425	.7923	8
9	.2209	.5050	.2122	3	.2884	.5050	.2671	3	.3547	.5050	.3324	3	.4209	.5050	.3977	3	.4908	.5050	.4656	3	15											
10		.5675	.2109			.5675	.2658			.5675	.3311			.5675	.3964			.5675	.4643			.5675	.5300	.5675	.5953	.5675	.6606	.5675	.7259	.5675	.7912	
11		.6300	.2096			.6300	.2775			.6300	.3298			.6300	.3951			.6300	.4630			.6300	.5300	.6300	.5953	.6300	.6606	.6300	.7259	.6300	.7912	
12		.6925	.2083			.6925	.2762			.6925	.3428			.6925	.3938			.6925	.4617			.6925	.5300	.6925	.5953	.6925	.6606	.6925	.7259	.6925	.7912	
13		.7550	.2070			.7550	.2749			.7550	.3415			.7550	.4081			.7550	.4604			.7550	.5300	.7550	.5953	.7550	.6606	.7550	.7259	.7550	.7912	
14		.8175	.2057			.8175	.2736			.8175	.3402			.8175	.4068			.8175	.4591			.8175	.5300	.8175	.5953	.8175	.6606	.8175	.7259	.8175	.7912	
15		.8800	.2044			.8800	.2723			.8800	.3389			.8800	.4055			.8800	.4760			.8800	.5300	.8800	.5953	.8800	.6606	.8800	.7259	.8800	.7912	
16		.9425	.2031			.9425	.2720			.9425	.3376			.9425	.4042			.9425	.4747			.9425	.5300	.9425	.5953	.9425	.6606	.9425	.7259	.9425	.7912	
17	.2313	1.0050	.2122	4	.3014	1.0050	.2697	4	.3690	1.0050	.3363	4	.4365	1.0050	.4029	4	.5091	1.0050	.4734	4	17											
18		1.0675	.2109			1.0675	.2684			1.0675	.3350			1.0675	.4016			1.0675	.4721			1.0675	.5300	1.0675	.5953	1.0675	.6606	1.0675	.7259	1.0675	.7912	
19		1.1300	.2096			1.1300	.2671			1.1300	.3337			1.1300	.4003			1.1300	.4708			1.1300	.5300	1.1300	.5953	1.1300	.6606	1.1300	.7259	1.1300	.7912	
20		1.1925	.2083			1.1925	.2658			1.1925	.3324			1.1925	.3990			1.1925	.4695			1.1925	.5300	1.1925	.5953	1.1925	.6606	1.1925	.7259	1.1925	.7912	
21		1.2550	.2070			1.2550	.2775			1.2550	.3311			1.2550	.3977			1.2550	.4682			1.2550	.5300	1.2550	.5953	1.2550	.6606	1.2550	.7259	1.2550	.7912	
22		1.3175	.2057			1.3175	.2762			1.3175	.3298			1.3175	.3964			1.3175	.4669			1.3175	.5300	1.3175	.5953	1.3175	.6606	1.3175	.7259	1.3175	.7912	
23		1.3800	.2044			1.3800	.2749			1.3800	.3428			1.3800	.3951			1.3800	.4656			1.3800	.5300	1.3800	.5953	1.3800	.6606	1.3800	.7259	1.3800	.7912	
24		1.4425	.2031			1.4425	.2736			1.4425	.3415			1.4425	.4068			1.4425	.4747			1.4425	.5300	1.4425	.5953	1.4425	.6606	1.4425	.7259	1.4425	.7912	
25						1.5050	.2723			1.5050	.3402			1.5050	.4081			1.5050	.4734													
26						1.5675	.2710			1.5675	.3389			1.5675	.4068			1.5675	.4721			1.5675	.5300	1.5675	.5953	1.5675	.6606	1.5675	.7259	1.5675	.7912	
27						1.6300	.2697			1.6300	.3376			1.6300	.4055			1.6300	.4747			1.6300	.5300	1.6300	.5953	1.6300	.6606	1.6300	.7259	1.6300	.7912	
28						1.6925	.2684			1.6925	.3363			1.6925	.4042			1.6925	.4734			1.6925	.5300	1.6925	.5953	1.6925	.6606	1.6925	.7259	1.6925	.7912	
29						1.7550	.2671			1.7550	.3350			1.7550	.4029			1.7550	.4721			1.7550	.5300	1.7550	.5953	1.7550	.6606	1.7550	.7259	1.7550	.7912	
30						1.8175	.2658			1.8175	.3337			1.8175	.4016			1.8175	.4712			1.8175	.5300	1.8175	.5953	1.8175	.6606	1.8175	.7259	1.8175	.7912	
31										1.8800	.3324			1.8800	.4003			1.8800	.4708			1.8800	.5300	1.8800	.5953	1.8800	.6606	1.8800	.7259	1.8800	.7912	
32										1.9425	.3311			1.9425	.3990			1.9425	.4695			1.9425	.5300	1.9425	.5953	1.9425	.6606	1.9425	.7259	1.9425	.7912	
33										2.0050	.3298			2.0050	.3977			2.0050	.4708													
34										2.0675	.3964			2.0675	.4695			2.0675	.5300			2.0675	.5953	2.0675	.6606	2.0675	.7259	2.0675	.7912			
35										2.1300	.3951			2.1300	.4682			2.1300	.5300			2.1300	.5953	2.1300	.6606	2.1300	.7259	2.1300	.7912			
36										2.1925	.3938			2.1925	.4669			2.1925	.5300			2.1925	.5953	2.1925	.6606	2.1925	.7259	2.1925	.7912			
37										2.2551	.4081			2.2551	.4656			2.2551	.5300			2.2551	.5953	2.2551	.6606	2.2551	.7259	2.2551	.7912			
38										2.3173	.4068			2.3173	.4643			2.3173	.5300			2.3173	.5953	2.3173	.6606	2.3173	.7259	2.3173	.7912			
39										2.3799	.4055			2.3799	.4630			2.3799	.5300			2.3799	.5953	2.3799	.6606	2.3799	.7259	2.3799	.7912			
40										2.4425	.4042			2.4425	.4617			2.4425	.5300			2.4425	.5953	2.4425	.6606	2.4425	.7259	2.4425	.7912			
41										2.5051	.4029			2.5051	.4695			2.5050	.4604													
42										2.5673	.4016			2.5673	.4682			2.5673	.5300			2.5673	.5953	2.5673	.6606	2.5673	.7259	2.5673	.7912			
43										2.6299	.4003			2.6299	.4669			2.6299	.5300			2.6299	.5953	2.6299	.6606	2.6299	.7259	2.6299	.7912			
44										2.6925	.3990			2.6925	.4656			2.6925	.5300			2.6925	.5953	2.6925	.6606	2.6925	.7259	2.6925	.7912			
45										2.7551	.3977			2.7551	.4643			2.7551	.5300			2.7551	.5953	2.7551	.6606	2.7551	.7259	2.7551	.7912			
46										2.8173	.3964			2.8173	.4630			2.8173	.5300			2.8173	.5953	2.8173	.6606	2.8173	.7259	2.8173	.7912			
47										2.8799	.3951			2.8799	.4617			2.8799	.5300			2.8799	.5953	2.8799	.6606	2.8799	.7259	2.8799	.7912			
48										2.9425	.3938			2.9425	.4604			2.9425	.5300			2.9425	.5953	2.9425	.6606	2.9425	.7259	2.9425	.7912			
49																					49											

HSTL1946

DRAWING NUMBER

HSTL1946

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TABLE 2 (CONTINUED)

SECOND DASH NO.	1/2"				9/16"													
	D DIA	K' +.040 -.000	D' DIA	GROUP NO.	D DIA	K' +.040 -.000	D' DIA	GROUP NO.	SECOND DASH NO.	D DIA	K' +.040 -.000	D' DIA	GROU NO.					
5	.5400	.2550	.5384	2	.6230	-	-	2	-	-	-	-	4					
6		.3175	.5371			.3175	.6208		65		4.0050	.6065						
7		.3800	.5358			.3800	.6195		66		4.0675	.6052						
8		.4425	.5345			.4425	.6182		67		4.1300	.6039						
9		.5050	.5332			.5050	.6169		68		4.1925	.6026						
10		.5675	.5319			.5675	.6156		69	.6854	4.2550	.6013						
11		.6300	.5306			.6300	.6143		70		4.3175	.6000						
12		.6925	.5292			.6925	.6130		71		4.3800	.5987						
13		.7550	.5280			.7550	.6117		72		4.4425	.5974						
14		.8175	.5267			.8175	.6104											
15		.8800	.5254			.8800	.6091											
16		.9425	.5241			.9425	.6078											
17		.5609	1.0050			.5436	3		.6542	1.0050	.6065	3						
18			1.0675			.5423				1.0675	.6052			1.5050	.6273			
19			1.1300			.5410				1.1300	.6039			1.5675	.6260			
20			1.1925			.5397				1.1925	.6026			1.6300	.6247			
21	1.2550		.5384	1.2550	.6013	1.6925		.6234										
22	1.3175		.5371	1.3175	.6000	1.7550		.6221										
23	1.3800		.5358	1.3800	.5987	1.8175		.6208										
24	1.4425		.5345	1.4425	.5974	1.8800		.6195										
25	1.5050		.5332	1.5050	.6273	1.9425		.6182										
26	1.5675		.5319	1.5675	.6260	2.0050		.6169										
27	1.6300		.5306	1.6300	.6247	2.0675		.6156										
28	1.6925		.5293	1.6925	.6234	2.1300		.6143										
29	1.7550		.5280	1.7550	.6221	2.1925		.6130										
30	1.8175		.5267	1.8175	.6208	2.2550		.6117										
31	1.8800		.5254	1.8800	.6195	2.3175		.6104										
32	1.9425		.5241	1.9425	.6182	2.3800		.6091										
33	.5817	2.0050	.5436	4	.6542	2.0050	.6169	3										
34		2.0675	.5423			2.0675	.6156		2.4425	.6078								
35		2.1300	.5410			2.1300	.6143		2.5050	.6065								
36		2.1925	.5397			2.1925	.6130		2.5675	.6052								
37		2.2550	.5384			2.2550	.6117		2.6300	.6039								
38		2.3175	.5371			2.3175	.6104		2.6925	.6026								
39		2.3800	.5358			2.3800	.6091		2.7550	.6013								
40		2.4425	.5345			2.4425	.6078		2.8175	.6000								
41		2.5050	.5332			2.5050	.6065		2.8800	.5987								
42		2.5675	.5319			2.5675	.6052		2.9425	.5974								
43		2.6300	.5306			2.6300	.6039		3.0050	.6273								
44		2.6925	.5293			2.6925	.6026		3.0675	.6260								
45		2.7550	.5280			2.7550	.6013		3.1300	.6247								
46		2.8175	.5267			2.8175	.6000		3.1925	.6234								
47		2.8800	.5254			2.8800	.5987		3.2550	.6221								
48		2.9425	.5241			2.9425	.5974		3.3175	.6208								
49	.6025	3.0050	.5436	5	.6854	3.0050	.6195	4										
50		3.0675	.5423			3.0675	.6260		3.4425	.6182								
51		3.1300	.5410			3.1300	.6247		3.5050	.6169								
52		3.1925	.5397			3.1925	.6234		3.5675	.6156								
53		3.2550	.5384			3.2550	.6221		3.6300	.6143								
54		3.3175	.5371			3.3175	.6208		3.6925	.6130								
55		3.3800	.5358			3.3800	.6195		3.7550	.6117								
56		3.4425	.5345			3.4425	.6182		3.8175	.6104								
57		3.5050	.5332			3.5050	.6169		3.8800	.6091								
58		3.5675	.5319			3.5675	.6156		3.9425	.6078								
59		3.6300	.5306			3.6300	.6143											
60		3.6925	.5293			3.6925	.6130											
61		3.7550	.5280			3.7550	.6117											
62		3.8175	.5267			3.8175	.6104											
63		3.8800	.5254			3.8800	.6091											
64		3.9425	.5241			3.9425	.6078											

SECOND DASH NO.	5/8"				SECOND DASH NO.	5/8"			
D DIA	K' +.040 -.000	D' DIA	GROUP NO.	D DIA	K' +.040 -.000	D' DIA	GROUP NO.		
5	-	-	2	-	-	-	4		
6	-	-		-	-	-			
7	.3800	.6879		53	3.2550	.6957			
8	.4425	.6866		54	3.3175	.6944			
9	.5050	.6853		55	3.3800	.6931			
10	.5675	.6840		56	3.4425	.6918			
11	.6300	.6827		57	3.5050	.6905			
12	.6925	.6814		58	3.5675	.6892			
13	.7550	.6801		59	3.6300	.6879			
14	.8175	.6788		60	3.6925	.6866			
15	.8800	.6775		61	3.7550	.6853			
16	.9425	.6762		62	3.8175	.6840			
17	1.0050	.6749		63	3.8800	.6827			
18	1.0675	.6736		64	3.9425	.6814			
19	1.1300	.6723		65	4.0050	.6801			
20	1.1925	.6710		66	4.0675	.6788			
21	1.2550	.6697		67	4.1300	.6775			
22	1.3175	.6684		68	4.1925	.6762			
23	1.3800	.6671		69	4.2550	.6749			
24	1.4425	.6658		70	4.3175	.6736			
25	1.5050	.6645		71	4.3800	.6723			
26	1.5675	.6632		72	4.4425	.6710			
27	1.6300	.6957		73	4.5050	.6697			
28	1.6925	.6944		74	4.5675	.6684			
29	1.7550	.6931		75	4.6300	.6671			
30	1.8175	.6918		76	4.6925	.6658			
31	1.8800	.6905	77	4.7550	.6645				
32	1.9425	.6892	78	4.8175	.6632				
33	2.0050	.6879	3						
34	2.0675	.6866							
35	2.1300	.6853							
36	2.1925	.6840							
37	2.2550	.6827							
38	2.3175	.6814							
39	2.3800	.6801							
40	2.4425	.6788							
41	2.5050	.6775							
42	2.5675	.6762							
43	2.6300	.6749							
44	2.6925	.6736							
45	2.7550	.6723							
46	2.8175	.6710							
47	2.8800	.6697							
48	2.9425	.6684							
49	3.0050	.6671							
50	3.0675	.6658							
51	3.1300	.6645							
52	3.1925	.6632							

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TABLE 2 (CONTINUED)

3/4"										
SECOND DASH NO.	D DIA	K' +.040 -.000	D' DIA	GROUP NO.	SECOND DASH NO.	D DIA	K' +.040 -.000	D' DIA	GROU NO.	
5	.8266	-	-	2	-	.9048	-	-	4	
6		-	-		-		-			
7		-	-		-		-			
8		.4425	.8238		65		4.0050	.8277		
9		.5050	.8225		66		4.0675	.8264		
10		.5675	.8212		67		4.1300	.8251		
11		.6300	.8199		68		4.1925	.8238		
12		.6925	.8186		69		4.2550	.8225		
13		.7550	.8173		70		4.3175	.8212		
14		.8175	.8160		71		4.3800	.8199		
15		.8800	.8147		72		4.4425	.8186		
16		.9425	.8134		73		4.5050	.8173		
17		1.0050	.8121		74		4.5675	.8160		
18		1.0675	.8108		75		4.6300	.8147		
19		1.1300	.8095		76		4.6925	.8134		
20		1.1925	.8082		77		4.7550	.8121		
21		1.2550	.8069		78		4.8175	.8108		
22		1.3175	.8056		79		4.8800	.8095		
23		1.3800	.8043		80		4.9425	.8082		
24		1.4425	.8030		81		5.0050	.8069		
25		1.5050	.8017		82		5.0675	.8056		
26		1.5675	.8004		83		5.1300	.8043		
27		1.6300	.7991		84		5.1925	.8030		
28		1.6925	.7978		85		5.2550	.8017		
29		1.7550	.7965		86		5.3175	.8004		
30		1.8175	.7952		87		5.3800	.7991		
31		.8657	1.8800		.8329		88	5.4425		.7978
32			1.9425		.8316		89	5.5050		.7965
33			2.0050		.8303		90	5.5675		.7952
34			2.0675		.8290					
35	2.1300		.8277							
36	2.1925		.8264							
37	2.2550		.8251							
38	2.3175		.8238							
39	2.3800		.8225							
40	2.4425		.8212							
41	2.5050		.8199							
42	2.5675		.8186							
43	2.6300		.8173							
44	2.6925		.8160							
45	2.7550		.8147							
46	2.8175		.8134							
47	2.8800		.8121							
48	2.9425		.8108							
49	3.0050		.8095							
50	3.0675		.8082							
51	3.1300		.8069							
52	3.1925		.8056							
53	3.2550		.8043							
54	3.3175		.8030							
55	3.3800		.8017							
56	3.4425		.8004							
57	3.5050		.7991							
58	3.5675		.7978							
59	3.6300		.7965							
60	3.6925		.7952							
61	.9048	3.7550	.8329	4						
62		3.8175	.8316							
63		3.8800	.8303							
64		3.9425	.8290							

7/8"									
SECOND DASH NO.	D DIA	K' +.040 -.000	D' DIA	GROUP NO.	SECOND DASH NO.	D DIA	K' +.040 -.000	D' DIA	GROUP NO.
5	.9684	-	-	2	-	-	-	-	3
6		-	-		65	1.0153	4.0050	.9385	
7		-	-		66	4.0675	.9372		
8		-	-		67	4.1300	.9359		
9		.5050	.9646		68	4.1925	.9346		
10		.5675	.9633		69	4.2550	.9333		
11		.6300	.9620		70	4.3175	.9320		
12		.6925	.9606		71	4.3800	.9307		
13		.7550	.9593		72	4.4425	.9294		
14		.8175	.9580		73	4.5050	.9750		
15		.8800	.9567		74	4.5675	.9737		
16		.9425	.9554		75	4.6300	.9724		
17		1.0050	.9541		76	4.6925	.9711		
18		1.0675	.9528		77	4.7550	.9698		
19		1.1300	.9515		78	4.8175	.9685		
20		1.1925	.9502		79	4.8800	.9672		
21		1.2550	.9489		80	4.9425	.9659		
22		1.3175	.9476		81	5.0050	.9646		
23		1.3800	.9463		82	5.0675	.9633		
24		1.4425	.9450		83	5.1300	.9620		
25		1.5050	.9437		84	5.1925	.9606		
26		1.5675	.9424		85	5.2550	.9593		
27		1.6300	.9411		86	5.3175	.9580		
28		1.6925	.9398		87	5.3800	.9567		
29		1.7550	.9385		88	5.4425	.9554		
30		1.8175	.9372		89	5.5050	.9541		
31		1.8800	.9359		90	5.5675	.9528		
32		1.9425	.9346		91	5.6300	.9515		
33	2.0050	.9333	92	5.6925	.9502				
34	2.0675	.9320	93	5.7550	.9489				
35	2.1300	.9307	94	5.8175	.9476				
36	2.1925	.9294	95	5.8800	.9463				
37	2.2550	.9281	96	5.9425	.9450				
38	2.3175	.9273	97	6.0050	.9437				
39	2.3800	.9274	98	6.0675	.9424				
40	2.4425	.9271	99	6.1300	.9411				
41	2.5050	.9698	100	6.1925	.9398				
42	2.5675	.9685	101	6.2550	.9385				
43	2.6300	.9672	102	6.3175	.9372				
44	2.6925	.9659	103	6.3800	.9359				
45	2.7550	.9646	104	6.4425	.9346				
46	2.8175	.9633	105	6.5050	.9333				
47	2.8800	.9620	106	6.5675	.9320				
48	2.9425	.9606	107	6.6300	.9307				
49	1.0153	3.0050	.9593	3	108	6.6925	.9294		
50		3.0675	.9580						
51		3.1300	.9567						
52		3.1925	.9554						
53		3.2550	.9541						
54		3.3175	.9528						
55		3.3800	.9515						
56		3.4425	.9502						
57		3.5050	.9489						
58		3.5675	.9476						
59		3.6300	.9463						
60		3.6925	.9450						
61		3.7550	.9437						
62		3.8175	.9424						
63		3.8800	.9411						
64		3.9425	.9398						

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TABLE 2 (CONTINUED)

1"									
SECOND DASH NO.	D DIA	K' +.040 -.000	D' DIA	GROUP NO.	SECOND DASH NO.	D DIA	K' +.040 -.000	D' DIA	GROUP NO.
5		-	-		-		-	-	
6		-	-		65		4.0050	1.1322	
7		-	-		66		4.0675	1.1309	
8		-	-		67		4.1300	1.1296	
9		-	-		68	1.2092	4.1925	1.1283	4
10		.5675	1.1518		69		4.2550	1.1270	
11		.6300	1.1505		70		4.3175	1.1257	
12		.6925	1.1492		71		4.3800	1.1244	
13		.7550	1.1479		72		4.4425	1.1231	
14		.8175	1.1466		73		4.5050	1.1218	
15		.8800	1.1453		74		4.5675	1.1205	
16		.9425	1.1439		75		4.6300	1.1192	
17		1.0050	1.1426		76		4.6925	1.1179	
18	1.1571	1.0675	1.1413	3	77		4.7550	1.1166	
19		1.1300	1.1400		78		4.8175	1.1153	
20		1.1925	1.1387		79		4.8800	1.1140	
21		1.2550	1.1374		80		4.9425	1.1127	
22		1.3175	1.1361		81		5.0050	1.1635	
23		1.3800	1.1348		82		5.0675	1.1622	
24		1.4425	1.1335		83		5.1300	1.1609	
25		1.5050	1.1322		84		5.1925	1.1596	
26		1.5675	1.1309		85		5.2550	1.1583	
27		1.6300	1.1296		86		5.3175	1.1570	
28		1.6925	1.1283		87		5.3800	1.1557	
29		1.7550	1.1270		88		5.4425	1.1544	
30		1.8175	1.1257		89		5.5050	1.1531	
31		1.8800	1.1244		90		5.5675	1.1518	
32		1.9425	1.1231		91		5.6300	1.1505	
33		2.0050	1.1218		92		5.6925	1.1492	
34		2.0675	1.1205		93		5.7550	1.1479	
35		2.1300	1.1192		94		5.8175	1.1466	
36		2.1925	1.1179		95		5.8800	1.1453	
37		2.2550	1.1166		96		5.9425	1.1439	
38		2.3175	1.1153		97		6.0050	1.1426	
39		2.3800	1.1140		98		6.0675	1.1413	
40		2.4425	1.1127		99		6.1300	1.1400	
41		2.5050	1.1635		100	1.2613	6.1925	1.1387	5
42		2.5675	1.1622		101		6.2550	1.1374	
43		2.6300	1.1609		102		6.3175	1.1361	
44		2.6925	1.1596		103		6.3800	1.1348	
45		2.7550	1.1583		104		6.4425	1.1335	
46		2.8175	1.1570		105		6.5050	1.1322	
47		2.8800	1.1557		106		6.5675	1.1309	
48		2.9425	1.1544		107		6.6300	1.1296	
49	1.2092	3.0050	1.1531	4	108		6.6925	1.1283	
50		3.0675	1.1518		109		6.7550	1.1270	
51		3.1300	1.1505		110		6.8175	1.1257	
52		3.1925	1.1492		111		6.8800	1.1244	
53		3.2550	1.1479		112		6.9425	1.1231	
54		3.3175	1.1466		113		7.0050	1.1218	
55		3.3800	1.1453		114		7.0675	1.1205	
56		3.4425	1.1439		115		7.1300	1.1192	
57		3.5050	1.1426		116		7.1925	1.1179	
58		3.5675	1.1413		117		7.2550	1.1166	
59		3.6300	1.1400		118		7.3175	1.1153	
60		3.6925	1.1387		119		7.3800	1.1140	
61		3.7550	1.1374		120		7.4425	1.1127	
62		3.8175	1.1361		-		-	-	
63		3.8800	1.1348		-		-	-	
64		3.9425	1.1335		-		-	-	

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