



HI-LITE™ PIN

HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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	TENSION-TENSION FATIGUE POUNDS
											T1 MAX	THREAD SIZE UNJF-2B	LOAD MAX			
20	11/16	.995 .960	.935	.6865 .6855	.6180 .6120	.140	.238 .228	.040 .025	1/16" x 45°	.6250-18 UNJF-3A	.520	3/8-SP	14,200	92,900	44,800	16,600
24	13/16	1.206 1.166	1.125	.8115 .8105	.7430 .7370	.200	.335 .320	.045 .030	1/16" x 45°	.7500-16 UNJF-3A	.625	7/16-SP	19,100	129,800	75,500	27,900
28	15/16	1.372 1.331	1.315	.9365 .9355	.8680 .8610	.250	.385 .370	.050 .035	5/64" x 45°	.8750-14 UNJF-3A	.725	1/2-SP	31,500	172,600	101,800	37,700
32	17/16	1.552 1.512	1.500	1.0615 1.0605	.9930 .9860	.300	.435 .420	.060 .045	5/64" x 45°	1.0000-12 UNJF-3A	.830	9/16-SP	38,200	220,200	132,100	48,900

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

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



VIEW A

HI-LITE™ THREAD TRANSITION AREA. THIS AREA OF SPECIAL CONFIGURATION.

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions in inches and to be met after finish.

① 3. Surface texture per ASME B46.1.

4. Hole preparation per NAS618.

⑤ The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.

6. Oversize replacement for HPL738, HPL838 and HPL938.

MATERIAL: Nickel Base Alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: HPL1738BP() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, with color blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 391, except fatigue loads as tabulated.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HPL1738 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

HOW TO ORDER

① **EXAMPLE:**

Pin Part Number
HPL1738BP20-34

34/16 or 17/8 Maximum Grip Length
20/32 or 11/16 Nominal Diameter Pin
Finish Code
Pin Basic Part Number

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

DRAWN BY J.F. OBISPO	DATE 2004-03-15	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/16 OVERSIZE SPECIAL HIGH INTERFERENCE FIT
APPROVED M. CAWLEY	DATE 2004-03-15	
REVISION ①	DATE K. TRAN 2017-12-11	DRAWING NUMBER HPL1738