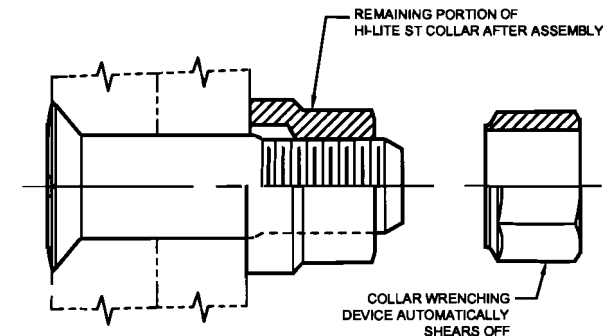
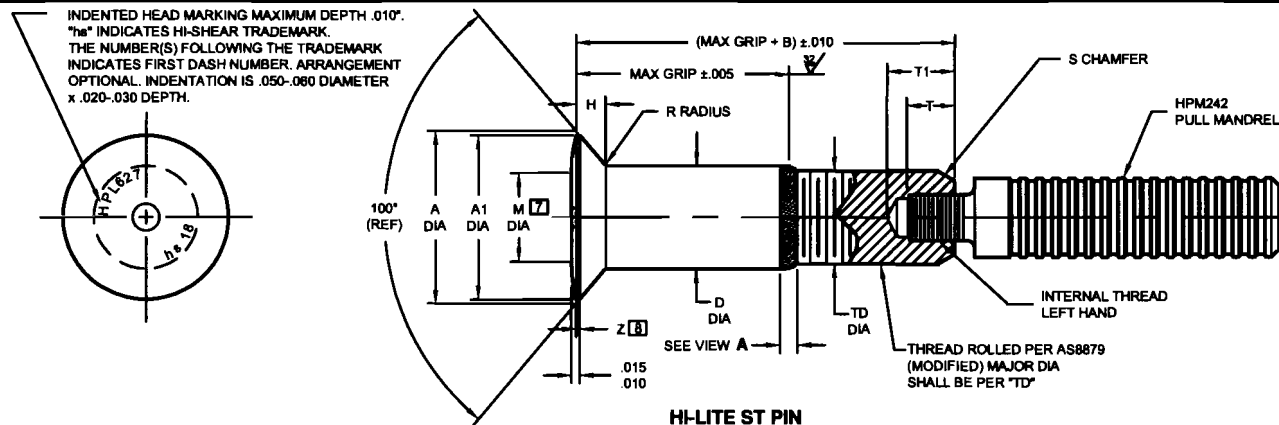




HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	A1 DIA	B REF	D DIA WITHOUT COATING OR SOLID FILM	D1 DIA REF	TD DIA	F	H	K MAX	M DIA FLAT	R RAD	Z MAX	S CHAMFER REF	THREAD	INTERNAL THREAD LEFT HAND ③			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
																T MIN	T1 MAX	THREAD SIZE		
18	37/64	.8380 .8310	.830 .806	.770	.5771 .5766	.571	.5550 .5500	.010	.1094 .1065	.039	.505 .475	.050 .040	.022	1/16" x 37"	9/16-18UNJF-3A Modified	.280	.456	.312-24UNJF-3B	57,000 49,700	17,000
20	41/64	.9250 .9180	.917 .893	.825	.6396 .6391	.634	.6180 .6120	.010	.1197 .1168	.044	.565 .535	.050 .040	.022	1/16" x 37"	5/8-18UNJF-3A Modified	.280	.456	.312-24UNJF-3B	70,050 61,000	21,000

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

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.
- Hole preparation per NAS618.
- Dimensions to be met after finish, except as noted.
- Surface texture per ANSI B46.1.
- Flat permissible within "M" diameter.
- Curved or flat edge manufacturer's option.
- Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
- Use HPL727 for oversize replacement.
- "D" diameter may increase by .0005 after application of solid film lube.

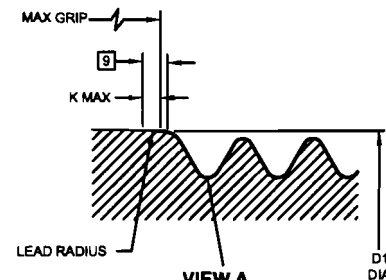
CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HPL627 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 mandrell.

**HOW TO ORDER
EXAMPLE:**

Pin Part Number Only
HPL627DL18-8A

Assembled with HPM Pull Mandrel (Optional)
8/16 or 1/2 Maximum Grip Length
18/32 or 9/16 Nominal Diameter Pin
Finish
Pin Part Number



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

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HPL627AP() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294,
and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL627DL() = 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.

U.S. Patents 4,326,625; 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	DATE	TITLE
J.F.O.	7-29-92	HI-LITE® ST™ PIN
APPROVED	DATE	
DAW	7-30-92	100° FLUSH SHEAR CROWN HEAD TITANIUM, SPECIAL THREAD 1/16 GRIP VARIATION, 1/64 OVERSIZE
REVISION	DATE	DRAWING NUMBER
③	J.F. Obispo 3-3-14	HPL627