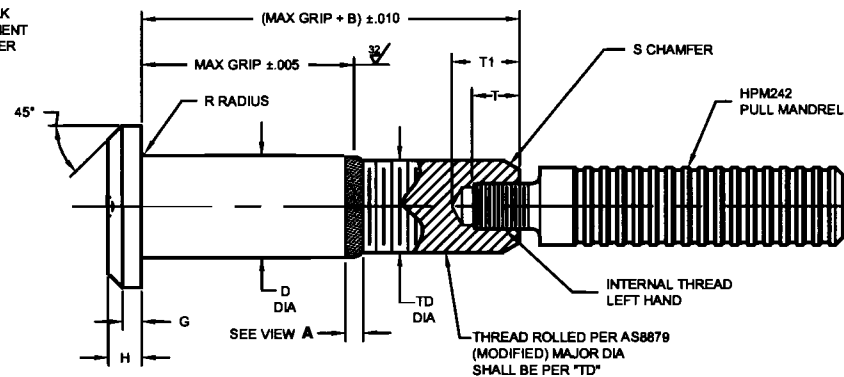
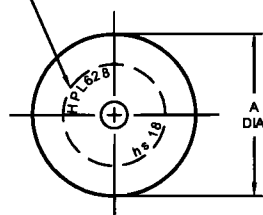
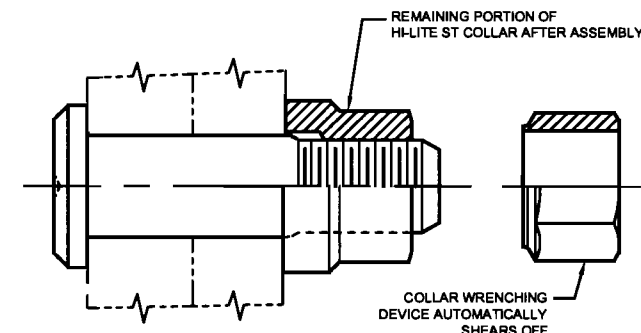


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER, ARRANGEMENT
OPTIONAL INDENTATION IS .050-.060 DIAMETER
x .020-.030 DEPTH.



HI-LITE ST PIN



HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA WITHOUT COATING OR SOLID FILM	D1 DIA REF	TD DIA	G REF	H	K MAX	R RAD	S CHAMFER REF	THREAD	INTERNAL THREAD LEFT HAND ⑤			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
													T MAX	T1 MAX	THREAD SIZE		
18	37/64	.877 .842	.770	.5771 .5766	.571	.5550 .5500	.115	.210 .200	.039	.040 .025	1/16" x 37°	9/16-18UNJF-3A Modified	.300	.456	.312-24UNJF-3B	57,000 49,700	32,400
20	41/64	.953 .905	.825	.6396 .6391	.634	.6180 .6120	.130	.238 .228	.044	.040 .025	1/16" x 37°	5/8-18UNJF-3A Modified	.300	.456	.312-24UNJF-3B	70,050 61,000	41,000
24	49/64	1.150 1.110	1.050	.7648 .7641	.759	.7430 .7370	.200	.335 .320	.044	.045 .030	1/16" x 37°	3/4-16UNJF-3A Modified	.350	.480	.375-24UNJF-3B	95,200 83,900	59,500

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
2. Dimensions to be met after finish, except as noted.
3. Surface texture per ANSI 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 HPL728 for oversize replacement.

MATERIAL:

8AL-4V titanium alloy per AMS4926 or AMS4967.

HEAT TREAT:

95,000 psi shear minimum.

FINISH:

HPL628AP() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL628DL() = 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.

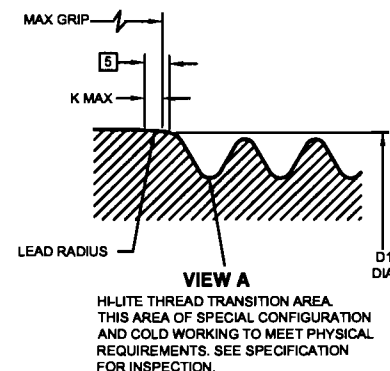
CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HPL628 indicates 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
EXAMPLE:**

Pin Part Number Only
HPL628DL18-8A
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

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



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

U.S. Patents 4,326,825; 4,485,510, 4,957,401 and 6,665,922 Other U.S. and international patents pending. "Hi-Lite" and "Pull-In" are registered trademarks and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.	
DRAWN J.F.O.	DATE 7-29-92
APPROVED DAW	DATE 7-30-92
REVISION 5	DATE J.F. Obispo 2-26-14
TITLE PULL-IN® HI-LITE® ST™ PIN PROTRUDING TENSION HEAD TITANIUM, SPECIAL THREAD 1/16 GRIP VARIATION, 1/64 OVERSIZE DRAWING NUMBER HPL628	