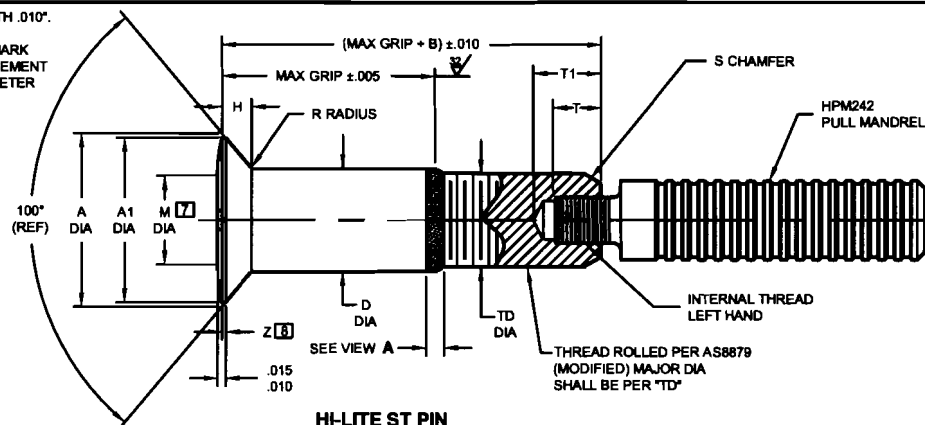
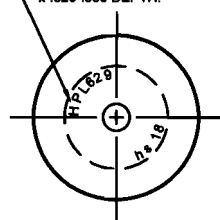
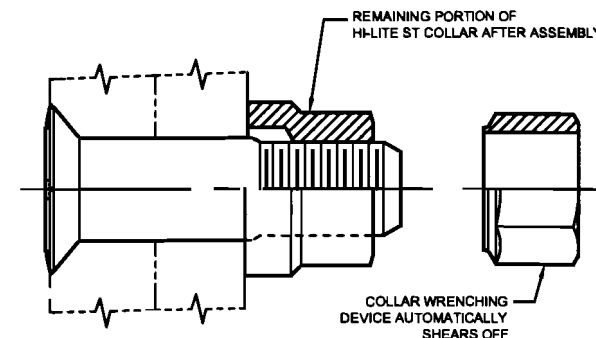


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER. ARRANGEMENT
OPTIONAL. INDENTATION IS .050-.080 DIAMETER
x .020-.030 DEPTH.



HI-LITE ST PIN



HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	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	1.0337	1.027	.770	.5771	.571	.5550	.010	.1916	.039	.505	.050	.022	1/16" x 37°	9/16-18UNJF-3A Modified	.280	.456	.312-24UNJF-3B	57,000	24,700
20	41/64	1.1230	1.116	.825	.6396	.634	.6180	.010	.2028	.044	.565	.050	.022	1/16" x 37°	5/8-18UNJF-3A Modified	.280	.456	.312-24UNJF-3B	70,050	29,600
		1.1158	1.091		.6391		.6120		.1998		.535	.040							61,000	

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 HPL729 for oversize replacement.
- "D" diameter may increase by .0005 after application of solid film lube.

MATERIAL:

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

HEAT TREAT:

95,000 psi shear minimum.

FINISH:

HPL629AP() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL629DL() = Kalgard FA or EM620C solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

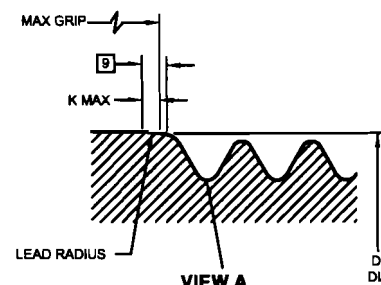
Hi-Lite Product Specification 391.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HPL629 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 EXAMPLE:

Pin Part Number Only
HPL629DL18-8A
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



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 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 J.F.O.	DATE 7-29-92
APPROVED DAW	DATE 7-30-92
REVISION ③	DATE J.F. Obispo 3-3-14
TITLE HI-LITE® ST™ PIN 100° FLUSH CROWN (MS20426) HEAD TITANIUM, SPECIAL THREAD 1/16 GRIP VARIATION, 1/64 OVERSIZE DRAWING NUMBER HPL629	