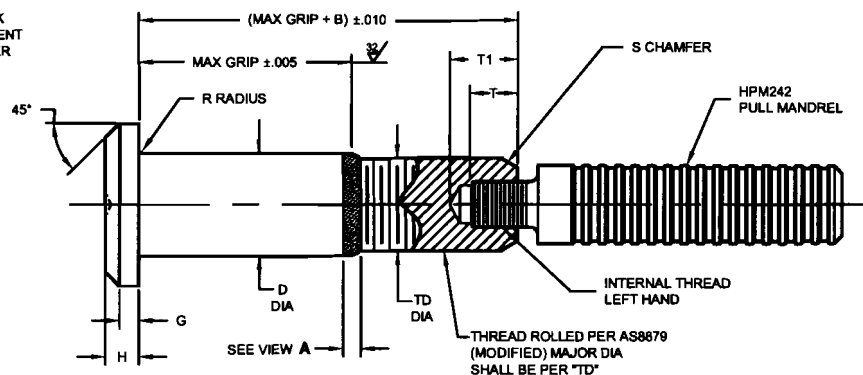
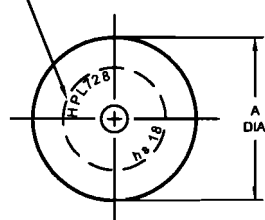
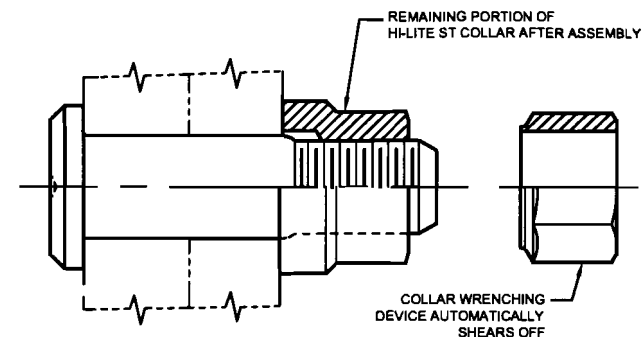


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER. ARRANGEMENT
OPTIONAL. INDENTATION IS .050-.060 DIAMETER
x .020-.030 DEPTH.



HI-LITE ST PIN



HI-LITE ST PIN AND COLLAR AFTER ASSEMBLY

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

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 ③			DOUBLE SHEAR POUNDS	TENSION POUNDS MINIMUM
													T MAX	T1 MAX	THREAD SIZE		
18	19/32	.905 .870	.770	.5927 .5922	.587	.5550 .5500	.115	.210 .200	.039	.040 .025	1/16" x 37°	9/16-18UNJF-3A Modified	.300	.456	.312-24UNJF-3B	62,000 52,400	32,400
20	21/32	.975 .940	.825	.6552 .6547	.649	.6180 .6120	.130	.238 .228	.044	.040 .025	1/16" x 37°	5/8-18UNJF-3A Modified	.300	.456	.312-24UNJF-3B	73,500 64,100	41,000

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIM.
- Dimensions to be met after finish, except as noted.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Lead radius must be tangent to "D" diameter within "K" distance and be continuous within this area.
- "D" diameter may increase by .0005" after application of solid film lube and .001" after aluminum coating.
- Oversize replacement for HPL528 and HPL628.

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

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HPL728AP() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL728DL() = Kalgard FA or EM620C solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.

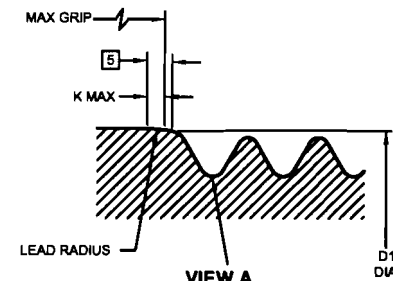
SPECIFICATION: Hi-Lite Product Specification 391.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HPL728 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
HPL728DL18-8A
└─ 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



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

U.S. Patents 4,326,625; 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.		TITLE PULL-IN® HI-LITE® ST™ PIN PROTRUDING TENSION HEAD TITANIUM, SPECIAL THREAD 1/16 GRIP VARIATION, 1/32 OVERSIZE	
DRAWN J.F.O.	DATE 7-29-92	DRAWING NUMBER HPL728	
APPROVED DAW	DATE 7-30-92		
REVISION ③	DATE J.F. Obispo 02-26-14		