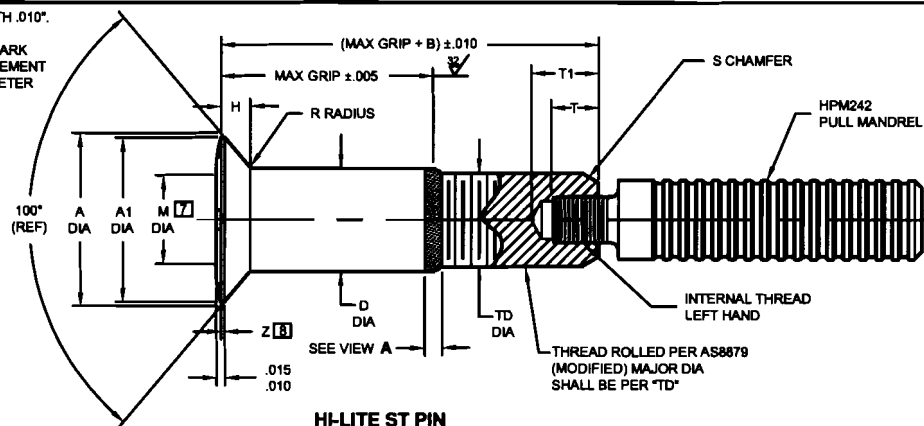
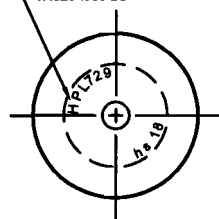
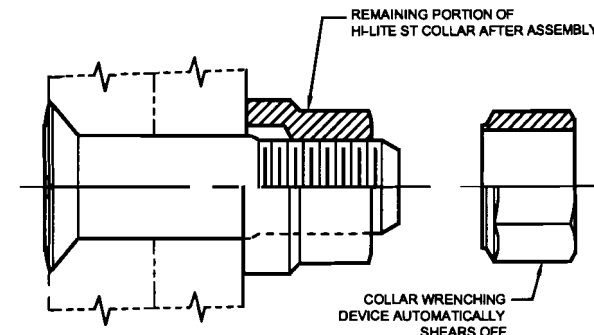


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST DASH NUMBER. ARRANGEMENT
OPTIONAL. INDENTATION IS .050-.080 DIAMETER
x .020-.030 DEPTH.



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	19/32	1.0337 1.0266	1.027 1.002	.770	.5927 .5922	.587	.5550 .5500	.010	.1850 .1820	.039	.505 .475	.050 .040	.022	1/16" x 37"	9/16-18UNJF-3A Modified	.280	.456	.312-24UNJF-3B	60,200 52,400	24,700
20	21/32	1.1230 1.1158	1.116 1.091	.825	.6552 .6547	.649	.6180 .6120	.010	.1963 .1933	.044	.565 .535	.050 .040	.022	1/16" x 37"	5/8-18UNJF-3A Modified	.280	.456	.312-24UNJF-3B	73,500 64,100	29,600

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.
- Oversize replacement for HPL529 and HPL629.
- "D" diameter may increase by .0005 after application of solid film lube.

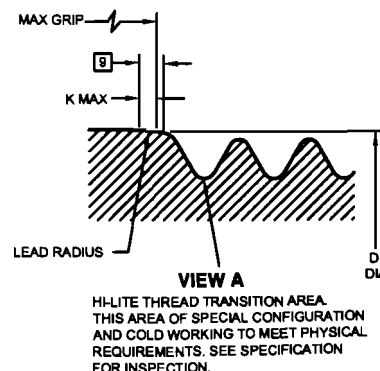
CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HPL729 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
HPL729DL18-8A

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: HPL729AP() = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL729DL() = Galgard 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 4,326,825; 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		DATE		TITLE	
J.F.O.		7-29-92		HI-LITE® ST™ PIN	
APPROVED		DATE		100° FLUSH CROWN (MS20426) HEAD TITANIUM, SPECIAL THREAD 1/16 GRIP VARIATION, 1/32 OVERSIZE	
DAW		7-30-92			
REVISION		DATE		DRAWING NUMBER	
3		J.F.Obispo 3-3-14		HPL729	