



FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS
											T MIN	T1 MAX	THREAD SIZE UNJF-2B	LOAD MAX			
18	9/16	.877 .842	.770	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16" x 37°	.5625-18 UNJF-3A	.280	.456	.3125-24	11,500	47,200	32,400	11,340
20	5/8	.953 .918	.825	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16" x 37°	.6250-18 UNJF-3A	.280	.456	.3125-24	11,500	58,300	41,000	14,350
⑥ 24	3/4	1.150 1.110	1.050	.7490 .7480	.7415 .7370	.200	.335 .320	.045 .030	1/16" x 37°	.7500-16 UNJF-3A	.305	.480	.3750-24	18,000	83,900	59,500	20,830
28	7/8	1.330 1.290	1.210	.8780 .8730	.8663 .8610	.250	.385 .370	.050 .035	5/64" x 37°	.8750-14 UNJF-3A	.325	.500	.3750-24	21,600	107,000	72,400	25,300
32	1	1.510 1.470	1.390	.9930 .9980	.9913 .9860	.300	.435 .420	.060 .045	5/64" x 37°	1.0000-12 UNJF-3A	.380	.575	.3750-24	21,600	140,700	93,500	32,700

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

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS.



VIEW A

HI-LITE™ THREAD TRANSITION AREA. THIS AREA OF SPECIAL CONFIGURATION.

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIM.
 - Dimensions in inches and to be met after finish.
 - ⑥ Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - ⑤ The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.
 - Use HPL858 for oversize replacement.
 - ⑦ After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: 6AL-4V titanium alloy per AMS4928, AMS4967 or British Standard 2TA 28.

HEAT TREAT: 160,000 psi tensile minimum and 95,000 psi shear minimum for sizes up to 3/4. 150,000 psi tensile and 90,000 psi shear minimum for 7/8 and larger.

FINISH: ⑥ ⑦ HPL758AP() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HPL758BM() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 391, except fatigue loads as tabulated.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER
 ⑥ **EXAMPLE:**

Pin Part Number
 HPL758BM18-34
 34/16 or 17/8 Maximum Grip Length
 18/32 or 9/16 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F. OBISPO	DATE 1998-11-18	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD 6AL-4V TITANIUM ALLOY SPECIAL THREAD, 1/16 GRIP VARIATION	
APPROVED E.E.B	DATE 1998-12-15	DRAWING NUMBER HPL758	
REVISION ⑥	DATE K. TRAN 2017-12-11	1 OF 1	