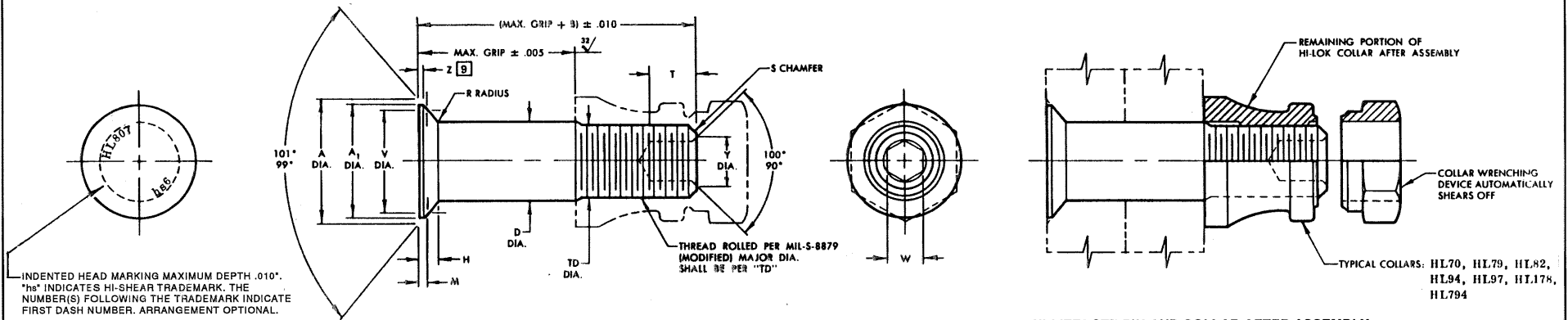


hi-shear
CORPORATION

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HI-LITE® ST™ PIN

HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	NOM. DIA.	A DIA. MAX.	A' DIA. MIN.	B REF.	D DIA.	TD DIA.	1 F	H REF.	M GAGE PROT.	R RAD. COLD WORKED	V GAGE DIA.	7 Z MAX.	S CHAMFER REF.	THREAD	INTERNAL THREAD LEFT HAND				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION FATIGUE POUNDS MAXIMUM
															T MIN.	T _i	THREAD SIZE	8 LOAD MAX.			
18	9/16	.9300	.881	.610	.5927 .5917	.5550	.010	.140	.0533 .0485	.050 .040	.8012 .8010	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.240	.340 .320	1/4-28UNJF-2B	9,450	59,600	24,600	8,600
20	5/8	1.0440	.995	.650	.6552 .6542	.6180 .6120	.010	.161	.0633 .0589	.050 .040	.8902 .8900	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.240	.340 .320	1/4-28UNJF-2B	9,450	72,800	31,000	10,850
24	3/4	1.3000	1.251	.905	.7802 .7792	.7430 .7370	.012	.215	.0776 .0716	.050 .040	1.1124 1.1122	.022	1/16" x 45°	3/4-16UNJF-3A Modified	.260	.385 .365	3/8-24UNJF-2B	14,175	103,300	48,000	16,800
28	7/8	1.5091	1.461	1.010	.9052 .9042	.8680 .8610	.014	.250	.0694 .0622	.050 .040	1.3440 1.3438	.022	5/64" x 45°	7/8-14UNJF-3A Modified	.380	.500 .480	3/8-24UNJF-2B	21,600	138,500	65,000	22,750
32	1	1.7201	1.671	1.170	1.0302 1.0292	.9930 .9860	.014	.285	.0617 .0536	.050 .040	1.5732 1.5730	.022	5/64" x 45°	1-12UNJF-3A Modified	.450	.575 .555	3/8-24UNJF-2B	21,600	179,500	85,000	29,750

GENERAL NOTES:

- Head edge out of roundness shall not exceed "F".
- Concentricity: Conical surface of head to "D" diameter within .005 FIR.
- "H" is dimensioned from maximum "D" diameter.
- Dimensions in inches and to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Curved or flat edge manufacturer's option.
- The maximum allowable installation load must not exceed the maximum load values in table or thread failure may occur.

MATERIAL: Alloy steel per MIL-S-5000, MIL-S-5626 or MIL-H-6049.

HEAT TREAT: 108,000 psi shear minimum (180,000-200,000 psi tensile per MIL-H-6875).

FINISH:

HPL807(-)(-) = Cadmium plate per QQ-P-416, Type II, Class 2, with color code black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HPL807BJ(-)(-) = I.V.D. aluminum coating per MIL-C-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.

HPL807CE(-)(-) = I.V.D. aluminum coating per MIL-C-83488, Type II (.00015-.00045 thick), with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HPL807CG(-)(-) = Cadmium plate per QQ-P-416, Type II, Class 2, with color green on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 391, except as noted.

CODE:

First dash number indicates nominal diameter in 1/32nds. Which HPL807 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

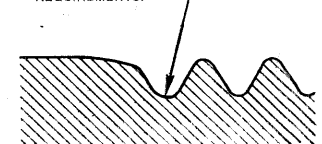
HOW TO ORDER EXAMPLES:

Pin Part Number Only
HPL807CE-18-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ 18/32 or 9/16 Nominal Diameter Pin
└─ Finish
└─ Pin Part Number

HOW TO ORDER EXAMPLES:

Pin and Collar Assembly Part Number Combination
HPL807CE79-18-8
└─ Size and Grip Length, See Above Example
└─ Collar Part Number
└─ Pin Part Number

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



VIEW A
HI-LITE THREAD TRANSITION AREA.
SEE SPECIFICATION FOR INSPECTION.

U.S. Patents 4,326,825; 4,485,510 and 4,957,401.
Other U.S. and foreign patents pending.
"Hi-Lite" is a registered trademark and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.

DRAWN DATE JRH 12-9-97		TITLE HI-LITE® ST™ PIN 100° FLUSH SPECIAL SHEAR HEAD ALLOY STEEL 1/16" GRIP VARIATION; 1/32" OVS	
APPROVED DATE me 12-9-97		DRAWING NUMBER HPL807	
REVISION DATE			