



FIRST DASH NO.	PIN NOM DIA	A DIA	A' DIA	B REF	D DIA	TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
													T MIN	T1 MAX	THREAD SIZE		
18	9/16	1.1408 1.1337	1.133 1.085	.770	.5615 .5605	.5550 .5500	.010	.2430 .2400	.050 .040	.025	1/16 x 45°	.5625-18 UNJF-3A	.280	.456	.312-24UNJF-2B	62,100	43,500
20	5/8	1.2723 1.2651	1.265 1.217	.825	.6240 .6230	.6180 .6120	.010	.2720 .2690	.050 .040	.025	1/16 x 45°	.6250-18 UNJF-3A	.280	.456	.312-24UNJF-2B	76,700	54,600

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 are in inches and to be met after finish.
 - Surface texture per ASME B46.1.
 - Curved or flat edge manufacturer's option.
 - Lead radius must be tangent to "D" diameter at maximum grip.
 - Use HPL833 for oversize replacement.
 - After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 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: Nickel Base Alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

- FINISH:**
- HPL823AP () = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HPL823AG () = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HPL823DL () = 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. 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
HPL823DL 18-8A
└─ Assembled with HPM Pull Mandrel (Optional)
└─ 8/16 or 1/2 Maximum Grip Length
└─ 18/32 or 9/16 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic 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

"HI-KOTE", "HI-LITE", "PULL-IN" AND "HPL" ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F. OBISPO	DATE 1996-04-01	TITLE PULL-IN™ PIN 100° FLUSH (MS24694) TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) SPECIAL THREAD 1/16 GRIP VARIATION	
APPROVED J. RAUSCH	DATE 1996-04-02	DRAWING NUMBER HPL823	
REVISION 8	DATE F. CARINGELLA 2019-10-31	1 OF 1	