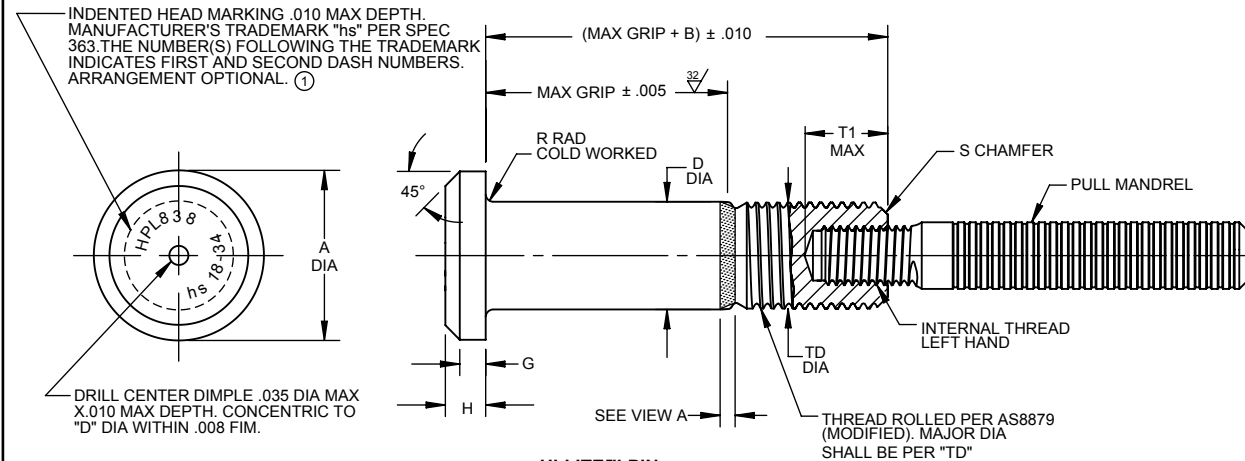




HI-LITE™ PIN

①

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 ⑤			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS
											T1 MAX	THREAD SIZE UNJF-2B	LOAD MAX			
18	37/64	.877 .842	.844	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.465	5/16-SP	11,500	65,600	35,400	13,100
20	41/64	.953 .918	.935	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.520	3/8-SP	14,200	80,600	44,800	16,600
24	49/64	1.150 1.110	1.125	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 45°	.7500-16 UNJF-3A	.625	7/16-SP	19,100	115,100	75,500	27,900
28	57/64	1.330 1.290	1.315	.8896 .8886	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 45°	.8750-14 UNJF-3A	.725	1/2-SP	31,500	154,700	101,800	37,700
32	1-1/64	1.510 1.470	1.500	1.0146 1.0136	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 45°	1.000-12 UNJF-3A	.830	9/16-SP	38,200	201,200	132,100	48,900

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIM.
 - Dimensions in inches and to be met after finish.
 - ① 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 HPL938 for oversize replacement.

MATERIAL: Nickel Base Alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

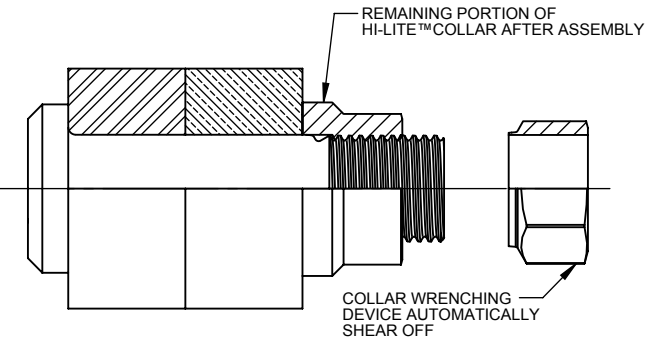
FINISH: HPL838BP()-() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, with color blue on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

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

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HPL838 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER
 ① **EXAMPLE:**

Pin Part Number
 HPL838BP18-34
 34/16 or 17/8 Maximum Grip Length
 18/32 or 9/16 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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.

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F.OBISPO	DATE 2004-03-15	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/64 OVERSIZE SPECIAL HIGH INTERFERENCE FIT	
APPROVED M.CAWLEY	DATE 2004-03-15	DRAWING NUMBER HPL838	
REVISION ①	DATE F.CARINGELLA 2017-12-11	1 OF 1	