

HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

HI-LITE™ PIN

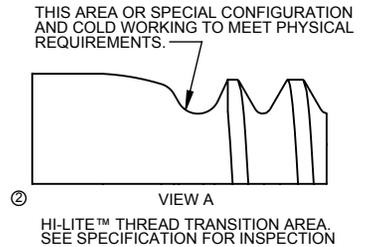
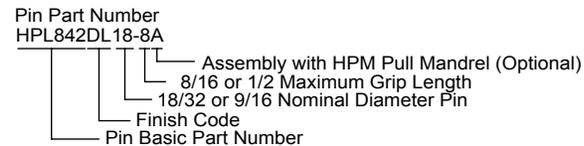
FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
											T MAX	T1 MAX	THREAD SIZE		
18	19/32	.905 .870	.770	.5927 .5917	.5550 .5500	.115	.210 .200	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.300	.456	.312-24UNJF-2B	69,200	43,500
20	21/32	.975 .940	.825	.6552 .6542	.6180 .6120	.130	.238 .228	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.300	.456	.312-24UNJF-2B	84,500	54,600

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIR.
 2. Dimensions are in inches and to be met after finish.
 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 5. Lead radius must be tangent to "D" diameter at max grip.
 6. Oversize replacement for HPL822 and HPL832.
 7. 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.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HPL842 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
 2 EXAMPLE:



MATERIAL: Nickel Base Alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: 2 HPL842DL()-() = KALGARD FA or EM620C solid film lube per AS5272, Type I, and cetyl alcohol lube per Hi-Shear Spec. 305.

7 HPL842AG()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

7 HPL842AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 391.

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY	DATE	TITLE	
J.F.OBISPO	1995-08-08	HI-LITE™ PIN PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) SPECIAL THREAD 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED	DATE	DRAWING NUMBER	
J.RAUSCH	1995-08-09	HPL842	
REVISION	DATE	1 OF 1	
2	F.CARINGELLA 2017-12-11		