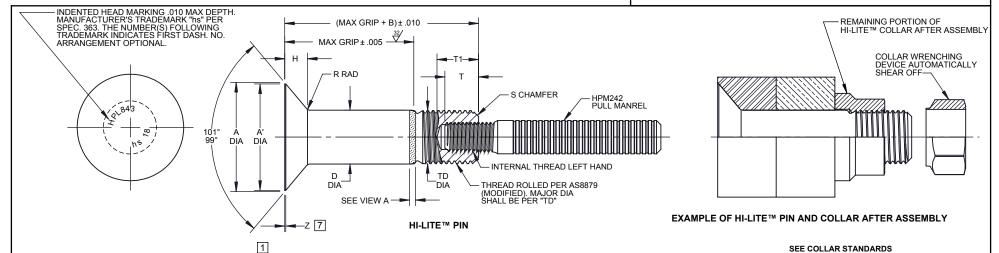
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A

HI-SHEAR Corporation, USA a LISI AEROSPACE Company

Design Holder

CAGE No. 73197

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INTERNAL THREAD LEFT HAND **DOUBLE** FIRST s TENSION SHEAR Δ' В D TD R z Α THREAD MODIFIED DASH NOM F н CHAMFER **POUNDS POUNDS** RFF T1 DIA DIA DIA DIA RAD MAX NO DIA THREAD SIZE REF MINIMUM MINIMUM MIN MAX .050 .5625-18 UNJF-3A .1408 | 1.133 .5927 .5550 .2300 18 37/64 .770 .010 .025 1/16 x 45° 300 .456 .312-24UNJF-2B 69,200 43,500 1337 1.085 .5917 5500 2270 .040 1.2723 1.265 .6552 .6180 2589 .050 .6250-18 UNJF-3A 20 .825 .010 .025 1/16 x 45° 300 .456 .312-24UNJF-2B 84.500 54.600 41/64 .2651 1.217 .6542 .6120 .2559 .040

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

- GENERAL NOTES: 1 Head edge out of roundness shall not exceed "F".
  2. Concentricity: Conical surface of head to "D" diameter within .005 FIR.
  - 3. "H' is dimensioned from maximum "D" diameter.
  - 4. Hole preparation per NAS618.
  - 5. Dimensions are in inches and to be met after finish.
  - 6. Surface texture per ASME B46.1.

**HOW TO ORDER EXAMPLE:** 

7 Curved or flat edge manufacturer's option.

8. Lead radius must be tangent to "D" diameter at maximum grip.

9. Oversize pin for HPL823 and HPL833.

[10] 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: HPL843DL()-() = KALGARD FA or EM620C solid film lube per AS5272. Type I

and cetyl alcohol lube per Hi-Shear Spec. 305.

10 HPL843AG()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294,

with color code orange on thread end and cetyl alcohol

lube per Hi-Shear Spec. 305.

10 HPL843AP()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294,

and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 391.

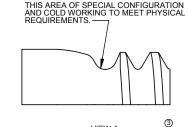
CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HPL843 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.

See "Finish" note for explanation of code letters.
Code letter "A" following second dash number indicates assembly with HPM pull mandrell.

Pin Part Number HPL843DL18-8A

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



VIEW A

HI-LITE™ THREAD TRANSITION AREA. SEE SPECIFICATION FOR INSPECTION

## "HI-LITE", "HPL", AND "HI-KOTE". ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY	DATE	TITLE
J.F.OBISPO	1996-04-17	HI-LITE™ PIN 100° FLUSH (MS24694) TENSION HEAD
APPROVED	DATE	NICKEL BASE ALLOY (INCONEL)
J.RAUCH	1996-04-24	SPECIAL THREAD
		1/16 GRIP VARIATION, 1/32 OVERSIZE
DEMICION	DATE	000000000000000000000000000000000000000

F.CARINGELL 2019-04-22

**HPL843** 

1 OF 1