



HI-LITE™ PIN

HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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-FATIGUE POUNDS
											T MIN	T1 MAX	THREAD SIZE UNJF-2B	LOAD MAX			
18	37/64	.877 .842	.770	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.280	.456	.3125-24	11,500	49,700	32,400	11,340
20	41/64	.953 .918	.825	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.280	.456	.3125-24	11,500	61,000	41,000	14,350
24	49/64	1.150 1.110	1.050	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.305	.480	.3750-24	18,000	82,600	59,500	20,830
28	57/64	1.330 1.290	1.210	.8896 .8886	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.325	.500	.3750-24	21,600	111,900	72,400	25,300
32	1-1/64	1.510 1.470	1.390	1.0146 1.0136	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 37°	1.000-12 UNJF-3A	.380	.575	.3750-24	21,600	145,500	93,500	32,700

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.

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions in inches and to be met after finish.
 3. Surface texture per ASME B46.1.
 4. 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.
 6. Use HPL958 for oversize replacement.
 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.

MATERIAL: 6Al-4V titanium alloy per AMS4928, AMS4967 or British Standard 2TA 28.

HEAT TREAT: 160,000 psi tensile minimum and 95,000 psi shear minimum for sizes up to 3/4. 150,000 psi tensile and 90,000 psi shear minimum for 7/8 and larger.

FINISH: [5] HPL858AP()-() = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HPL858BM()-() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, with color white 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 HPL858 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER

EXAMPLE: Pin Part Number
 HPL858BM18-34
 34/16 or 17/8 Maximum Grip Length
 18/32 or 9/16 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

"HI-LITE", "HST", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F.OBISPO	DATE 1998-11-18	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD 6AL-4V TITANIUM ALLOY SPECIAL THREAD 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED E.E.B.	DATE 1998-12-15		
REVISION [5]	DATE F.CARINGELLA 2017-12-11	DRAWING NUMBER HPL858	