



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 ROLLED	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND ⑤			
											T MIN	T1	THREAD SIZE	LOAD MAX
24	3/4	1.150 1.110	.895	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.260	.385 .365	3/8-24UNJF-2B	14,175
28	7/8	1.330 1.290	1.000	.8740 .8730	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.380	.500 .480	3/8-24UNJF-2B	21,600
32	1	1.510 1.470	1.160	.9990 .9980	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 37°	1.0000-12 UNJF-3A	.450	.575 .555	3/8-24UNJF-2B	21,600

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions in inches and to be met after finish.
 - ③ 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 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: Anneal per Hi-Shear Spec. 391-1.

FINISH: ⑥ HPL956AP() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 ⑥ HPL956KM() = HI-KOTE™ 1 aluminum pigmented 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 391-1, except as noted.⑧

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 ⑧ EXAMPLES:

Pin Part Number
 HPL956KM24-8A
 L Assembled with HPM Pull Mandrel (Optional)
 L 8/16 or 1/2 Maximum Grip Length
 L 24/32 or 3/4 Nominal Diameter Pin ⑧
 L Finish Code
 L Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
 HPL956KM1087-18-8
 L Size and Grip Length,
 L See Above Example
 L Collar Part Number
 L Pin Part Number

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS.



VIEW A

HI-LITE™ THREAD TRANSITION AREA.
 THIS AREA OF SPECIAL CONFIGURATION.

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

"HI-LITE", "HST", AND "HI-KOTE",
 ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY J.OBISPO	DATE 1991-10-08	TITLE HI-LITE™ PIN PROTRUDING TENSION HEAD TITANIUM ALLOY (ANNEALED) 1/16 GRIP VARIATION
APPROVED DAW	DATE 1991-10-10	
REVISION ⑧	DATE F.CARINGELLA 2017-12-11	DRAWING NUMBER HPL956