



PULL-IN™ PIN AND MANDREL

PULL-IN™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	K MAX	R RAD	S CHAMFER REF	THREAD	INTERNAL THREAD LEFT HAND				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												T MIN	T1	THREAD SIZE	LOAD MAX.		
14	7/16	.676 .641	.635	.4370 .4360	.4310 .4260	.045	.105 .093	.035	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	.200	.287 .267	.2188-28 UNJF-2B	-	28,600	12,100
16	1/2	.770 .735	.685	.4995 .4985	.4930 .4880	.050	.115 .103	.039	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	.230	.325 .305	.2500-28 UNJF-2B	6,500	37,300	15,300
18	9/16	.864 .829	.770	.5615 .5605	.5550 .5500	.055	.127 .112	.039	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.240	.345 .325	.3125-24 UNJF-2B	9,450	47,200	19,000
20	5/8	.953 .918	.825	.6240 .6230	.6180 .6120	.060	.137 .122	.044	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.270	.373 .353	.3750-24 UNJF-2B	9,450	58,300	23,000
24	3/4	1.108 1.066	1.050	.7490 .7480	.7430 .7370	.070	.151 .136	.044	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.360	.482 .462	.3750-24 UNJF-2B	14,175	83,900	30,700
28	7/8	1.285 1.241	1.210	.8740 .8730	.8680 .8610	.090	.187 .172	.045	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.360	.482 .462	.3750-24 UNJF-2B	21,600	114,000	45,000
32	1	1.468 1.424	1.390	.9990 .9980	.9930 .9860	.110	.218 .203	.045	.060 .045	5/64 x 37°	1.0000-12 UNJF-3A	.450	.616 .596	.3750-24 UNJF-2B	21,600	149,000	60,900

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

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 failure may occur.

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.

HOW TO ORDER

EXAMPLE:

Pin Part Number
HPL10AP18-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ 18/32 or 9/16 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number

MATERIAL:

6AL-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT:

95,000 psi shear minimum.

FINISH:

HPL10AP() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL10AZ() = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, with color code black on the thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION:

PULL-IN™ Product Specification 391.

"HI-KOTE", "HI-LITE", "PULL-IN" AND "HPL", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F.O.	DATE 1995-08-08	TITLE HI-LITE™ PULL-IN™ PIN PROTRUDING SHEAR HEAD TITANIUM SPECIAL THREAD 1/16 GRIP VARIATION	
APPROVED J. RAUSCH	DATE 1995-08-09		
REVISION 8	DATE 2024-01-30	DRAWING NUMBER HPL10	