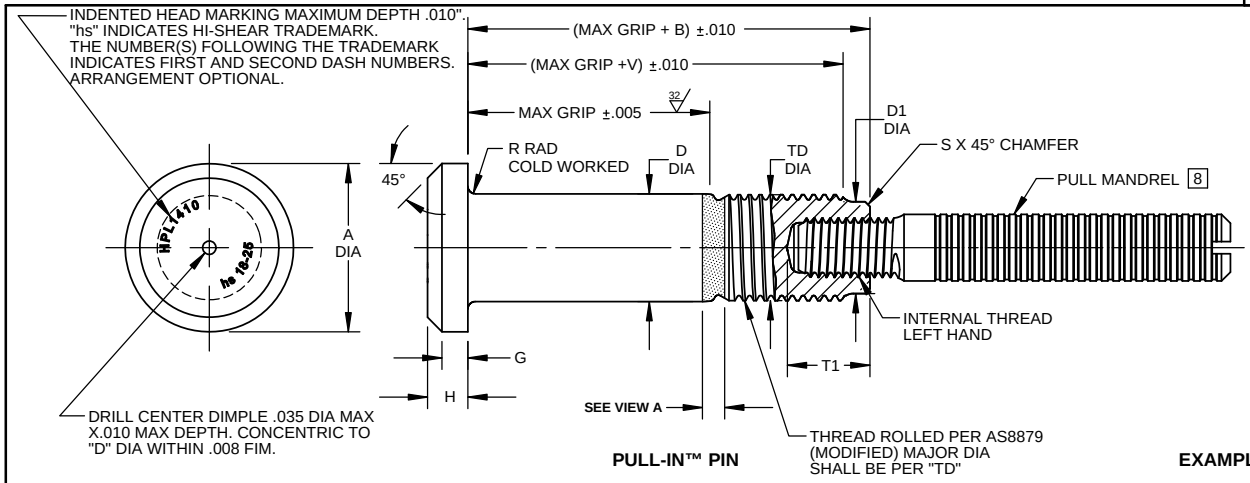
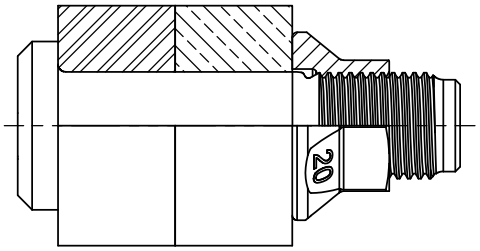
lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company
Design Holder
CAGE No. 73197

① For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



PULL-IN™ PIN



EXAMPLE OF PULL-IN™ PIN AND NUT/COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	D1 DIA	G REF	H	R RAD ROLLED	S CHAMFER REF	V REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND [6]			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS MAX
													T1 MAX	THREAD SIZE UNJF-2B	LOAD POUNDS MAX			
18	9/16	.877 .842	.844	.5615 .5605	.5537 .5500	.4783 .4764	.125	.210 .200	.040 .025	.020	.701	.5625-18 UNJF-3A	.465	5/16-SP	11,500	62,137	44,321	15,700
20	5/8	.953 .918	.935	.6240 .6230	.6165 .6120	.5413 .5394	.140	.238 .228	.040 .025	.020	.733	.6250-18 UNJF-3A	.520	3/8-SP	14,200	76,727	49,458	16,816
24	3/4	1.150 1.110	1.125	.7490 .7480	.7415 .7370	.6575 .6555	.200	.335 .320	.045 .030	.020	.927	.7500-16 UNJF-3A	.625	7/16-SP	19,109	110,410	81,469	28,500
28	7/8	1.330 1.290	1.315	.8740 .8730	.8663 .8610	.7717 .7697	.250	.385 .370	.050 .035	.020	1.021	.8750-14 UNJF-3A	.725	1/2-SP	31,500	150,300	112,121	38,210
32	1	1.510 1.470	1.500	.9990 .9980	.9913 .9860	.8819 .8799	.300	.435 .420	.060 .045	.020	1.151	1.0000-12 UNJF-3A	.830	9/16-SP	38,218	196,300	132,100	48,900

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

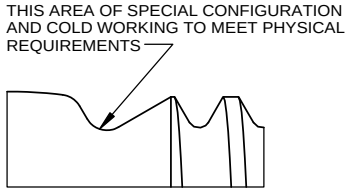
GENERAL NOTES:

1. Concentricity: "A" dia to "D" diameter within .010 FIM.
2. Dimensions in inches and to be met after finish.
① 3. Surface texture per ASME B46.1.
4. Hole preparation per HSL/HPL-IS01: PULL-STEM™/ PULL-IN™ fastener installation specification for HSL/HPL pins.
5. Use HPL1420 for oversize replacement.
[6] The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.
7. Product in accordance with LISI AEROSPACE Product Specification N°415.
[8] Mandrel is sold separately.

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

① **EXAMPLES:** Pin Part Number
HPL1410NAP18-25
- 25/16 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

MATERIAL: Pin = Nickel base alloy (inconel 718) per AMS5662 or AMS5962.

HEAT TREAT: Pin = 220,000 psi tensile minimum and 125,000 psi shear minimum.

FINISH: HPL1410NAP( )-( ) = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

HPL1410NSU( )-( ) = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, with color blue on pin end, and cetyl alcohol lube per Hi-Shear Spec. 305.

"HI-KOTE", "HI-LITE", "PULL-IN" AND "HPL", ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY	DATE	TITLE
F. CARINGELLA	2016-02-09	PULL-IN™ PIN PROTRUDING TENSION HEAD INTERFERENCE FIT NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION
APPROVED	DATE	
C.RIETZ	2016-02-09	
REVISION	DATE	DRAWING NUMBER
① M.BEARD	2017-10-25	**HPL1410** 1 OF 1

HPL1410