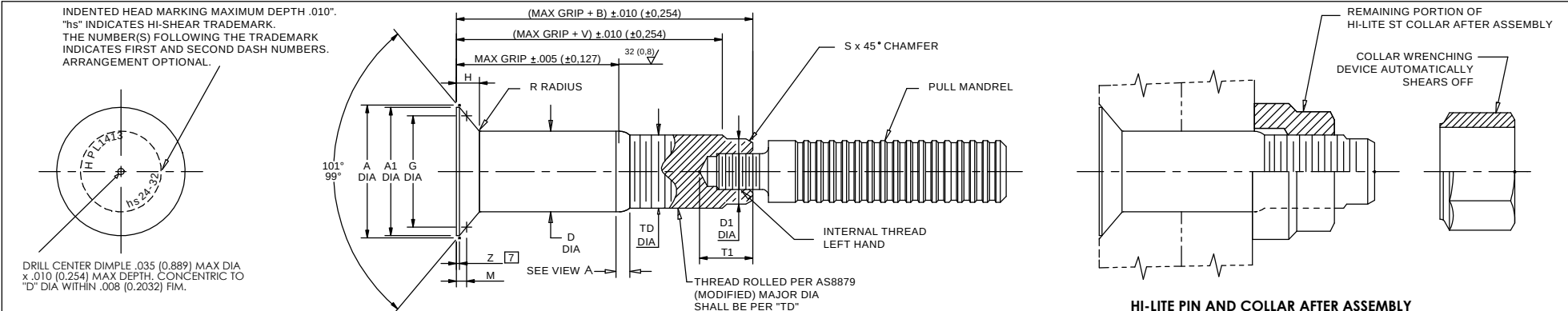


HI-SHEAR CORPORATION, U.S.A.(Patent Holder)CAGE No. 73197 a LISI AEROSPACE Company	BLANC AERO INDUSTRIES U.K.(Licensee) a LISI AEROSPACE Company BLANC AERO INDUSTRIES France(Licensee) a LISI AEROSPACE Company
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1											7																		
FIRST DASH NO.	PIN NOM DIA	A DIA	A1 DIA	B	D DIA		TD DIA		D1 DIA		F	G GAGE DIA		H	M GAGE PROT.		R RAD ROLLED		S	V	Z	THREAD	INTERNAL THREAD LEFT HAND 8			DOUBLE SHEAR STRENGTH		TENSILE STRENGTH	TENSION FATIGUE LOAD
		MAX	MIN	REF	MAX	MIN	MAX	MIN	MAX	MIN		REF	MAX		MIN	REF	MAX	MIN	REF	REF	MAX		T1	THREAD SIZE	LOAD	MIN	MAX	MIN	MAX
																							UNJF-2B	MAX					
24	3/4	1.3000 (33,02)	1.251 (31,78)	1.125 (28,58)	.7490 (19,025)	.7480 (18,999)	.7415 (18,834)	.7370 (18,720)	.6575 (16,700)	.6555 (16,650)	.012 (0,30)	1.1124 (28,255)	1.1122 (28,250)	.229 (5,82)	.0776 (1,971)	.0716 (1,819)	.050 (1,270)	.040 (1,016)	.020 (0,51)	.927 (23,54)	.022 (0,559)	3/4-16UNJF-3A Modified	.625 (15,88)	7/16-SP	17 985 (80 000)	75 000 (333 617)	82 200 (365 644)	41 000 (182 377)	14 300 (63 610)
28	7/8	1.5091 (38,33)	1.461 (37,11)	1.315 (33,40)	.8740 (22,200)	.8730 (22,174)	.8663 (22,003)	.8610 (21,870)	.7717 (19,600)	.7697 (19,550)	.014 (0,36)	1.3440 (34,138)	1.3438 (34,133)	.263 (6,68)	.0694 (1,763)	.0622 (1,580)	.050 (1,270)	.040 (1,016)	.020 (0,51)	1.021 (25,92)	.022 (0,559)	7/8-14UNJF-3A Modified	.725 (18,42)	1/2-SP	25 853 (115 000)	101 900 (453 274)	111 900 (497 756)	52 000 (231 308)	18 200 (80 958)
32	1	1.7201 (43,69)	1.671 (42,44)	1.500 (38,10)	.9990 (25,375)	.9980 (25,349)	.9913 (25,178)	.9860 (25,045)	.8819 (22,400)	.8799 (22,350)	.014 (0,36)	1.5732 (39,959)	1.5730 (39,954)	.298 (7,57)	.0617 (1,567)	.0536 (1,361)	.050 (1,270)	.040 (1,016)	.020 (0,51)	1.151 (29,22)	.022 (0,559)	1-12UNJF-3A Modified	.830 (21,08)	9/16-SP	31 473 (140 000)	133 200 (592 503)	146 100 (649 885)	67 000 (298 031)	20 100 (89 409)

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 (0,127) FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Hole preparation per NAS618.
 - Dimensions in inches (millimeters) and to be met after finish. Strengths and loads are in Lbs (N).
 - Surface texture per ANSI B46.1.
 - Curved or flat edge manufacturer's option.
 - The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.
 - Use HPL1513 for oversize replacement.

MATERIAL: 6AL-4V titanium alloy per AMS4928 or AMS4967

HEAT TREAT: Anneal per Hi-Shear Spec. 391-1

FINISH: HPL1413NKA()-() = HI-KOTE 1 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

HPL1413NKW()-() = HI-KOTE 1 NC aluminum coating per Hi-Shear Spec. 294 with color white on pin end and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE Product Specification 391-1, except as noted.

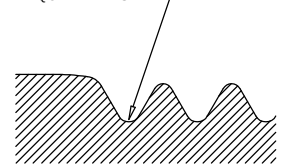
CODE: First dash number indicates nominal diameter in 1/32nds. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

**HOW TO ORDER
EXAMPLES:**

Pin Part Number Only
HPL1413NKA24-32

32/16 or 2 Maximum Grip Length
24/32 or 3/4 Nominal Diameter Pin
Finish
Pin Part Number

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



VIEW A

HI-LITE THREAD TRANSITION AREA
SEE SPECIFICATION FOR INSPECTION

"HI-KOTE", "HI-LITE" and "HPL" are registered trademarks of Hi-Shear Corporation.			
DRAWN	DATE	TITLE HI-LITE® PIN 100° FLUSH SPECIAL SHEAR HEAD TITANIUM (ANNEALED) SPECIAL THREAD, 1/16" GRIP VARIATION SPECIAL HIGH INTERFERENCE FIT	
M. ISEMENE	13-01-2012		
APPROVED	DATE	DRAWING NUMBER HPL1413	
J. GOYER	13-01-2012		
REVISION	DATE		
①	03-02-2012		