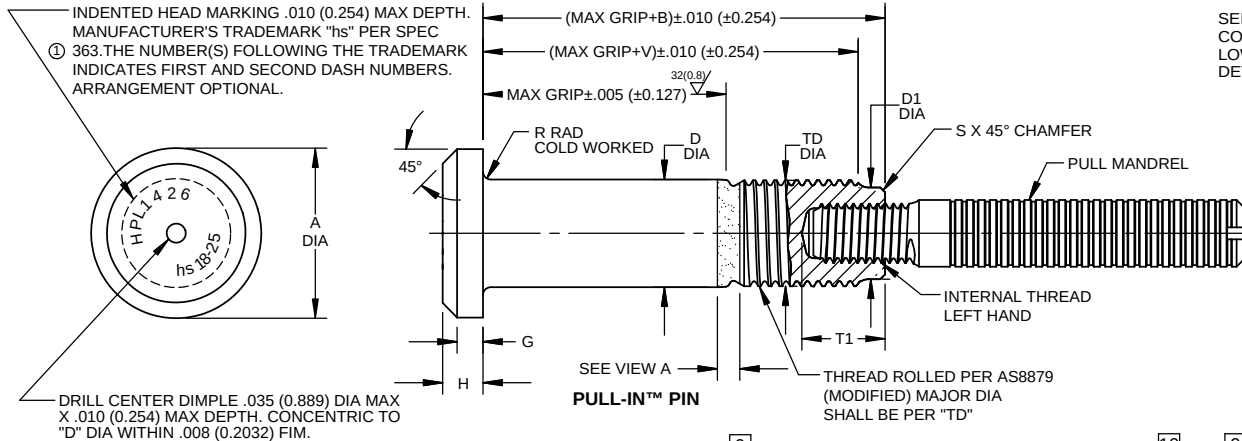
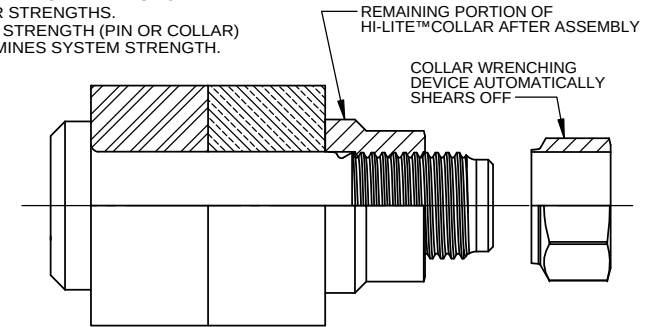


①

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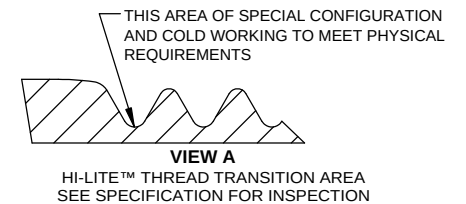


SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.



① PULL-IN™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA		B	D DIA		TD DIA		D1 DIA		G	H		R RAD ROLLED		S CHAMFER	V	THREAD	INTERNAL THREAD LEFT HAND			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION FATIGUE POUNDS MAX
		MAX	MIN		MAX	MIN	MAX	MIN	MAX	MIN		MAX	MIN	MAX	MIN				T1	THREAD SIZE UNJF-2B	LOAD POUNDS MAX			
16	33/64	.770 (19,56)	.735 (18,67)	.685 (17,40)	.5151 (13,084)	.5141 (13,058)	.4930 (12,522)	.4880 (12,395)	N/A		.100 (2,54)	.188 (4,78)	.178 (4,52)	.030 (0,76)	.020 (0,51)	.047 (1,19)	N/A	.5000-20UNJF-3A modified	.325 (8,26)	1/4-SP	8 835 (39 300)	39 600 (176 150)	25 600 (113 874)	8 900 (39 589)
18	37/64	.877 (22,28)	.842 (21,39)	.844 (21,44)	.5771 (14,658)	.5761 (14,633)	.5550 (14,097)	.5500 (13,970)	.4783 (12,150)	.4764 (12,100)	.125 (3,18)	.210 (5,33)	.200 (5,08)	.040 (1,02)	.025 (0,64)	.020 (0,51)	.701 (17,81)	.5625-18UNJF-3A modified	.465 (11,81)	5/16-SP	11 500 (51 155)	49 900 (221 966)	32 400 (144 122)	11 300 (50 265)
20	41/64	.953 (24,21)	.918 (23,32)	.935 (23,75)	.6396 (16,246)	.6386 (16,220)	.6180 (15,697)	.6120 (15,545)	.5413 (13,750)	.5394 (13,700)	.140 (3,56)	.238 (6,05)	.228 (5,79)	.040 (1,02)	.025 (0,64)	.020 (0,51)	.733 (18,63)	.6250-18UNJF-3A modified	.520 (13,21)	3/8-SP	14 200 (63 165)	61 200 (272 231)	41 000 (182 377)	14 400 (64 054)
24	49/64	1.150 (29,21)	1.110 (28,19)	1.125 (28,58)	.7646 (19,421)	.7636 (19,395)	.7430 (18,872)	.7370 (18,720)	.6575 (16,700)	.6555 (16,650)	.200 (5,08)	.335 (8,51)	.320 (8,13)	.045 (1,14)	.030 (0,76)	.020 (0,51)	.927 (23,54)	.7500-16UNJF-3A modified	.625 (15,88)	7/16-SP	19 109 (85 000)	87 400 (388 774)	59 500 (264 669)	21 000 (93 413)
28	57/64	1.330 (33,78)	1.290 (32,77)	1.315 (33,40)	.8896 (22,596)	.8886 (22,570)	.8680 (22,047)	.8610 (21,870)	.7717 (19,600)	.7697 (19,550)	.250 (6,35)	.385 (9,78)	.370 (9,40)	.050 (1,27)	.035 (0,89)	.020 (0,51)	1.021 (25,92)	.8750-14UNJF-3A modified	.725 (18,42)	1/2-SP	31 500 (140 119)	115 000 (511 545)	77 500 (344 737)	28 800 (128 109)
32	1-1/64	1.510 (38,35)	1.470 (37,34)	1.500 (38,10)	1.0146 (25,771)	1.0136 (25,745)	.9930 (25,222)	.9860 (25,045)	.8819 (22,400)	.8799 (22,350)	.300 (7,62)	.435 (11,05)	.420 (10,67)	.060 (1,52)	.045 (1,14)	.020 (0,51)	1.151 (29,22)	1.0000-12UNJF-3A modified	.830 (21,08)	9/16-SP	38 218 (170 000)	145 200 (645 882)	100 900 (448 825)	37 600 (167 253)



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

DRAWN BY F.CARINGELLA	DATE 2016-02-01	TITLE PULL-IN™ PIN PROTRUDING TENSION HEAD INTERFERENCE FIT, TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED C.REITZ	DATE 2016-02-01	
REVISION ①	DATE M.BEARD 2017-11-03	DRAWING NUMBER HPL1426

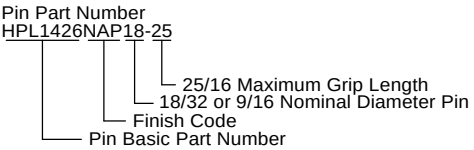
1 OF 2

- GENERAL NOTES:**
1. Concentricity: "A" dia to "D" diameter within .010 (0.254) FIM.
 2. Dimensions in inches (millimeters) and to be met after finish. Strengths and loads are in LBS. (N).
 - 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. HPL1426 is the oversize replacement for HPL1416.
 6. Use HPL1436 for oversize replacement.
 - ⑦ 7. The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.
 8. Product in accordance with LISI AEROSPACE Product Specification N°415.
 - ⑨ 9. For Dash code 16 only: D1 DIA & V not applicable since the pin end is fully threaded.
 - ⑩ 10. For Dash code 16 only: chamfer is as following: S x 37° CHAMFER.

- MATERIAL:** PIN = Titanium alloy 6Al-4V per AMS4928 or AMS4967
- HEAT TREAT:** PIN = 160,000 psi (1103 MPa) tensile minimum and 95,000 psi (655 MPa) shear minimum for size up to 3/4. 150,000 psi (1034 MPa) tensile and 90,000 psi (620 MPa) shear minimum for 7/8 and larger.
- FINISH:** HPL1426BJ()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HPL1426NAP()-() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HPL1426 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER
 ① **EXAMPLE:**



HPL1426