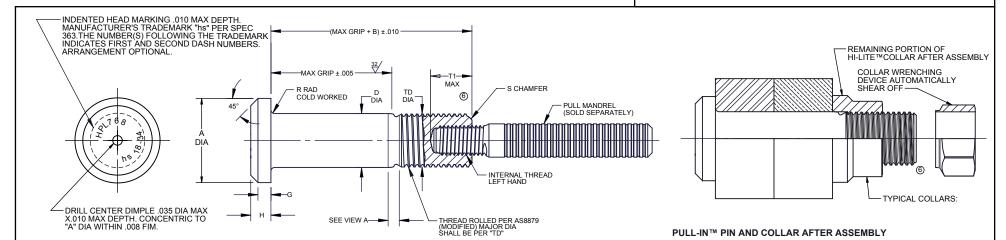
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA a LISI AEROSPACE Company

Design Holder

CAGE No. 73197

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PULL-IN™ PIN

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	н	R RAD	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD 5			DOUBLE SHEAR	TENSION POUNDS	TENSION- TENSION
											T1 MAX	THREAD SIZE UNJF-3B	LOAD MAX	POUNDS MINIMUM	MINIMUM	FATIGUE POUNDS
18	9/16	.877 .842	.844	.5615 .5605	.5537 .5500	.125	.210 .200	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.465	5/16-SP	11,500	47,200	28,350	9,900
20	5/8	.953 .918	.935	.6240 .6230	.6165 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.520	3/8-SP	14,200	58,300	38,360	13,470
24	3/4	1.150 1.110	1.125	.7490 .7480	.7415 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.625	7/16-SP	19,109	83,900	55,600	19,400
28	7/8	1.330 1.290	1.315	.8740 .8730	.8663 .8610	.250	.385 .370	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.725	1/2-SP	31,500	111,100	67,900	25,200
32	1	1.510 1.470	1.500	.9990 .9980	.9913 .9860	.300	.435 .420	.060 .045	5/64 x 37°	1.0000-12 UNJF-3A	.830	9/16-SP	38,200	140,724	88,600	31,912

CODE:

HOW TO ORDER

EXAMPLE:

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

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

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.
- The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.
- 6. Use HPL868 for oversize replacement.

7 After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating 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: 6AI-4V titanium alloy per AMS4928, AMS4967 or British Standard 2TA 28.

HEAT TREAT: 160,000 psi tensile minimum and 95,000 psi shear minimum for sizes up to 3/4.

150,000 psi tensile and 90,000 psi shear minimum for 7/8 and larger.

FINISH: 7 HPL768KM()-() = 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 HS412.

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.

Pin Part Number HPL768KM18-34 -34/16 or 17/8 Maximum Grip Length -18/32 or 9/16 Nominal Diameter Pin -Finish Code Pin Basic Part Number

VIEW A

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

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

DRAWN BY	DATE	TITLE
J.F. OBISPO	2004-03-15	PULL-IN™ PIN
0.1 . 0 5.0. 0	2004-03-13	PROTRUDING TENSION HEAD
		6AL-4V TITANIUM ALLOY
APPROVED	DATE	
M. CAWLEY	2004-03-15	SPECIAL THREAD, 1/16 GRIP VARIATION
		SPECIAL HIGH INTERFERENCE FIT
DEVICION	DATE	DDAMMAIC AU MADED

F.CARINGELLA 2018-10-15

1 OF 1