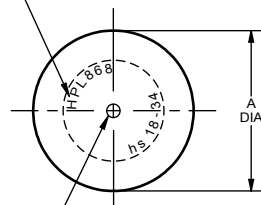
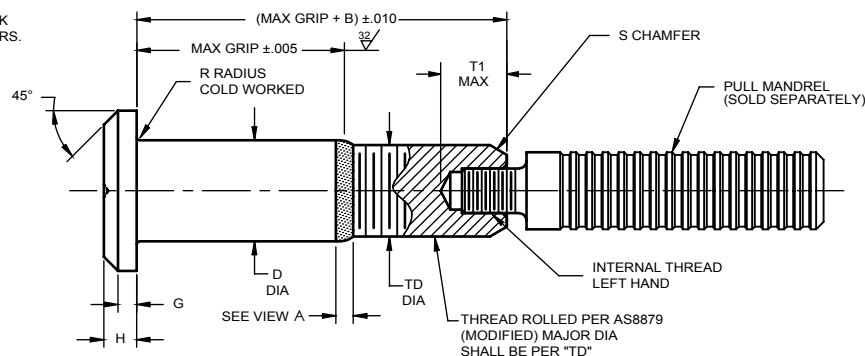


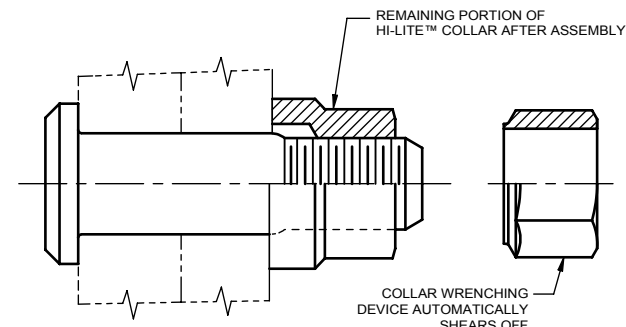
INDENTED HEAD MARKING MAXIMUM DEPTH .010".  
 "hs" INDICATES HI-SHEAR TRADEMARK.  
 THE NUMBER(S) FOLLOWING THE TRADEMARK  
 INDICATES FIRST AND SECOND DASH NUMBERS.  
 ARRANGEMENT OPTIONAL.



DRILL CENTER DIMPLE .035 MAX DIA  
 x .010 MAX DEPTH, CONCENTRIC TO  
 "A" DIA WITHIN .008 FIM.



**PULL-IN™ PIN**

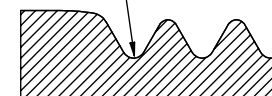


**PULL-IN™ PIN AND COLLAR AFTER ASSEMBLY**

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND [5]			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS
											T1 MAX	THREAD SIZE UNJF-3B	LOAD MAX			
18	37/64	.877 .842	.844	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.465	5/16-SP	11,500	49,900	28,350	9,900
20	41/64	.953 .918	.935	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.520	3/8-SP	14,200	61,200	38,360	13,470
24	49/64	1.150 1.110	1.125	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.625	7/16-SP	19,109	87,400	55,600	19,400
28	57/64	1.330 1.290	1.315	.8896 .8886	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.725	1/2-SP	31,500	115,000	67,900	25,200
32	1-1/64	1.510 1.470	1.500	1.0146 1.0136	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 37°	1.000-12 UNJF-3A	.830	9/16-SP	38,200	145,200	88,600	31,912

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.



**VIEW A**

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
  2. Dimensions are in inches and to be met after finish.
  - ④ 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/mandrel failure may occur.
  6. Use HPL968 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.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HPL868 oversize pin replaces.  
 Second dash number indicates maximum grip in 1/16ths.  
 See "Finish" note for explanation of code letters.

**HOW TO ORDER**

**④EXAMPLE:**

Pin Part Number  
**HPL868KM18-34**  
 — 34/16 or 17/8 Maximum Grip Length  
 — 18/32 or 9/16 Nominal Diameter Pin  
 — Finish Code  
 — Pin Basic Part Number

**MATERIAL:** 6AL-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] HPL868KM( )-( ) = 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.

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

DRAWN BY J.F. OBISPO	DATE 2004-03-15	TITLE PULL-IN™ PIN PROTRUDING TENSION HEAD 6AL-4V TITANIUM ALLOY, SPECIAL THREAD 1/16 GRIP VARIATION, 1/64 OVERSIZE SPECIAL HIGH INTERFERENCE FIT
APPROVED M. CAWLEY	DATE 2004-03-15	
REVISION ④	DATE K. TRAN 2017-10-27	DRAWING NUMBER <b>HPL868</b>