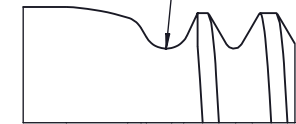


PULL-IN™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA MAX	A' DIA MIN	B REF	D DIA AFTER COATING	TD DIA	F	H REF	M GAGE PROT.	R RAD ROLLED	V GAGE DIA	Z MAX	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND ⑧			
															T MIN	T1	THREAD SIZE	LOAD MAX
24	3/4	1.3000	1.251	.895	.7490 .7480	.7430 .7370	.012	.229	.0776 .0716	.050 .040	1.1124 1.1122	.022	1/16 x 37°	.7500-16 UNJF-3A	.260	.385 .365	3/8-24UNJF-2B	14,175
28	7/8	1.5091	1.461	1.000	.8740 .8730	.8680 .8610	.014	.263	.0694 .0622	.050 .040	1.3440 1.3438	.022	5/64 x 37°	.8750-14 UNJF-3A	.380	.500 .480	3/8-24UNJF-2B	21,600
32	1	1.7201	1.671	1.160	.9990 .9980	.9930 .9860	.014	.298	.0617 .0536	.050 .040	1.5732 1.5730	.022	5/64 x 37°	1.0000-12 UNJF-3A	.450	.575 .555	3/8-24UNJF-2B	21,600

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
SEE SPECIFICATION FOR INSPECTION

GENERAL NOTES:

- Head edge out of roundness shall not exceed "F".
- Concentricity: Conical surface of head to "D" diameter within .005 FIM.
- "H" is dimensioned from maximum "D" diameter.
- Hole preparation per NAS618.
- Dimensions are in inches and to be met after finish.
- ⑨ Surface texture per ASME B46.1.
- ⑦ Curved or flat edge manufacturer's option.
- ⑧ The maximum allowable installation load must not exceed the maximum load values in table or thread failure may occur.
- ⑨ After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 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: 6AL-4V titanium alloy per AMS4928, AMS4967 or British Standard 2TA 28.

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

- ⑨ **FINISH:** ⑨ HPL955KM() = 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.
- ⑨ HPL955AP() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- HPL955NKA() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.
- HPL955NKB() = Sulfuric acid anodizing per ISO8080 and HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only and cetyl alcohol lube per Hi-Shear Spec. 305.
- HPL955NKC() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only 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. Code letter "A" following second dash number indicates assembly with HPM pull mandrel.

HOW TO ORDER

⑨ **EXAMPLES:**

Pin Part Number
HPL955KM24-8A
Assembled with HPM Pull Mandrel (Optional)
8/16 or 1/2 Maximum Grip Length
3/4 or 12/16 Nominal Diameter Pin
Finish Code
Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HPL955KM70-18-8

Size and Grip Length, See Above Example
Collar Part Number
Pin Basic Part Number

"HI-KOTE", "HI-LITE", "PULL-IN" AND "HPL", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F.O.	DATE 1991-11-08	TITLE PULL-IN™ PIN 100° FLUSH SPECIAL SHEAR HEAD TITANIUM (ANNEALED) 1/16 GRIP VARIATION	
APPROVED DAW	DATE 1991-11-10	DRAWING NUMBER HPL955	
REVISION 9	DATE K. TRAN 2017-10-30	1 OF 1	