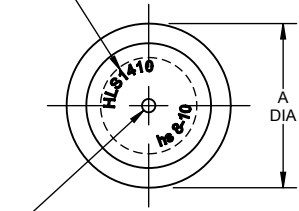
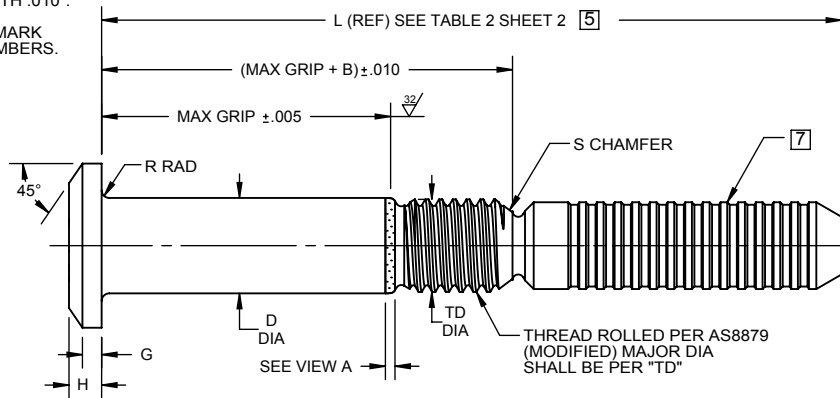


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
"hs" INDICATES HI-SHEAR TRADEMARK.
THE NUMBER(S) FOLLOWING THE TRADEMARK
INDICATES FIRST AND SECOND DASH NUMBERS.
ARRANGEMENT OPTIONAL.



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



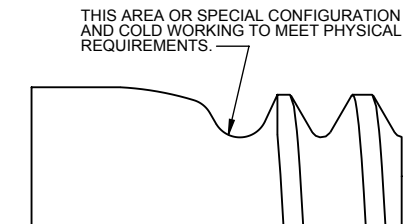
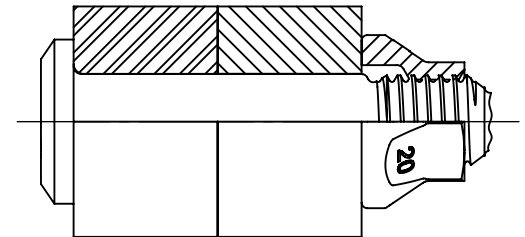
PULL-STEM™ PIN

TABLE 1

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS MAX
6	3/16	.337 .357	.290	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 X 45°	.1900-32 UNJF-3A	7,081	4,350	1,560
7	7/32	.410 .390	.305	.2182 .2172	.2100 .2070	.040	.081 .071	.025 .015	1/32 X 45°	.2160-28 UNJF-3A	9,352	5,634	1,972
8	1/4	.440 .415	.320	.2495 .2485	.2440 .2410	.045	.090 .080	.030 .020	1/32 X 45°	.2500-28 UNJF-3A	12,320	7,750	2,800
10	5/16	.505 .475	.380	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64 X 45°	.3125-24 UNJF-3A	19,160	12,605	4,420
12	3/8	.600 .565	.420	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 X 45°	.3750-24 UNJF-3A	27,652	19,176	6,840
14	7/16	.676 .641	.485	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 X 45°	.4375-20 UNJF-3A	37,611	25,815	9,270
16	1/2	.770 .735	.525	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 X 45°	.5000-20 UNJF-3A	49,100	34,300	12,300

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

PULL-STEM™ PIN AND NUT/COLLAR AFTER ASSEMBLY



VIEW A

HI-LITE™ THREAD TRANSITION AREA.
SEE SPECIFICATION FOR INSPECTOR

- 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 HSL/HPL-IS01: PULL-STEM™ / PULL-IN™ fastener installation specification for HSL/HPL pins.
 5. Shorter or longer grips than those listed may be available as specials.
 6. Use HSL1420 for oversize replacement.
 7. Coating and lube not mandatory on pintail.
 8. Product in accordance with LISI AEROSPACE Product Specification N°415
 9. "NKA" is a duplicate code, use "NAP" for new design.

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

③ **EXAMPLE:** Pin Part Number
HSL1410NAP8-8
└─ 8/16 or 1/2 Maximum Grip Length
└─ 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number

MATERIAL: Pin = Nickel base alloy (Inconel 718) per AMS5662 or AMS5962.

HEAT TREAT: Pin = 220,000 psi tensile minimum and 125,000 psi shear minimum.③

FINISH: HSL1410NAP() = HI-KOTE™1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

⑨ HSL1410NKA() = HI-KOTE™1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

"HI-KOTE", "HI-LITE", "PULL-STEM" AND "HSL",
ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY F.CARINGELLA	DATE 2013-08-28	TITLE PULL-STEM™ PIN PROTRUDING TENSION HEAD BREAK STEM, INTERFERENCE FIT NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION
APPROVED I.KOMSITSKY	DATE 2013-08-28	
REVISION 3	DATE F.CARINGELLA 2017-10-27	DRAWING NUMBER HSL1410

TABLE 2

SECOND DASH NUMBER	L REF						
	-6 DIA.	-7 DIA.	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.
1	-	-	-	-	-	-	-
2	1.000	1.000	1.000	-	-	-	-
3	1.125	1.125	1.125	1.250	-	-	-
4	1.250	1.250	1.250	1.375	1.375	-	-
5	1.375	1.375	1.375	1.500	1.500	1.625	-
6	1.500	1.500	1.500	1.625	1.625	1.750	1.750
7	1.625	1.625	1.625	1.750	1.750	1.875	1.875
8	1.750	1.750	1.750	1.875	1.875	2.000	2.000
9	1.875	1.875	1.875	2.000	2.000	2.125	2.125
10	2.000	2.000	2.000	2.125	2.125	2.250	2.250
11	2.125	2.125	2.125	2.250	2.250	2.375	2.375
12	2.250	2.250	2.250	2.375	2.375	2.500	2.500
13	2.375	2.375	2.375	2.500	2.500	2.625	2.625
14	2.500	2.500	2.500	2.625	2.625	2.750	2.750
15	2.625	2.625	2.625	2.750	2.750	2.875	2.875
16	2.750	2.750	2.750	2.875	2.875	3.000	3.000
17	2.875	2.875	2.875	3.000	3.000	3.125	3.125
18	3.000	3.000	3.000	3.125	3.125	3.250	3.250
19	3.125	3.125	3.125	3.250	3.250	3.375	3.375
20	3.250	3.250	3.250	3.375	3.375	3.500	3.500
21	3.375	3.375	3.375	3.500	3.500	3.625	3.625
22	3.500	3.500	3.500	3.625	3.625	3.750	3.750
23	3.625	3.625	3.625	3.750	3.750	3.875	3.875
24	3.750	3.750	3.750	3.875	3.875	4.000	4.000
25	-	-	-	4.000	4.000	4.125	4.125
26	-	-	-	4.125	4.125	4.250	4.250
27	-	-	-	4.250	4.250	4.375	4.375
28	-	-	-	4.375	4.375	4.500	4.500
29	-	-	-	-	4.500	4.625	4.625
30	-	-	-	-	4.625	4.750	4.750
31	-	-	-	-	4.750	4.875	4.875
32	-	-	-	-	4.875	5.000	5.000
33	-	-	-	-	5.000	5.125	5.125
34	-	-	-	-	5.125	5.250	5.250
35	-	-	-	-	5.250	5.375	5.375
36	-	-	-	-	5.375	5.500	5.500
37	-	-	-	-	5.500	5.625	5.625
38	-	-	-	-	5.625	5.750	5.750
39	-	-	-	-	5.750	5.875	5.875
40	-	-	-	-	5.875	6.000	6.000
41	-	-	-	-	6.000	6.125	6.125
42	-	-	-	-	6.125	6.250	6.250
43	-	-	-	-	6.250	6.375	6.375
44	-	-	-	-	6.375	6.500	6.500

HSL1410

DRAWING NUMBER

HSL1410

2 OF 2