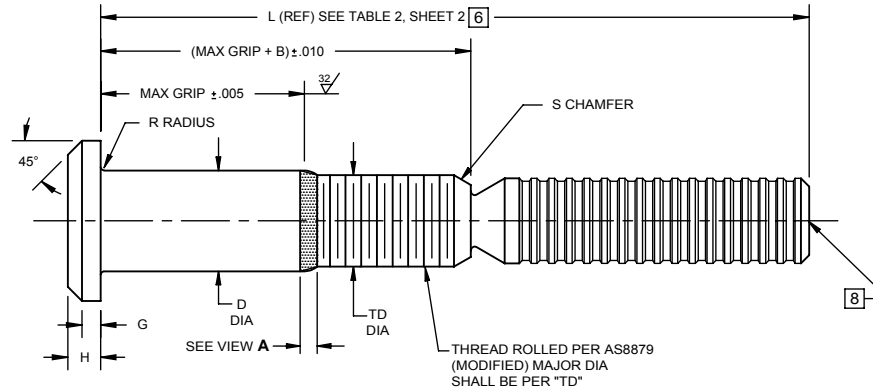
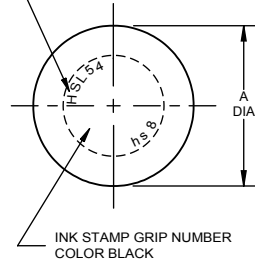


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
 "hs" INDICATES HI-SHEAR TRADEMARK.
 THE NUMBER(S) FOLLOWING THE TRADEMARK
 INDICATES FIRST DASH NUMBER. ARRANGEMENT
 OPTIONAL.



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
5	5/32	.322 .306	.280	.1635 .1625	.1595 .1570	.030	.065 .055	.025 .015	1/32 x 45°	.1640-32 UNJC-3A	5,280	2,940
6	3/16	.377 .357	.290	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 x 45°	.1900-32 UNJF-3A	7,060	4,350
8	1/4	.440 .415	.320	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 45°	.2500-28 UNJF-3A	12,260	7,750
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	12,300
[8] 12	3/8	.600 .565	.420	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 45°	.3750-24 UNJF-3A	27,600	19,100
[8] 14	7/16	.676 .641	.500	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 45°	.4375-20 UNJF-3A	37,500	25,800
[8] 16	1/2	.770 .735	.600	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 45°	.5000-20 UNJF-3A	49,100	34,300

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIM.
- Dimensions are in inches and to be met after finish.
- Surface texture per ASME B46.1.
- Hole preparation per NAS618.
- Lead radius must be tangent to "D" diameter at maximum grip.
- Shorter or longer grips than those listed may be available as specials.
- Use HSL154 for oversize replacement.
- Paint or dye pin tail flat end with color: orange for -12 size, green for -14 size, and blue for -16 size. Paint overspray is permissible.
- 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: Nickel base alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: [9] HSL54AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

[9] HSL54AG()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color code orange on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HSL54DL()-() = Kalgard FA or EM620C solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.

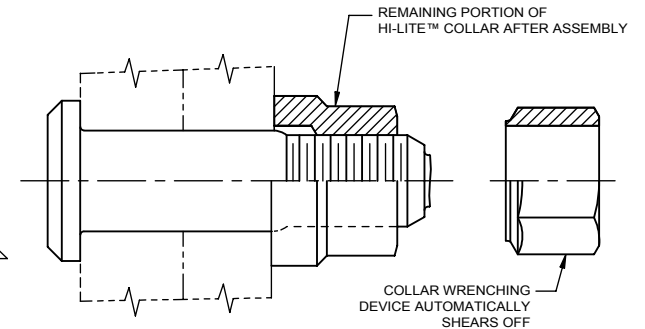
SPECIFICATION: HI-LITE™ Product Specification 380-2.

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.

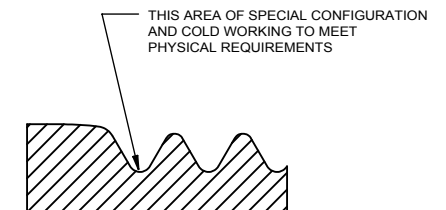
HOW TO ORDER
 EXAMPLE:

Pin Part Number
 HSL54AP8-8
 8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number



PULL-STEM™ PIN AND COLLAR AFTER ASSEMBLY

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



VIEW A

HI-LITE™ THREAD TRANSITION AREA
 SEE SPECIFICATION FOR INSPECTION

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

DRAWN BY J.F. OBISPO	DATE 1996-04-01	TITLE PULL-STEM™ PIN PROTRUDING TENSION HEAD BREAK STEM, INTERFERENCE FIT NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION
APPROVED J. RAUSCH	DATE 1996-04-02	
REVISION [6]	DATE K. TRAN 2017-10-31	DRAWING NUMBER HSL54

TABLE 2

SECOND DASH NUMBER	L REF [6]						
	-5 DIA.	-6 DIA.	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.
1	-	-	-	-	-	-	-
2	.875	1.000	1.000	-	-	-	-
3	1.000	1.125	1.125	1.250	-	-	-
4	1.125	1.250	1.250	1.375	1.375	-	-
5	1.250	1.375	1.375	1.500	1.500	1.625	1.625
6	1.375	1.500	1.500	1.625	1.625	1.750	1.750
7	1.500	1.625	1.625	1.750	1.750	1.875	1.875
8	1.625	1.750	1.750	1.875	1.875	2.000	2.000
9	1.750	1.875	1.875	2.000	2.000	2.125	2.125
10	1.875	2.000	2.000	2.125	2.125	2.250	2.250
11	2.000	2.125	2.125	2.250	2.250	2.375	2.375
12	2.125	2.250	2.250	2.375	2.375	2.500	2.500
13	2.250	2.375	2.375	2.500	2.500	2.625	2.625
14	2.375	2.500	2.500	2.625	2.625	2.750	2.750
15	2.500	2.625	2.625	2.750	2.750	2.875	2.875
16	2.625	2.750	2.750	2.875	2.875	3.000	3.000
17	2.750	2.875	2.875	3.000	3.000	3.125	3.125
18	2.875	3.000	3.000	3.125	3.125	3.250	3.250
19	3.000	3.125	3.125	3.250	3.250	3.375	3.375
20	3.125	3.250	3.250	3.375	3.375	3.500	3.500
21	-	3.375	3.375	3.500	3.500	3.625	3.625
22	-	3.500	3.500	3.625	3.625	3.750	3.750
23	-	3.625	3.625	3.750	3.750	3.875	3.875
24	-	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

HSL54

DRAWING NUMBER

HSL54

2 OF 2