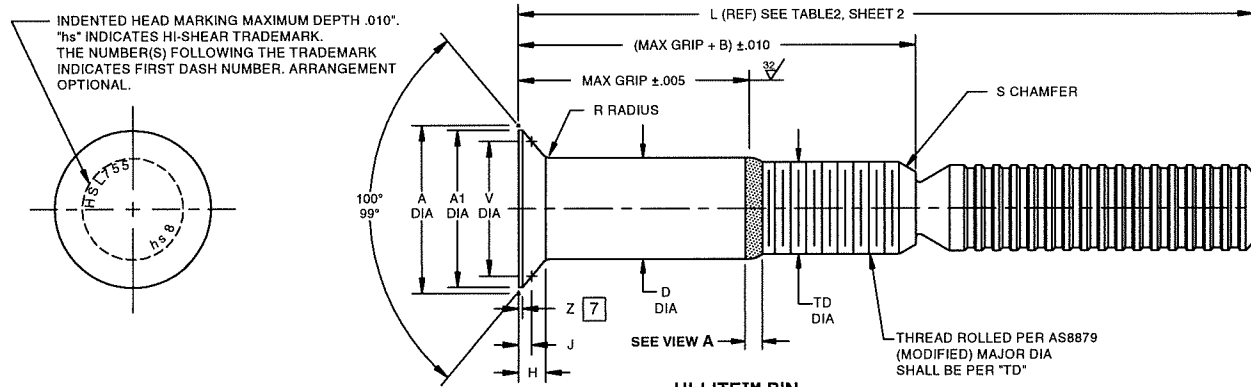
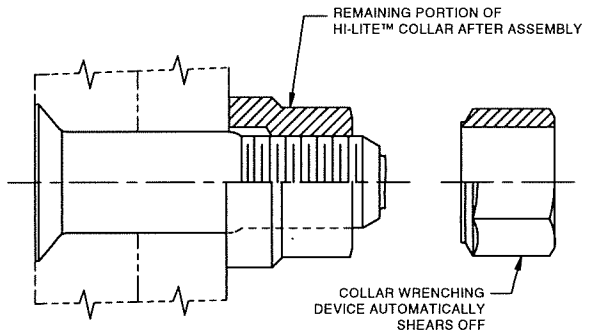


Hi-Shear Corporation, U.S.A. a LISI AEROSPACE Company	Design Holder	CAGE No. 73197	LIISI AEROSPACE CANADA, Canada a LIISI AEROSPACE Company	Licensee	CAGE No. 14528
BLANC AERO TECHNOLOGIES SA, France a LIISI AEROSPACE Company	Licensee	CAGE No. FA1X3	Air Industries CO., USA	Licensee (USA, Canada)	CAGE No. 06725
BLANC AERO INDUSTRIES SA, France a LIISI AEROSPACE Company	Licensee	CAGE No. F0188-C			

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



HI-LITE™ PIN



HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

TABLE 1

FIRST DASH NO.	PIN NOM DIA	A DIA	A1 DIA MIN	B REF	D DIA		F	TD DIA	H REF	J GAGE PROT.	R RAD	V GAGE DIA	Z MAX	S CHAMFER REF	THREAD	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS MAXIMUM
					WITHOUT COATING OR SOLID FILM	WITH COATING OR SOLID FILM												
6	3/16	.3277	.2963	.290	.1895 .1890	.1895 .1885	.005	.1840 .1810	.056	.0295 .0263	.030 .020	.2560 .2558	.015	1/32 x 37°	.1900-32UNJF-3A Modified	5,380	2,400	900
8	1/4	.4283	.3969	.320	.2495 .2490	.2495 .2485	.006	.2440 .2410	.074	.0227 .0195	.030 .020	.3732 .3730	.015	1/32 x 37°	.2500-28UNJF-3A Modified	9,300	4,500	1,575
10	5/16	.5361	.5047	.380	.3120 .3115	.3120 .3110	.007	.3060 .3020	.092	.0234 .0198	.040 .030	.4791 .4789	.015	3/64 x 37°	.3125-24UNJF-3A Modified	14,600	6,850	2,397
12	3/8	.6415	.6101	.420	.3745 .3740	.3745 .3735	.008	.3680 .3640	.110	.0295 .0259	.040 .030	.5698 .5696	.015	3/64 x 37°	.3750-24UNJF-3A Modified	21,000	10,200	3,570
14	7/16	.7425	.6941	.485	.4370 .4365	.4370 .4360	.009	.4310 .4260	.126	.0347 .0307	.050 .040	.6582 .6580	.022	3/64 x 37°	.4375-20UNJF-3A Modified	28,600	13,100	4,585
16	1/2	.8423	.7939	.525	.4995 .4990	.4995 .4985	.010	.4930 .4880	.142	.0504 .0464	.050 .040	.7200 .7198	.022	3/64 x 37°	.5000-20UNJF-3A Modified	37,300	18,000	6,300

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.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Curved or flat edge manufacturer's option.
- Fatigue test required on pins having grip length equal to two diameters or longer. Use maximum load rate per table. Minimum load rate is 10% of maximum load.
- This HI-LITE™ pin is to be used in combination with a HI-LITE™ collar.
- This HI-LITE™ pin is to be used in interference fit holes only.
- 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:

6AL-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT:

95,000 psi shear minimum.

FINISH:

HSL755(-)(-) = Surface coating per Hi-Shear Spec. 306, Type I, color blue, with color black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

HSL755CE(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick), with color black on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

HSL755CF(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick), with color black on thread end.

HSL755KN(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color white on thread end.

HSL755RP(-)(-) = Phosphate fluoride treat with color orange on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

HSL755AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 380, 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.

HOW TO ORDER

EXAMPLE:

Pin Part Number Only
HSL755CE8-8

8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
I.V.D. aluminum coating
Pin Basic Part Number

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

"HI-KOTE", "HI-LITE", "PULL-STEM" and "HSL", are Trademarks of Hi-Shear Corporation.			
DRAWN BY J.F. Obispo	DATE 11-20-91	TITLE HI-LITE™ PULL-STEM™ PIN 100° FLUSH SPECIAL SHEAR HEAD BREAK STEM, INTERFERENCE FIT TITANIUM 1/16 GRIP VARIATION	
APPROVED DAW	DATE 11-21-91	DRAWING NUMBER HSL755	
REVISION (3)	DATE FC 1-7-15	1 OF 2	



hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

TABLE 2

SECOND DASH NUMBER	L (REF)						
		-6 DIA.	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.
1		-	-	-	-	-	-
2		.945	.927	-	-	-	-
3		1.070	1.052	1.160	-	-	-
4		1.195	1.177	1.285	1.265	-	-
5		1.320	1.302	1.410	1.390	1.500	-
6		1.445	1.427	1.535	1.515	1.625	1.610
7		1.570	1.552	1.660	1.640	1.750	1.735
8		1.695	1.677	1.785	1.765	1.875	1.860
9		1.820	1.802	1.910	1.890	2.000	1.985
10		1.945	1.927	2.035	2.015	2.125	2.110
11		2.070	2.052	2.160	2.140	2.250	2.235
12		2.195	2.177	2.285	2.265	2.375	2.360
13		2.320	2.302	2.410	2.390	2.500	2.485
14		2.445	2.427	2.535	2.515	2.625	2.610
15		2.570	2.552	2.660	2.640	2.750	2.735
16		2.695	2.677	2.785	2.765	2.875	2.860
17		2.820	2.802	2.910	2.890	3.000	2.985
18		2.945	2.927	3.035	3.015	3.125	3.110
19		3.070	3.052	3.160	3.140	3.250	3.235
20		3.195	3.177	3.285	3.265	3.375	3.360
21		3.320	3.302	3.410	3.390	3.500	3.485
22		3.445	3.427	3.535	3.515	3.625	3.610
23		3.570	3.552	3.660	3.640	3.750	3.735
24		3.695	3.677	3.785	3.765	3.875	3.860
25		-	-	3.910	3.890	4.000	3.985
26		-	-	4.035	4.015	4.125	4.110
27		-	-	4.160	4.140	4.250	4.235
28		-	-	4.285	4.265	4.375	4.360
29		-	-	-	-	4.500	4.485
30		-	-	-	-	4.625	4.610
31		-	-	-	-	4.750	4.735
32		-	-	-	-	4.875	4.860

HSL755

DRAWING NUMBER

HSL755

Sheet 2 OF 2