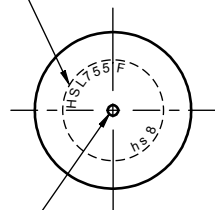


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
 "hs" INDICATES HI-SHEAR TRADEMARK.
 THE NUMBER(S) FOLLOWING THE TRADEMARK
 INDICATES FIRST DASH NUMBER. ARRANGEMENT
 OPTIONAL.



DRILL CENTER DIMPLE .035 MAX DIA
 x .010 MAX DEPTH. CONCENTRIC TO
 "A1" DIA WITHIN .008 FIM.
 ONLY FOR DASH NUMBER 12, 14 and 16.

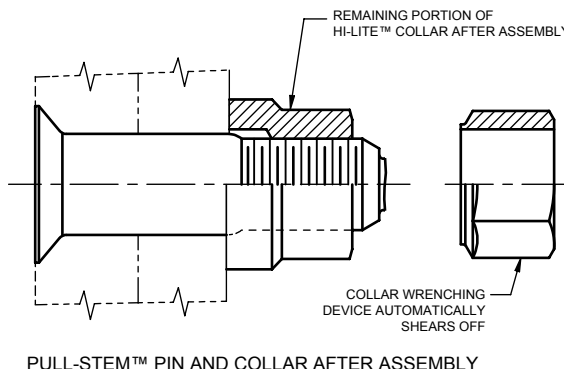
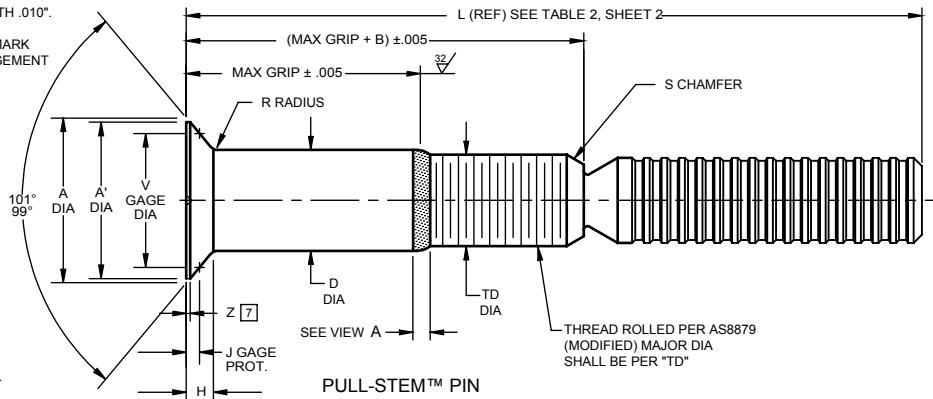
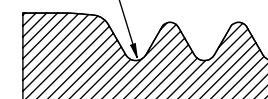


TABLE 1

FIRST DASH NO.	PIN NOM DIA	A DIA	A' DIA MIN	B REF	D DIA AFTER COATING	F	TD DIA	H REF	J GAGE PROT.	R RAD	V GAGE DIA	Z MAX	S CHAMFER REF	THREAD MODIFIED	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS MAXIMUM
6	3/16	.3277	.2963	.290	.1895 .1885	.005	.1840 .1810	.056	.0295 .0263	.030 .020	.2560 .2558	.015	1/32 x 37°	.1900-32 UNJF-3A	5,380	2,405	900
8	1/4	.4283	.3969	.320	.2495 .2485	.006	.2440 .2410	.074	.0227 .0195	.030 .020	.3732 .3730	.015	1/32 x 37°	.2500-28 UNJF-3A	9,300	4,500	1,575
10	5/16	.5361	.5047	.380	.3120 .3110	.007	.3060 .3020	.092	.0234 .0198	.040 .030	.4791 .4789	.015	3/64 x 37°	.3125-24 UNJF-3A	14,600	6,850	2,397
12	3/8	.6415	.6101	.420	.3745 .3735	.008	.3680 .3640	.110	.0295 .0259	.040 .030	.5698 .5696	.015	3/64 x 37°	.3750-24 UNJF-3A	21,000	10,200	3,570
14	7/16	.7425	.6941	.485	.4370 .4360	.009	.4310 .4260	.126	.0347 .0307	.050 .040	.6582 .6580	.022	3/64 x 37°	.4375-20 UNJF-3A	28,600	13,100	4,585
16	1/2	.8423	.7939	.525	.4995 .4985	.010	.4930 .4880	.142	.0504 .0464	.050 .040	.7200 .7198	.022	3/64 x 37°	.5000-20 UNJF-3A	37,300	18,000	6,300

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:

1. Concentricity: Head edge to "D" diameter shall not exceed "F".
2. Concentricity: Conical surface of head to "D" diameter within .005 FIM.
3. "H" is dimensioned from maximum "D" diameter.
4. Dimensions are in inches and to be met after finish.
5. Surface texture per ASME B46.1.
6. Hole preparation per NAS618.
7. Curved or flat edge manufacturer's option.
8. This PULL-STEM™ pin is to be used in combination with a HI-LITE™ collar.
9. This PULL-STEM™ pin is to be used in interference fit holes only.
10. Use HSL855F for oversize replacement.
11. 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 or AMS4967.

HEAT TREAT: 95,000 psi shear minimum.

② **FINISH:** ① HSL755AP () (F) = HI-KOTE™ 1 or HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification HS412.

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
HSL755AP8-8F
 — 8/16 or 1/2 Maximum Grip Length
 — 8/32 or 1/4 Nominal Diameter Pin
 — Finish Code
 — Pin Basic Part Number

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

DRAWN BY J.F. OBISPO	DATE 2004-07-01	TITLE PULL-STEM™ PIN 100° FLUSH SPECIAL SHEAR HEAD BREAK STEM, INTERFERENCE FIT TITANIUM 1/16 GRIP VARIATION
APPROVED M. CAWLEY	DATE 2004-07-08	
REVISION ②	DATE K. TRAN 2017-10-31	DRAWING NUMBER HSL755F

TABLE 2

SECOND DASH NUMBER	L (REF)						
		-6	-8	-10	-12	-14	-16
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		-	-	-	4.390	4.500	4.485
30		-	-	-	4.515	4.625	4.610
31		-	-	-	4.640	4.750	4.735
32		-	-	-	-	4.875	4.860
33		-	-	-	-	5.000	4.985
34		-	-	-	-	5.125	5.110
35		-	-	-	-	5.250	5.235
36		-	-	-	-	5.375	5.360

HSL755F

DRAWING NUMBER

HSL755F

2 OF 2