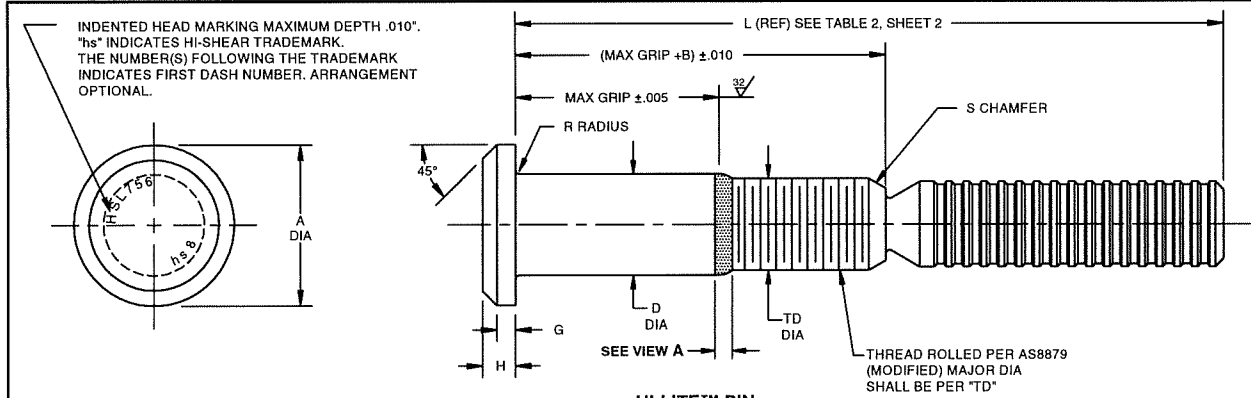


|                                                                                                                                                                                            |                                                   |                                                      |                                                                                                                |                                  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------|------------------------------------------------------|----------------------------------------------------------------------------------------------------------------|----------------------------------|
| Hi-Shear Corporation, U.S.A.<br>a LISI AEROSPACE Company<br>BLANC AERO TECHNOLOGIES SA, France<br>a LISI AEROSPACE Company<br>BLANC AERO INDUSTRIES SA, France<br>a LISI AEROSPACE Company | Design Holder<br>Licensee<br>Licensee<br>Licensee | CAGE No. 73197<br>CAGE No. FA1X3<br>CAGE No. F0188-C | LISI AEROSPACE CANADA, Canada<br>a LISI AEROSPACE Company<br>Air Industries CO., USA<br>Licensee (USA, Canada) | CAGE No. L4528<br>CAGE No. 06725 |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------|------------------------------------------------------|----------------------------------------------------------------------------------------------------------------|----------------------------------|



HI-LITE™ PIN

TABLE 1

③

| FIRST DASH NO. | PIN NOM DIA | A DIA        | B REF | D DIA                         |                            | TD DIA         | G REF | H            | R RAD        | S CHAMFER REF | THREAD                      | DOUBLE SHEAR POUNDS MINIMUM | TENSION POUNDS MINIMUM | TENSION-TENSION FATIGUE LBS. MAX |
|----------------|-------------|--------------|-------|-------------------------------|----------------------------|----------------|-------|--------------|--------------|---------------|-----------------------------|-----------------------------|------------------------|----------------------------------|
|                |             |              |       | WITHOUT COATING OR SOLID FILM | WITH COATING OR SOLID FILM |                |       |              |              |               |                             |                             |                        |                                  |
| 6              | 3/16        | .377<br>.357 | .290  | .1895<br>.1890                | .1895<br>.1885             | .1840<br>.1810 | .035  | .074<br>.064 | .025<br>.015 | 1/32 x 37°    | .1900-32UNJF-3A<br>Modified | 5,380                       | 3,180                  | 1,050                            |
| 8              | 1/4         | .440<br>.415 | .320  | .2495<br>.2490                | .2495<br>.2485             | .2440<br>.2410 | .045  | .090<br>.080 | .025<br>.015 | 1/32 x 37°    | .2500-28UNJF-3A<br>Modified | 9,300                       | 5,820                  | 1,950                            |
| 10             | 5/16        | .505<br>.475 | .380  | .3120<br>.3115                | .3120<br>.3110             | .3060<br>.3020 | .055  | .112<br>.102 | .030<br>.020 | 3/64 x 37°    | .3125-24UNJF-3A<br>Modified | 14,600                      | 9,200                  | 3,140                            |
| 12             | 3/8         | .600<br>.565 | .420  | .3745<br>.3740                | .3745<br>.3735             | .3680<br>.3640 | .075  | .140<br>.130 | .030<br>.020 | 3/64 x 37°    | .3750-24UNJF-3A<br>Modified | 21,000                      | 14,000                 | 4,850                            |
| 14             | 7/16        | .676<br>.641 | .500  | .4370<br>.4365                | .4370<br>.4360             | .4310<br>.4260 | .095  | .160<br>.150 | .030<br>.020 | 3/64 x 37°    | .4375-20UNJF-3A<br>Modified | 28,600                      | 17,670                 | 6,120                            |
| 16             | 1/2         | .770<br>.735 | .600  | .4995<br>.4990                | .4995<br>.4985             | .4930<br>.4880 | .095  | .188<br>.178 | .030<br>.020 | 3/64 x 37°    | .5000-20UNJF-3A<br>Modified | 37,300                      | 23,940                 | 8,340                            |

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIM.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- This HI-LITE™ Pin is to be used in combination with a HI-LITE™ Collar.
- This HI-LITE™ Pin 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:

160,000 psi tensile minimum (95,000 psi shear minimum).

FINISH:

- HSL756(-)(-) = 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.
- HSL756CE(-)(-) = 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.
- HSL756CF(-)(-) = I.V.D. aluminum coating per MIL-DTL-83488, Type II (.00015-.00045 thick), with color black on thread end.
- HSL756KM(-)(-) = 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.
- HSL756KN(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color white on thread end.
- HSL756RP(-)(-) = Phosphate fluoride treat with color orange on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
- HSL756AP(-)(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 and cetyl alcohol lube per Hi-Shear Spec. 305.

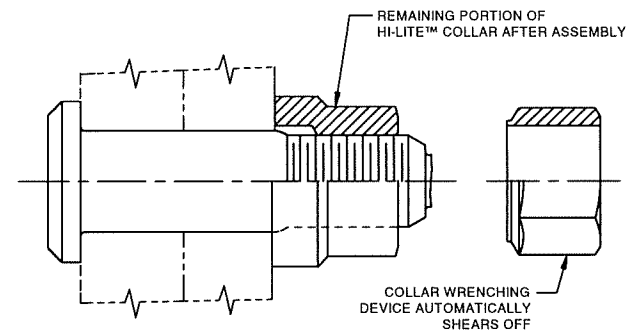
SPECIFICATION: HI-LITE™ Product Specification 380-2.

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

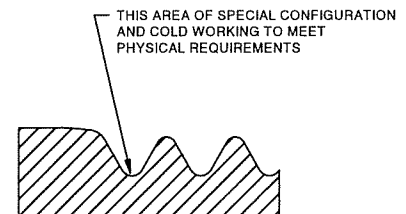
EXAMPLE:

Pin Part Number Only  
HSL756CE8-8  
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



HI-LITE™ 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<br>J.F.Obispo                                                               | DATE<br>11-20-91     | TITLE<br>HI-LITE™ PULL-STEM™ PIN<br>PROTRUDING TENSION HEAD<br>BREAK STEM, INTERFERENCE FIT<br>TITANIUM<br>1/16 GRIP VARIATION |  |
| APPROVED<br>JGW                                                                      | DATE<br>11-21-91     |                                                                                                                                |  |
| REVISION<br>④                                                                        | DATE<br>FC<br>1-7-15 | DRAWING NUMBER<br>HSL756                                                                                                       |  |

TABLE 2

| SECOND<br>DASH<br>NUMBER | L REF |            |            |             |             |             |             |
|--------------------------|-------|------------|------------|-------------|-------------|-------------|-------------|
|                          |       | -6<br>DIA. | -8<br>DIA. | -10<br>DIA. | -12<br>DIA. | -14<br>DIA. | -16<br>DIA. |
| 1                        |       | -          | -          | -           | -           | -           | -           |
| 2                        |       | 1.000      | 1.000      | -           | -           | -           | -           |
| 3                        |       | 1.125      | 1.125      | 1.250       | -           | -           | -           |
| 4                        |       | 1.250      | 1.250      | 1.375       | 1.375       | -           | -           |
| 5                        |       | 1.375      | 1.375      | 1.500       | 1.500       | 1.625       | -           |
| 6                        |       | 1.500      | 1.500      | 1.625       | 1.625       | 1.750       | 1.750       |
| 7                        |       | 1.625      | 1.625      | 1.750       | 1.750       | 1.875       | 1.875       |
| 8                        |       | 1.750      | 1.750      | 1.875       | 1.875       | 2.000       | 2.000       |
| 9                        |       | 1.875      | 1.875      | 2.000       | 2.000       | 2.125       | 2.125       |
| 10                       |       | 2.000      | 2.000      | 2.125       | 2.125       | 2.250       | 2.250       |
| 11                       |       | 2.125      | 2.125      | 2.250       | 2.250       | 2.375       | 2.375       |
| 12                       |       | 2.250      | 2.250      | 2.375       | 2.375       | 2.500       | 2.500       |
| 13                       |       | 2.375      | 2.375      | 2.500       | 2.500       | 2.625       | 2.625       |
| 14                       |       | 2.500      | 2.500      | 2.625       | 2.625       | 2.750       | 2.750       |
| 15                       |       | 2.625      | 2.625      | 2.750       | 2.750       | 2.875       | 2.875       |
| 16                       |       | 2.750      | 2.750      | 2.875       | 2.875       | 3.000       | 3.000       |
| 17                       |       | 2.875      | 2.875      | 3.000       | 3.000       | 3.125       | 3.125       |
| 18                       |       | 3.000      | 3.000      | 3.125       | 3.125       | 3.250       | 3.250       |
| 19                       |       | 3.125      | 3.125      | 3.250       | 3.250       | 3.375       | 3.375       |
| 20                       |       | 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       |

HSL756

DRAWING NUMBER

HSL756

Sheet 2 OF 2