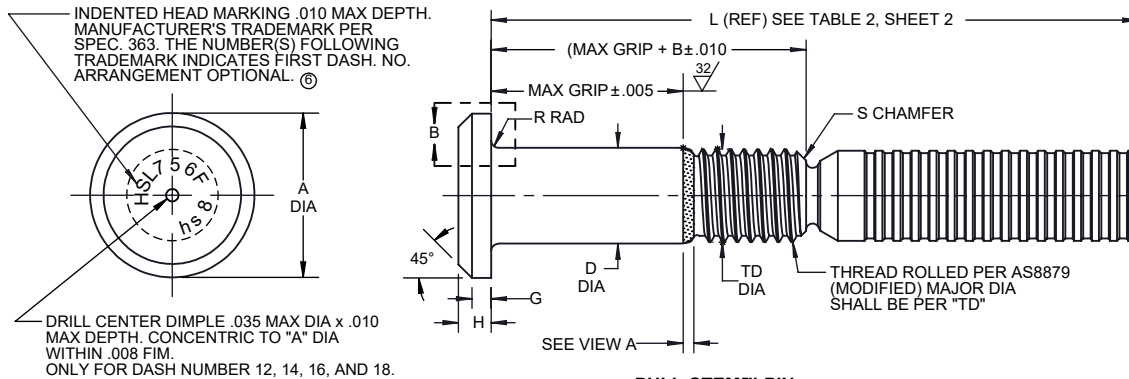




PULL-STEM™ PIN

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 LBS. MAX.
6	3/16	.377 .357	.290	.1895 .1885	.1840 .1810	.035	.074 .064	.020 .010	1/32 x 37°	.1900-32 UNJF-3A	5,380	3,180	1,050
8	1/4	.440 .415	.320	.2495 .2485	.2440 .2410	.045	.090 .080	.020 .010	1/32 x 37°	.2500-28 UNJF-3A	9,300	5,820	1,950
10	5/16	.505 .475	.380	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	14,600	9,200	3,140
12	3/8	.600 .565	.420	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	21,000	14,000	4,850
14	7/16	.676 .641	.485	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	28,600	18,900	6,540
16	1/2	.770 .735	.525	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	37,300	25,600	8,900
18	9/16	.877 .842	.600	.5615 .5605	.5550 .5500	.125	.210 .200	.035 .025	1/16 x 37°	.5625-18 UNJF-3A	47,200	32,400	11,381

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions are in inches and to be met after finish.
 3. Surface texture per AMSE B46.1.
 4. Hole preparation per NAS618.
 5. This PULL-STEM™ Pin is to be used in combination with a HI-LITE™ Collar.
 7. This PULL-STEM™ Pin to be used in interference fit holes only.
 8. Use HSL856F for oversize replacement.
 - ⑥ 9. 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.

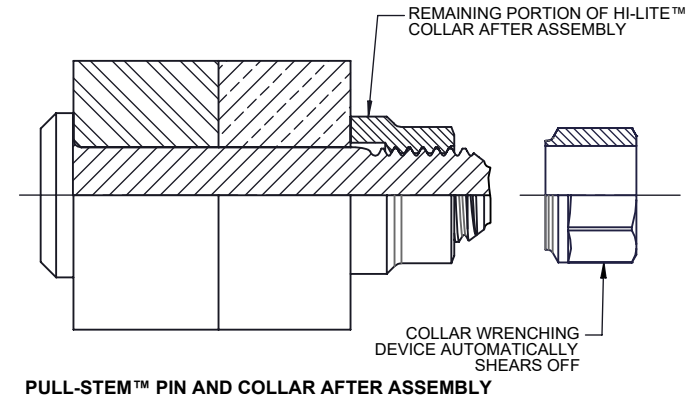
HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

FINISH: ⑥HSL756AP()-()F = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

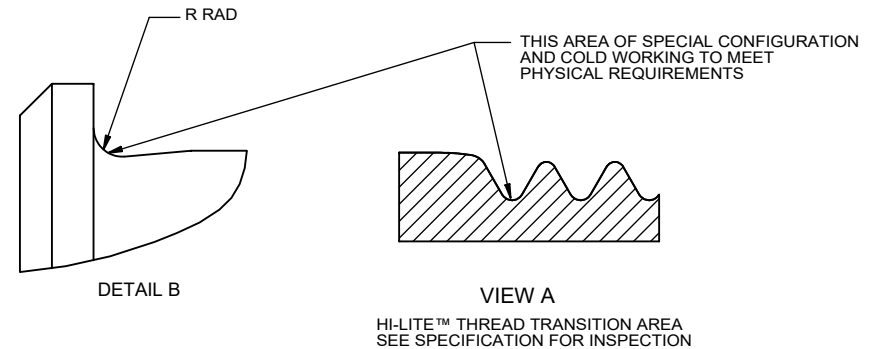
HSL756NAP()-()F = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification HS412, except fillet per Detail B.

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.



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



**HOW TO ORDER
 EXAMPLE:**

Pin Part Number
 HSL756NAP8-8F

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 2004-03-01	TITLE PULL-STEM™ PIN PROTRUDING TENSION HEAD BREAK STEM, INTERFERENCE FIT SPECIAL, TITANIUM 1/16 GRIP VARIATION
APPROVED M.CAWLEY	DATE 2004-03-01	
REVISION 6	DATE K. MURKER 2020-01-31	DRAWING NUMBER HSL756F

TABLE 2

SECOND DASH NUMBER	L REF							
		-6 DIA.	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.	-18 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	2.000
8		1.750	1.750	1.875	1.875	2.000	2.000	2.125
9		1.875	1.875	2.000	2.000	2.125	2.125	2.250
10		2.000	2.000	2.125	2.125	2.250	2.250	2.375
11		2.125	2.125	2.250	2.250	2.375	2.375	2.500
12		2.250	2.250	2.375	2.375	2.500	2.500	2.625
13		2.375	2.375	2.500	2.500	2.625	2.625	2.750
14		2.500	2.500	2.625	2.625	2.750	2.750	2.875
15		2.625	2.625	2.750	2.750	2.875	2.875	3.000
16		2.750	2.750	2.875	2.875	3.000	3.000	3.125
17		2.875	2.875	3.000	3.000	3.125	3.125	3.250
18		3.000	3.000	3.125	3.125	3.250	3.250	3.375
19		3.125	3.125	3.250	3.250	3.375	3.375	3.500
20		3.250	3.250	3.375	3.375	3.500	3.500	3.625
21		3.375	3.375	3.500	3.500	3.625	3.625	3.750
22		3.500	3.500	3.625	3.625	3.750	3.750	3.875
23		3.625	3.625	3.750	3.750	3.875	3.875	4.000
24		3.750	3.750	3.875	3.875	4.000	4.000	4.125
25		-	-	4.000	4.000	4.125	4.125	4.250
26		-	-	4.125	4.125	4.250	4.250	4.375
27		-	-	4.250	4.250	4.375	4.375	4.500
28		-	-	4.375	4.375	4.500	4.500	4.625
29		-	-	-	4.500	4.625	4.625	4.750
30		-	-	-	4.625	4.750	4.750	4.875
31		-	-	-	4.750	4.875	4.875	5.000
32		-	-	-	4.875	5.000	5.000	5.125
33		-	-	-	5.000	5.125	5.125	5.250
34		-	-	-	5.125	5.250	5.250	5.375
35		-	-	-	5.250	5.375	5.375	5.500
36		-	-	-	5.375	5.500	5.500	5.625
37		-	-	-	5.500	5.625	5.625	5.750
38		-	-	-	5.625	5.750	5.750	5.875

HSL756F

DRAWING NUMBER

HSL756F

2 OF 2