

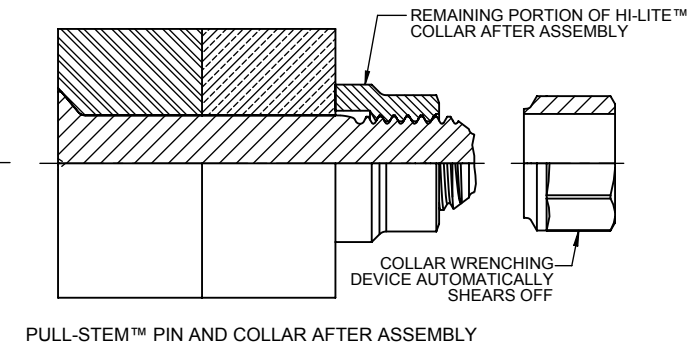
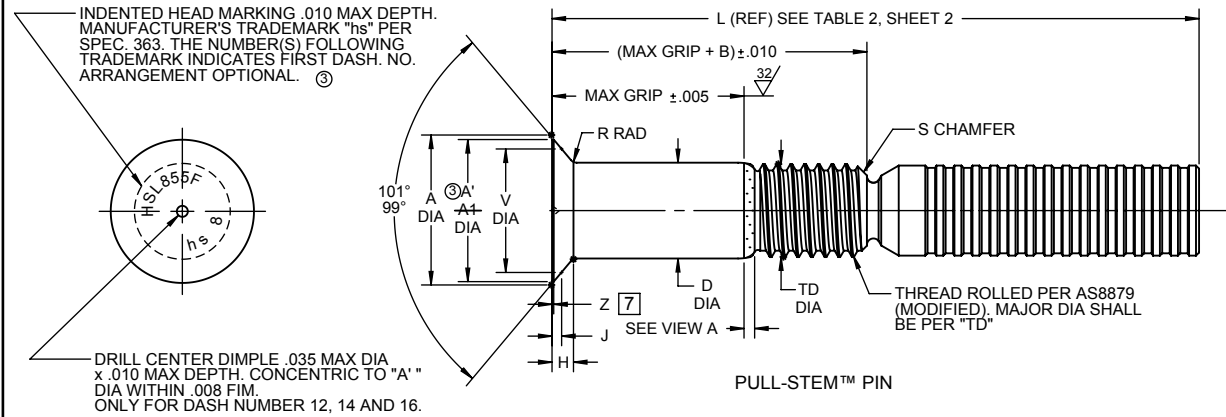


TABLE 1

FIRST DASH NO.	PIN NOM DIA	A DIA	A' 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 MODIFIED	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-FATIGUE POUNDS MAXIMUM
6	13/64	.3277	.2963	.300	.2026 .2016	.005	.1840 .1810	.052	.0295 .0263	.030 .020	.2560 .2558	.015	1/32 x 37°	.1900-32 UNJF-3A	6,130	2,405	900
8	17/64	.4283	.3969	.330	.2651 .2641	.006	.2440 .2410	.068	.0227 .0195	.030 .020	.3732 .3730	.015	1/32 x 37°	.2500-28 UNJF-3A	10,490	4,500	1,575
10	21/64	.5361	.5047	.390	.3276 .3266	.007	.3060 .3020	.087	.0234 .0198	.040 .030	.4791 .4789	.015	3/64 x 37°	.3125-24 UNJF-3A	16,000	6,850	2,397
12	25/64	.6415	.6101	.430	.3901 .3891	.008	.3680 .3640	.105	.0295 .0259	.040 .030	.5698 .5696	.015	3/64 x 37°	.3750-24 UNJF-3A	22,700	10,200	3,570
14	29/64	.7425	.6941	.495	.4526 .4516	.009	.4310 .4260	.121	.0347 .0307	.050 .040	.6582 .6580	.022	3/64 x 37°	.4375-20 UNJF-3A	30,600	13,100	4,585
16	33/64	.8423	.7939	.535	.5151 .5141	.010	.4930 .4880	.137	.0504 .0464	.050 .040	.7200 .7198	.022	3/64 x 37°	.5000-20 UNJF-3A	39,600	18,000	6,300

- GENERAL NOTES:**
- Concentricity: Head edge to "D" diameter shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions are in inches and to be met after finish.
 - Surface texture per ASME B46.1.
 - Hole preparation per NAS618.
 - Curved or flat edge manufacturer's option.
 - This PULL-STEM™ pin is to be used in combination with a HI-LITE™ collar.
 - This PULL-STEM™ pin is to be used in interference fit holes only.
 - Use HSL859F for oversize replacement.

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

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HSL855AP() () 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 412.③

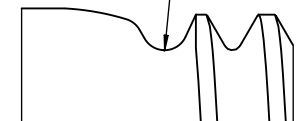
CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HSL855F oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER

③ **EXAMPLE:** Pin Part Number
HSL855AP8-8F
└─ 8/16 or 1/2 Maximum Grip Length
└─ 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ 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 2004-07-01	TITLE PULL-STEM™ PIN 100° FLUSH SPECIAL SHEAR HEAD BREAK STEM, INTERFERENCE FIT TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED C.CAWLEY	DATE 2004-07-04		
REVISION ③	DATE F.CARINGELLA 2017-10-31	DRAWING NUMBER HSL855F	

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		-	-	-	4.390	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

HSL855F

DRAWING NUMBER

HSL855F

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