

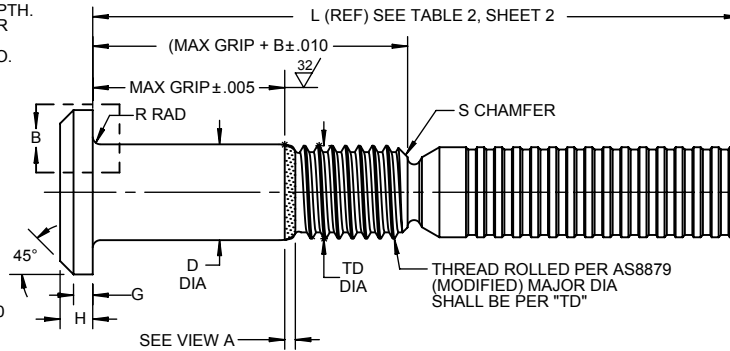
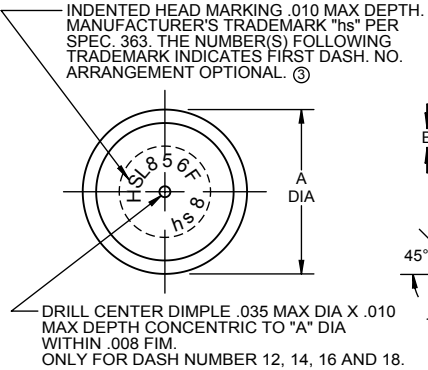


TABLE 1 PULL-STEM™ PIN

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	13/64	.377 .357	.300	.2026 .2016	.1840 .1810	.035	.074 .064	.020 .010	1/32 x 37°	.1900-32 UNJF-3A	6,130	3,180	1,050
8	17/64	.440 .415	.330	.2651 .2641	.2440 .2410	.045	.090 .080	.020 .010	1/32 x 37°	.2500-28 UNJF-3A	10,490	5,820	1,950
10	21/64	.505 .475	.390	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	16,000	9,200	3,140
12	25/64	.600 .565	.430	.3901 .3891	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	22,700	14,000	4,850
14	29/64	.676 .641	.495	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	30,600	18,900	6,540
16	33/64	.770 .735	.535	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	39,600	25,600	8,900
18	37/64	.877 .842	.610	.5771 .5761	.5550 .5500	.125	.210 .200	.035 .025	1/16 x 37°	.5625-18 UNJF-3A	49,900	32,400	11,381

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 - ③ 2. Dimensions are in inches and to be met after finish.
 - ③ 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 HSL860F for oversize replacement.

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

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

FINISH: HSL856AP()-()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.

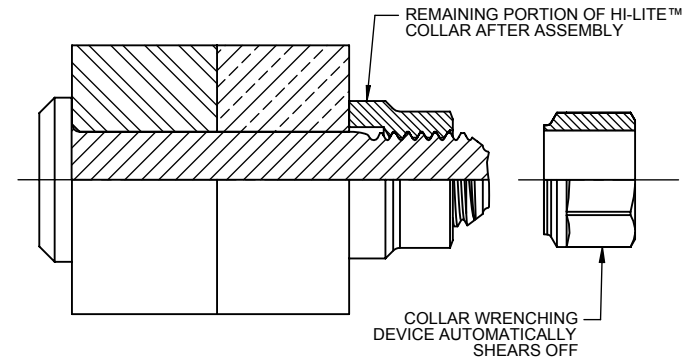
SPECIFICATION: HI-LITE™ Product Specification HS412, except fillet per Detail B.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HSL856F 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:**

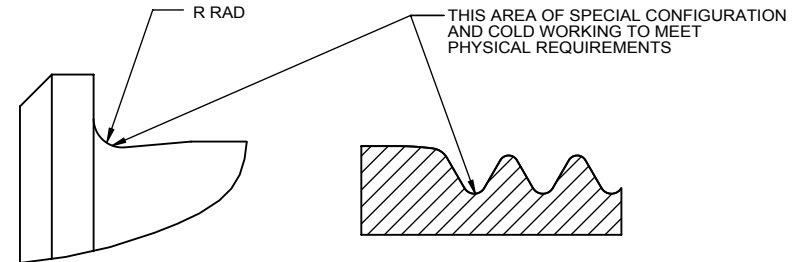
Pin Part Number
HSL856AP8-8F

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



PULL-STEM™ PIN AND COLLAR AFTER ASSEMBLY

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



DETAIL B

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 2004-03-01	TITLE PULL-STEM™ PIN PROTRUDING TENSION HEAD BREAK STEM, INTERFERENCE FIT SPECIAL, TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED M.CAWLEY	DATE 2004-03-01		
REVISION ③	DATE F.CARINGELLA 2017-11-01	DRAWING NUMBER HSL856F	

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

HSL856F