

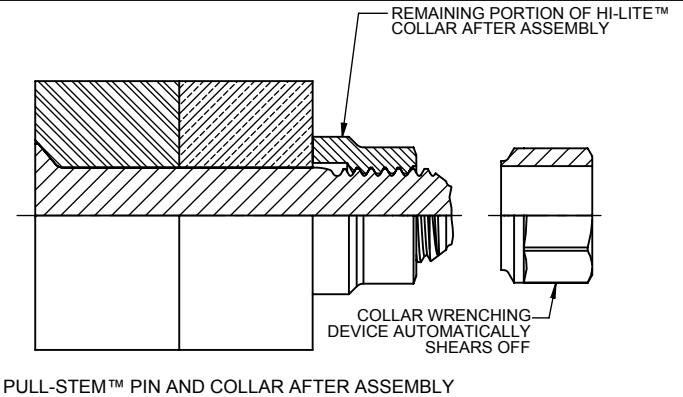
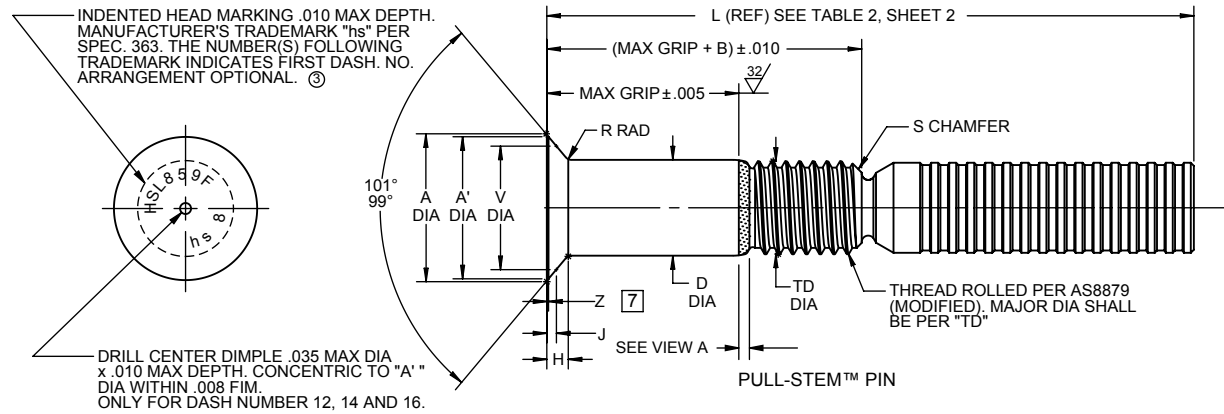


TABLE 1

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-TENSION FATIGUE POUNDS MAXIMUM
6	7/32	.3277	.2963	.300	.2182 .2172	.005	.1840 .1810	.044	.0295 .0263	.030 .020	.2560 .2558	.015	1/32 x 37°	.1900-32 UNJF-3A	7,100	2,405	900
8	9/32	.4283	.3969	.330	.2807 .2797	.006	.2440 .2410	.060	.0227 .0195	.030 .020	.3732 .3730	.015	1/32 x 37°	.2500-28 UNJF-3A	11,800	4,500	1,575
10	11/32	.5361	.5047	.390	.3432 .3422	.007	.3060 .3020	.079	.0234 .0198	.040 .030	.4791 .4789	.015	3/64 x 37°	.3125-24 UNJF-3A	17,600	6,850	2,397
12	13/32	.6415	.6101	.430	.4057 .4047	.008	.3680 .3640	.097	.0295 .0259	.040 .030	.5698 .5696	.015	3/64 x 37°	.3750-24 UNJF-3A	24,600	10,200	3,570
14	15/32	.7425	.6941	.495	.4682 .4672	.009	.4310 .4260	.114	.0347 .0307	.050 .040	.6582 .6580	.022	3/64 x 37°	.4375-20 UNJF-3A	32,700	13,100	4,585
16	17/32	.8423	.7939	.535	.5307 .5297	.010	.4930 .4880	.128	.0504 .0464	.050 .040	.7200 .7198	.022	3/64 x 37°	.5000-20 UNJF-3A	42,000	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:**
- Concentricity: Head edge to "D" 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 AMSE 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.
 - Oversize replacement for HSL755F and HSL855F.

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

HEAT TREAT: 95,000 psi shear minimum.

FINISH: HSL859AP()-() 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 of the pin which HSL859F 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
 HSL859AP8-8F
 L 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, 1/32 OVERSIZE
APPROVED M.CAWLEY	DATE 2004-07-08	
REVISION 3	DATE F.CARINGELLA 2017-11-01	DRAWING NUMBER HSL859F

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

HSL859F

DRAWING NUMBER

HSL859F

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