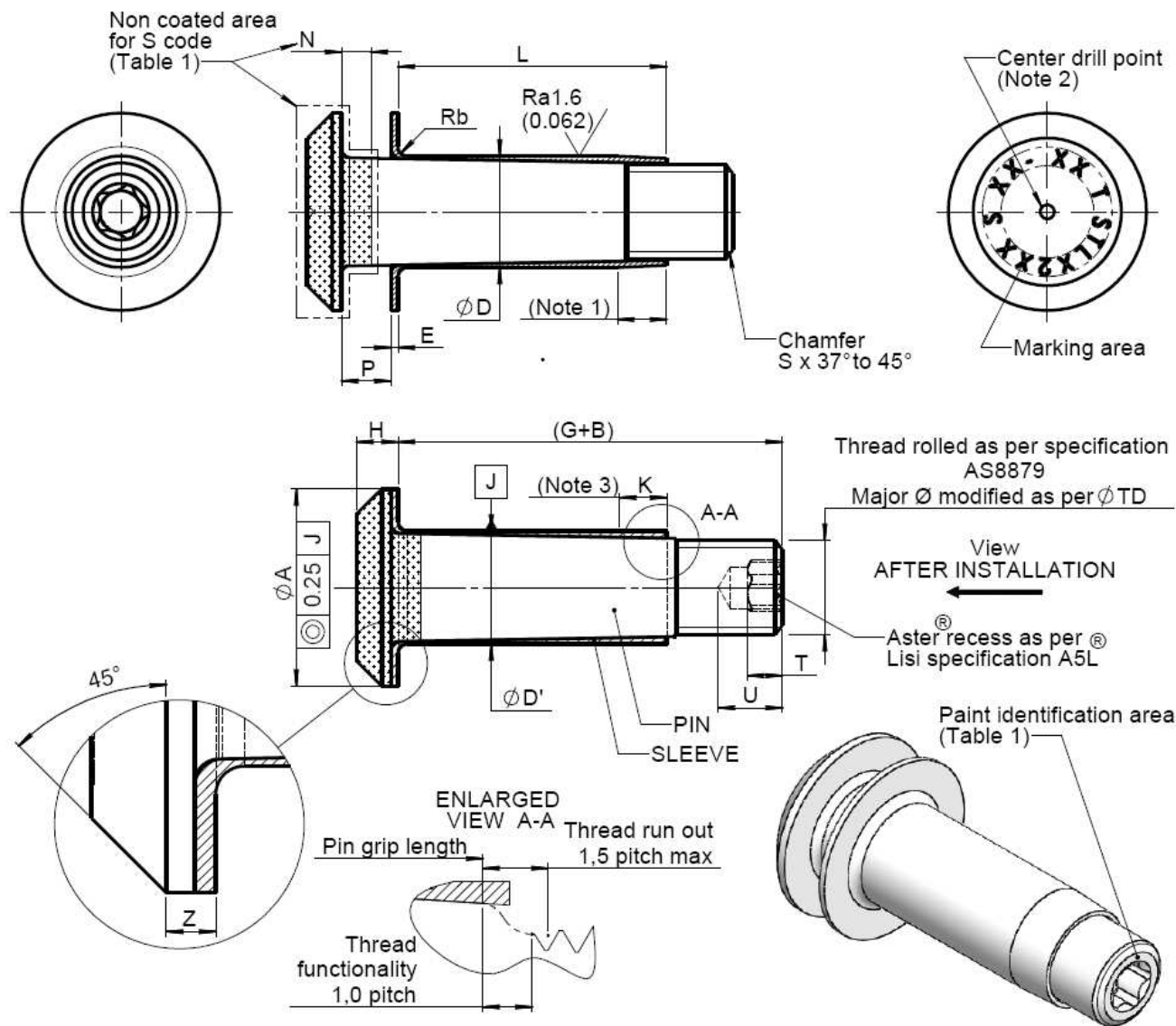




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**SLEEVE TAPER-HI-LITE[®],
PROTRUDING HEAD
INCONEL pin shear 125 ksi min
3/32 grip variation
1st oversize**

STL1250



Note 1: Ø D is not applicable on the non supported sleeve extremity on the length equal to K Max.

Note 2: Drill center dimple in top of head, Ø: 0.9mm (0.0354") Max. Depth: 0.254 mm (0.010") Max. Drill center concentric to ØA within 0.203mm (0.008").

Note 3: The expanded D' diameter shall be in accordance with values specified on table 2, except on sleeve extremity on the length equal to K max. In this area, max diameter may be 0.025mm (.001) greater than D'max, min diameter is identical to D'min.

FIGURE 1

NOTES:

UNLESS OTHERWISE SPECIFIED

I. Units:

Dimensions and tolerances are in millimeters (inch). Dimensions to be met after finish

II. Surface Texture :

Ra3.2 ($\sqrt{125}$) per ASME B46.1 before coating

III. Break sharp edges:

0.05/0.2mm (.002/.008inch). Bolt and sleeve shall be free from burrs

IV. Thread:

Per AS8879 except reduced major Ø as tabulated

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PAGE 1/12	A. BERTHOU		B.REGNARD		5 th – APR – 12	C



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STL1250

1. APPLICATION

This product standard specifies the dimensions, tolerances and properties of an Inconel SLEEVE TAPER-HI-LITE[®] fastener system designed to target 0,6% minimum interference fit for use in composite / composite or composite / aluminum aerospace structure.
It applies to the first oversize STL1250 (+1/64") only. The next repair is covered by STL2250 for second oversize (+1/32"). The nominal size is STL250.
Maximum operating temperature is 235°C (455°F).

2. REQUIREMENTS

Table 1: Material, finish and identification

FINISH CODE	MATERIAL		FINISH		IDENTIFICATION
	PIN	SLEEVE	PIN	SLEEVE	
S	Inconel 718 as per AMS 5962 or 5662 + cold working Min. shear strength : Rc min = 862 MPa (125 ksi)	321 CRES per AMS 5510 or AMS 5645	Non-chromated aluminum based coating: HI-KOTE [®] 1NC as per EN4473 type II except specified area (see figure 1) and Cetyl Alcohol lube per Hi-Shear spec 305 Solvent base	Passivate per AMS 2700. METHOD 1. TYPE 6 or 8. CLASS 3	Blue paint on pin extremity
P	Min. tensile strength : Rm min = 1517 MPa (220 ksi)		Non-chromated aluminum based coating: HI-KOTE [®] 1NC as per EN4473 type II and Cetyl Alcohol lube per Hi-Shear spec 305 Solvent base	and cetyl alcohol lube per Hi-Shear spec 305 Solvent base	

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1st oversize**

STL1250

Table 2: Dimensions and Tolerances

See figure 1

Ø code (1/32")	Thread as per AS8879 Ø TD modified UNJF 3A	Ø A Max	B Max	Ø D ± 0.0125 (±.0005)	Ø D' after installation		E ref	Z min	H ref	P Max	N min	S ref	T min	U Max	Ø TD		Rb Max
					min	Max									min	Max	
6	.1900-32	11,60 (0.457)	15,88 (0.625)	6,722 (0.2646)	6,830 (0.2689)	6,865 (0.2703)	0,60 (0.024)	1,05 (0.041)	2,65 (0.104)	7,23 (0.285)	5,00 (0.197)	0,79 (0.031)	1,85 (0.073)	7,58 (0.298)	4,597 (0.1810)	4,673 (0.1840)	1,25 (0.049)
7	.2160-28	13,10 (0.516)	16,54 (0.651)	7,515 (0.2958)	7,624 (0.3002)	7,659 (0.3015)	0,60 (0.024)	1,05 (0.041)	2,85 (0.112)	7,15 (0.281)	5,00 (0.197)	0,79 (0.031)	1,94 (0.076)	7,83 (0.308)	5,258 (0.2070)	5,334 (0.2100)	1,25 (0.049)
8	.2500-28	14,60 (0.575)	17,43 (0.686)	8,705 (0.3427)	8,821 (0.3473)	8,856 (0.3487)	0,80 (0.031)	1,25 (0.049)	3,45 (0.136)	7,72 (0.304)	5,00 (0.197)	0,79 (0.031)	2,14 (0.084)	8,38 (0.330)	6,121 (0.2410)	6,197 (0.2440)	1,45 (0.057)
10	.3125-24	17,30 (0.681)	21,94 (0.864)	10,293 (0.4052)	10,419 (0.4102)	10,455 (0.4116)	0,80 (0.031)	1,55 (0.061)	4,15 (0.163)	11,42 (0.450)	5,00 (0.197)	1,19 (0.047)	2,24 (0.088)	12,40 (0.488)	7,670 (0.3020)	7,772 (0.3060)	1,90 (0.075)
12	.3750-24	20,00 (0.787)	23,70 (0.933)	12,277 (0.4833)	12,422 (0.4891)	12,459 (0.4905)	1,00 (0.039)	1,75 (0.069)	5,25 (0.207)	12,99 (0.511)	5,00 (0.197)	1,19 (0.047)	2,45 (0.096)	13,59 (0.535)	9,245 (0.3640)	9,347 (0.3680)	1,90 (0.075)
14	.4375-20	22,30 (0.878)	24,26 (0.955)	14,250 (0.5610)	14,405 (0.5671)	14,442 (0.5686)	1,00 (0.039)	1,75 (0.069)	5,75 (0.226)	13,20 (0.520)	5,00 (0.197)	1,19 (0.047)	2,75 (0.108)	13,92 (0.548)	10,820 (0.4260)	10,947 (0.4310)	1,90 (0.075)
16	.5000-20	25,20 (0.992)	25,29 (0.996)	15,837 (0.6235)	16,003 (0.6300)	16,041 (0.6315)	1,00 (0.039)	1,95 (0.077)	6,55 (0.258)	13,90 (0.547)	5,00 (0.197)	1,19 (0.047)	3,11 (0.122)	14,11 (0.556)	12,395 (0.4880)	12,522 (0.4930)	2,15 (0.085)
18	.5625-18	27,40 (1.079)	26,60 (1.047)	17,424 (0.6860)	17,599 (0.6929)	17,637 (0.6944)	1,10 (0.043)	2,55 (0.100)	7,45 (0.293)	14,64 (0.576)	5,00 (0.197)	1,59 (0.063)	3,55 (0.140)	14,23 (0.560)	13,970 (0.5500)	14,097 (0.5550)	2,15 (0.085)
20	.6250-18	29,90 (1.177)	27,92 (1.099)	19,015 (0.7486)	19,209 (0.7563)	19,248 (0.7578)	1,10 (0.043)	2,85 (0.112)	8,25 (0.325)	15,88 (0.625)	5,00 (0.197)	1,59 (0.063)	4,13 (0.163)	14,09 (0.555)	15,545 (0.6120)	15,697 (0.6180)	2,25 (0.089)
24	.7500-16	34,70 (1.366)	30,30 (1.193)	22,584 (0.8891)	22,801 (0.8977)	22,841 (0.8992)	1,30 (0.051)	3,55 (0.140)	9,55 (0.376)	17,56 (0.691)	5,00 (0.197)	1,59 (0.063)	4,87 (0.192)	13,40 (0.528)	18,719 (0.7370)	18,872 (0.7430)	2,30 (0.091)
28	.8750-14	39,80 (1.567)	32,80 (1.291)	26,155 (1.0297)	26,395 (1.0392)	26,436 (1.0408)	1,30 (0.051)	3,75 (0.148)	10,55 (0.415)	19,00 (0.748)	5,00 (0.197)	1,98 (0.078)	5,46 (0.215)	14,65 (0.577)	21,869 (0.8610)	22,047 (0.8680)	2,55 (0.100)
32	1.0000-12	44,70 (1.760)	34,59 (1.362)	29,331 (1.1547)	29,590 (1.1650)	29,632 (1.1666)	1,30 (0.051)	4,65 (0.183)	12,25 (0.482)	20,22 (0.796)	5,00 (0.197)	1,98 (0.078)	6,26 (0.246)	15,97 (0.629)	25,044 (0.9860)	25,222 (0.9930)	2,90 (0.114)
36	1.1250-12	49,50 (1.949)	37,21 (1.465)	32,503 (1.2796)	32,795 (1.2911)	32,838 (1.2928)	1,30 (0.051)	5,15 (0.203)	13,55 (0.533)	22,46 (0.884)	5,00 (0.197)	1,98 (0.078)	7,14 (0.281)	17,91 (0.705)	28,194 (1.1100)	28,372 (1.1170)	3,15 (0.124)

Ø code (1/32")	Thread as per AS8879 Ø TD modified UNJF 3A	Recess size code as per LI SI specification A5L [®]	K Max
6	.1900-32	A5L06	7,86 (0.310)
7	.2160-28	A5L07	7,83 (0.308)
8	.2500-28	A5L08	8,55 (0.337)
10	.3125-24	A5L10	12,23 (0.482)
12	.3750-24	A5L12	13,98 (0.551)
14	.4375-20	A5L14	14,60 (0.575)
16	.5000-20	A5L16	15,36 (0.605)
18	.5625-18	A5L18	15,91 (0.627)
20	.6250-18	A5L20	17,28 (0.680)
24	.7500-16	A5L24	19,03 (0.749)
28	.8750-14	A5L28	20,50 (0.807)
32	1.0000-12	A5L32	21,71 (0.855)
36	1.1250-12	A5L36	24,01 (0.945)

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PROTRUDING HEAD
INCONEL pin shear 125 ksi min
3/32 grip variation
1st oversize**

STL1250

Table 3: Grip length limitations

-Ø	Grip length	
	min	Max
6	4	12
7	5	14
8	5	20
10	6	25
12	7	30
14	8	31
16	9	37
18	10	41
20	11	42
24	14	53
28	15	59
32	16	65
36	18	69

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Table 4: Dimensions, grip, and sleeve length

Length Code 1/16"	Assembly Thickness		L ref	Length Code 1/16"	Assembly Thickness		L ref
	min	Max			min	Max	
4	3,97 (0.156)	6,35 (0.250)	6,35 (0.250)	40	61,12 (2.406)	63,50 (2.500)	63,50 (2.500)
5	5,56 (0.219)	7,93 (0.312)	7,93 (0.312)	41	62,71 (2.469)	65,08 (2.562)	65,08 (2.562)
6	7,15 (0.281)	9,52 (0.375)	9,52 (0.375)	42	64,30 (2.531)	66,67 (2.625)	66,67 (2.625)
7	8,74 (0.344)	11,11 (0.437)	11,11 (0.437)	43	65,89 (2.594)	68,26 (2.687)	68,26 (2.687)
8	10,32 (0.406)	12,70 (0.500)	12,70 (0.500)	44	67,47 (2.656)	69,85 (2.750)	69,85 (2.750)
9	11,91 (0.469)	14,28 (0.562)	14,28 (0.562)	45	69,06 (2.719)	71,43 (2.812)	71,43 (2.812)
10	13,50 (0.531)	15,87 (0.625)	15,87 (0.625)	46	70,65 (2.781)	73,02 (2.875)	73,02 (2.875)
11	15,09 (0.594)	17,46 (0.687)	17,46 (0.687)	47	72,24 (2.844)	74,61 (2.937)	74,61 (2.937)
12	16,67 (0.656)	19,05 (0.750)	19,05 (0.750)	48	73,82 (2.906)	76,20 (3.000)	76,20 (3.000)
13	18,26 (0.719)	20,63 (0.812)	20,63 (0.812)	49	75,41 (2.969)	77,78 (3.062)	77,78 (3.062)
14	19,85 (0.781)	22,22 (0.875)	22,22 (0.875)	50	77,00 (3.031)	79,37 (3.125)	79,37 (3.125)
15	21,44 (0.844)	23,81 (0.937)	23,81 (0.937)	51	78,59 (3.094)	80,96 (3.187)	80,96 (3.187)
16	23,02 (0.906)	25,40 (1.000)	25,40 (1.000)	52	80,17 (3.156)	82,55 (3.250)	82,55 (3.250)
17	24,61 (0.969)	26,98 (1.062)	26,98 (1.062)	53	81,76 (3.219)	84,13 (3.312)	84,13 (3.312)
18	26,20 (1.031)	28,57 (1.125)	28,57 (1.125)	54	83,35 (3.281)	85,72 (3.375)	85,72 (3.375)
19	27,79 (1.094)	30,16 (1.187)	30,16 (1.187)	55	84,94 (3.344)	87,31 (3.437)	87,31 (3.437)
20	29,37 (1.156)	31,75 (1.250)	31,75 (1.250)	56	86,52 (3.406)	88,90 (3.500)	88,90 (3.500)
21	30,96 (1.219)	33,33 (1.312)	33,33 (1.312)	57	88,11 (3.469)	90,48 (3.562)	90,48 (3.562)
22	32,55 (1.281)	34,92 (1.375)	34,92 (1.375)	58	89,70 (3.531)	92,07 (3.625)	92,07 (3.625)
23	34,14 (1.344)	36,51 (1.437)	36,51 (1.437)	59	91,29 (3.594)	93,66 (3.687)	93,66 (3.687)
24	35,72 (1.406)	38,10 (1.500)	38,10 (1.500)	60	92,87 (3.656)	95,25 (3.750)	95,25 (3.750)
25	37,31 (1.469)	39,68 (1.562)	39,68 (1.562)	61	94,46 (3.719)	96,83 (3.812)	96,83 (3.812)
26	38,90 (1.531)	41,27 (1.625)	41,27 (1.625)	62	96,05 (3.781)	98,42 (3.875)	98,42 (3.875)
27	40,49 (1.594)	42,86 (1.687)	42,86 (1.687)	63	97,64 (3.844)	100,01 (3.937)	100,01 (3.937)
28	42,07 (1.656)	44,45 (1.750)	44,45 (1.750)	64	99,22 (3.906)	101,60 (4.000)	101,60 (4.000)
29	43,66 (1.719)	46,03 (1.812)	46,03 (1.812)	65	100,81 (3.969)	103,18 (4.062)	103,18 (4.062)
30	45,25 (1.781)	47,62 (1.875)	47,62 (1.875)	66	102,40 (4.031)	104,77 (4.125)	104,77 (4.125)
31	46,84 (1.844)	49,21 (1.937)	49,21 (1.937)	67	103,99 (4.094)	106,36 (4.187)	106,36 (4.187)
32	48,42 (1.906)	50,80 (2.000)	50,80 (2.000)	68	105,57 (4.156)	107,95 (4.250)	107,95 (4.250)
33	50,01 (1.969)	52,38 (2.062)	52,38 (2.062)	69	107,16 (4.219)	109,53 (4.312)	109,53 (4.312)
34	51,60 (2.031)	53,97 (2.125)	53,97 (2.125)	70			
35	53,19 (2.094)	55,56 (2.187)	55,56 (2.187)	71			
36	54,77 (2.156)	57,15 (2.250)	57,15 (2.250)	72			
37	56,36 (2.219)	58,73 (2.312)	58,73 (2.312)	73			
38	57,95 (2.281)	60,32 (2.375)	60,32 (2.375)	74			
39	59,54 (2.344)	61,91 (2.437)	61,91 (2.437)	75			

Note: Given assembly thickness are the one compatible with the fastener system once installed. Structure creep if any shall be taken into account before fastener grip selection in the table.

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STL1250

Table 5: overall length

Length Code (1/16")	(G+B) Max												
	Ø code (1/32")												
	6	7	8	10	12	14	16	18	20	24	28	32	36
4	22,23 (0.875)												
5	23,81 (0.937)	24,47 (0.963)	25,36 (0.998)										
6	25,40 (1.000)	26,06 (1.026)	26,95 (1.061)	31,46 (1.239)									
7	26,99 (1.063)	27,65 (1.089)	28,54 (1.124)	33,05 (1.301)	34,81 (1.370)								
8	28,58 (1.125)	29,24 (1.151)	30,13 (1.186)	34,64 (1.364)	36,40 (1.433)	36,96 (1.455)							
9	30,16 (1.187)	30,82 (1.213)	31,71 (1.248)	36,22 (1.426)	37,98 (1.495)	38,54 (1.517)	39,57 (1.558)						
10	31,75 (1.250)	32,41 (1.276)	33,30 (1.311)	37,81 (1.489)	39,57 (1.558)	40,13 (1.580)	41,16 (1.620)	42,47 (1.672)					
11	33,34 (1.313)	34,00 (1.339)	34,89 (1.374)	39,40 (1.551)	41,16 (1.620)	41,72 (1.643)	42,75 (1.683)	44,06 (1.735)	45,38 (1.787)				
12	34,93 (1.375)	35,59 (1.401)	36,48 (1.436)	40,99 (1.614)	42,75 (1.683)	43,31 (1.705)	44,34 (1.746)	45,65 (1.797)	46,97 (1.849)				
13		37,17 (1.463)	38,06 (1.498)	42,57 (1.676)	44,33 (1.745)	44,89 (1.767)	45,92 (1.808)	47,23 (1.859)	48,55 (1.911)				
14		38,76 (1.526)	39,65 (1.561)	44,16 (1.739)	45,92 (1.808)	46,48 (1.830)	47,51 (1.870)	48,82 (1.922)	50,14 (1.974)	52,52 (2.068)			
15			41,24 (1.624)	45,75 (1.801)	47,51 (1.870)	48,07 (1.893)	49,10 (1.933)	50,41 (1.985)	51,73 (2.037)	54,11 (2.130)	56,61 (2.229)		
16			42,83 (1.686)	47,34 (1.864)	49,10 (1.933)	49,66 (1.955)	50,69 (1.996)	52,00 (2.047)	53,32 (2.099)	55,70 (2.193)	58,20 (2.291)	59,99 (2.362)	
17			44,41 (1.748)	48,92 (1.926)	50,68 (1.995)	51,24 (2.017)	52,27 (2.058)	53,58 (2.109)	54,90 (2.161)	57,28 (2.255)	59,78 (2.354)	61,57 (2.424)	
18			46,00 (1.811)	50,51 (1.989)	52,27 (2.058)	52,83 (2.080)	53,86 (2.120)	55,17 (2.172)	56,49 (2.224)	58,87 (2.318)	61,37 (2.416)	63,16 (2.487)	65,78 (2.590)
19			47,59 (1.874)	52,10 (2.051)	53,86 (2.120)	54,42 (2.143)	55,45 (2.183)	56,76 (2.235)	58,08 (2.287)	60,46 (2.380)	62,96 (2.479)	64,75 (2.549)	67,37 (2.652)
20			49,18 (1.936)	53,69 (2.114)	55,45 (2.183)	56,01 (2.205)	57,04 (2.246)	58,35 (2.297)	59,67 (2.349)	62,05 (2.443)	64,55 (2.541)	66,34 (2.612)	68,96 (2.715)
21				55,27 (2.176)	57,03 (2.245)	57,59 (2.267)	58,62 (2.308)	59,93 (2.359)	61,25 (2.411)	63,63 (2.505)	66,13 (2.604)	67,92 (2.674)	70,54 (2.777)
22				56,86 (2.239)	58,62 (2.308)	59,18 (2.330)	60,21 (2.370)	61,52 (2.422)	62,84 (2.474)	65,22 (2.568)	67,72 (2.666)	69,51 (2.737)	72,13 (2.840)
23				58,45 (2.301)	60,21 (2.370)	60,77 (2.393)	61,80 (2.433)	63,11 (2.485)	64,43 (2.537)	66,81 (2.630)	69,31 (2.729)	71,10 (2.799)	73,72 (2.902)
24				60,04 (2.364)	61,80 (2.433)	62,36 (2.455)	63,39 (2.496)	64,70 (2.547)	66,02 (2.599)	68,40 (2.693)	70,90 (2.791)	72,69 (2.862)	75,31 (2.965)
25				61,62 (2.426)	63,38 (2.495)	63,94 (2.517)	64,97 (2.558)	66,28 (2.609)	67,60 (2.661)	69,98 (2.755)	72,48 (2.854)	74,27 (2.924)	76,89 (3.027)
26					64,97 (2.558)	65,53 (2.580)	66,56 (2.620)	67,87 (2.672)	69,19 (2.724)	71,57 (2.818)	74,07 (2.916)	75,86 (2.987)	78,48 (3.090)
27					66,56 (2.620)	67,12 (2.643)	68,15 (2.683)	69,46 (2.735)	70,78 (2.787)	73,16 (2.880)	75,66 (2.979)	77,45 (3.049)	80,07 (3.152)
28					68,15 (2.683)	68,71 (2.705)	69,74 (2.746)	71,05 (2.797)	72,37 (2.849)	74,75 (2.943)	77,25 (3.041)	79,04 (3.112)	81,66 (3.215)
29					69,73 (2.745)	70,29 (2.767)	71,32 (2.808)	72,63 (2.859)	73,95 (2.911)	76,33 (3.005)	78,83 (3.104)	80,62 (3.174)	83,24 (3.277)
30					71,32 (2.808)	71,88 (2.830)	72,91 (2.870)	74,22 (2.922)	75,54 (2.974)	77,92 (3.068)	80,42 (3.166)	82,21 (3.237)	84,83 (3.340)
31						73,47 (2.893)	74,50 (2.933)	75,81 (2.985)	77,13 (3.037)	79,51 (3.130)	82,01 (3.229)	83,80 (3.299)	86,42 (3.402)
32							76,09 (2.996)	77,40 (3.047)	78,72 (3.099)	81,10 (3.193)	83,60 (3.291)	85,39 (3.362)	88,01 (3.465)
33							77,67 (3.058)	78,98 (3.109)	80,30 (3.161)	82,68 (3.255)	85,18 (3.354)	86,97 (3.424)	89,59 (3.527)
34							79,26 (3.120)	80,57 (3.172)	81,89 (3.224)	84,27 (3.318)	86,77 (3.416)	88,56 (3.487)	91,18 (3.590)
35							80,85 (3.183)	82,16 (3.235)	83,48 (3.287)	85,86 (3.380)	88,36 (3.479)	90,15 (3.549)	92,77 (3.652)
36							82,44 (3.246)	83,75 (3.297)	85,07 (3.349)	87,45 (3.443)	89,95 (3.541)	91,74 (3.612)	94,36 (3.715)

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**SLEEVE TAPER-HI-LITE[®],
PROTRUDING HEAD
INCONEL pin shear 125 ksi min
3/32 grip variation
1st oversize**

STL1250

Table 5: overall length (continued)

Length Code (1/16")	(G+B) Max												
	Ø code (1/32")												
	6	7	8	10	12	14	16	18	20	24	28	32	36
37							84,02 (3.308)	85,33 (3.359)	86,65 (3.411)	89,03 (3.505)	91,53 (3.604)	93,32 (3.674)	95,94 (3.777)
38								86,92 (3.422)	88,24 (3.474)	90,62 (3.568)	93,12 (3.737)	94,91 (3.840)	97,53 (3.840)
39								88,51 (3.485)	89,83 (3.537)	92,21 (3.630)	94,71 (3.729)	96,50 (3.799)	99,12 (3.902)
40								90,10 (3.547)	91,42 (3.599)	93,80 (3.693)	96,30 (3.791)	98,09 (3.862)	100,71 (3.965)
41								91,68 (3.609)	93,00 (3.661)	95,38 (3.755)	97,88 (3.854)	99,67 (3.924)	102,29 (4.027)
42								94,59 (3.724)	96,97 (3.818)	99,47 (3.916)	101,26 (3.987)	103,88 (4.090)	106,50 (4.215)
43									98,56 (3.880)	101,06 (3.979)	103,56 (4.049)	106,06 (4.152)	108,56 (4.277)
44									100,15 (3.943)	102,65 (4.041)	105,15 (4.112)	107,65 (4.215)	110,15 (4.340)
45									101,73 (4.005)	104,23 (4.104)	106,73 (4.174)	109,23 (4.277)	111,73 (4.402)
46									103,32 (4.068)	105,82 (4.166)	108,32 (4.237)	110,82 (4.340)	113,32 (4.465)
47									104,91 (4.130)	107,41 (4.229)	109,91 (4.299)	112,41 (4.402)	114,91 (4.527)
48									106,50 (4.193)	109,00 (4.291)	111,50 (4.362)	114,00 (4.465)	116,50 (4.590)
49									108,08 (4.255)	110,58 (4.354)	113,08 (4.424)	115,58 (4.527)	118,08 (4.652)
50									109,67 (4.318)	112,17 (4.416)	114,67 (4.487)	117,17 (4.590)	119,67 (4.715)
51									111,26 (4.380)	113,76 (4.479)	116,26 (4.549)	118,76 (4.652)	121,26 (4.777)
52									112,85 (4.443)	115,35 (4.541)	117,85 (4.612)	120,35 (4.715)	122,85 (4.840)
53									114,43 (4.505)	116,93 (4.604)	119,43 (4.674)	121,93 (4.777)	124,43 (4.902)
54									118,52 (4.666)	121,02 (4.764)	123,52 (4.834)	126,02 (4.937)	128,52 (5.062)
55									120,11 (4.729)	122,61 (4.827)	125,11 (4.897)	127,61 (4.990)	130,11 (5.115)
56									121,70 (4.791)	124,20 (4.889)	126,70 (4.959)	129,20 (5.062)	131,70 (5.187)
57									123,28 (4.854)	125,78 (4.952)	128,28 (5.022)	130,78 (5.125)	133,28 (5.250)
58									124,87 (4.916)	127,37 (4.987)	129,87 (5.090)	132,37 (5.215)	134,87 (5.340)
59									126,46 (4.979)	128,96 (5.049)	131,46 (5.152)	133,96 (5.277)	136,46 (5.402)
60										129,54 (5.112)	132,04 (5.215)	134,54 (5.340)	137,04 (5.465)
61										131,12 (5.174)	133,62 (5.277)	136,12 (5.402)	138,62 (5.527)
62										133,01 (5.237)	135,51 (5.340)	138,01 (5.465)	140,51 (5.590)
63										134,60 (5.299)	137,10 (5.402)	139,60 (5.527)	142,10 (5.652)
64										136,19 (5.362)	138,69 (5.465)	141,19 (5.590)	143,69 (5.715)
65										137,77 (5.424)	140,27 (5.527)	142,77 (5.652)	145,27 (5.777)
66											141,85 (5.590)	144,35 (5.715)	146,85 (5.840)
67												143,43 (5.652)	145,93 (5.777)
68													145,16 (5.715)
69													146,74 (5.777)

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**SLEEVE TAPER-HI-LITE[®],
PROTRUDING HEAD
INCONEL pin shear 125 ksi min
3/32 grip variation
1st oversize**

STL1250

Table 6: Tensile strength, fatigue load, shear strength

Ø code (1/32")	Min. Axial Tensile Strength N (lbf)	Max Tension Fatigue Load N (lbf)	Double Shear Strength N (lbf)
6	18 580 (4,177)	6 503 (1,462)	41 260 (9,276)
7	23 970 (5,389)	8 390 (1,886)	52 870 (11,886)
8	33 810 (7,601)	11 834 (2,660)	70 130 (15,766)
10	53 980 (12,135)	18 893 (4,247)	104 580 (23,511)
12	81 660 (18,358)	28 581 (6,425)	150 510 (33,836)
14	110 370 (24,812)	38 630 (8,684)	204 280 (45,924)
16	148 710 (33,431)	52 049 (11,701)	258 490 (58,111)
18	188 720 (42,426)	66 052 (14,849)	321 610 (72,301)
20	237 980 (53,500)	83 293 (18,725)	392 270 (88,186)
24	346 760 (77,955)	121 366 (27,284)	561 590 (126,251)
28	473 690 (106,490)	165 792 (37,271)	761 240 (171,134)
32	616 470 (138,588)	215 765 (48,506)	975 840 (219,378)
36	795 620 (178,863)	278 467 (62,602)	1 223 480 (275,049)

Notes: - Mechanical properties applied at room temperature.
- Tensile strength and fatigue load values are valid for fastener pin only. Global fastener performances depend on associated nut mechanical characteristics.

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**SLEEVE TAPER-HI-LITE® ,
PROTRUDING HEAD
INCONEL pin shear 125 ksi min
3/32 grip variation
1st oversize**

STL1250

Table 7: mass

Length Code (1/16")	Mass (kg/1000 parts)For information only												
	Ø code (1/32")												
	6	7	8	10	12	14	16	18	20	24	28	32	36
4	5,29 (11.67)												
5	5,77 (12.71)	7,56 (16.66)	10,83 (23.87)										
6	6,30 (13.89)	8,24 (18.16)	11,63 (25.63)	18,27 (40.29)									
7	6,77 (14.93)	8,83 (19.46)	12,42 (27.37)	19,39 (42.74)	29,59 (65.24)								
8	7,25 (15.98)	9,42 (20.76)	13,20 (29.11)	20,49 (45.17)	31,17 (68.72)	42,65 (94.02)							
9	7,96 (17.55)	10,35 (22.81)	13,99 (30.85)	21,59 (47.60)	32,74 (72.17)	44,76 (98.69)	60,46 (133.29)						
10	8,43 (18.59)	10,94 (24.11)	15,27 (33.67)	23,51 (51.84)	34,31 (75.63)	46,89 (103.37)	63,08 (139.06)	82,78 (182.49)					
11	8,92 (19.66)	11,53 (25.41)	16,07 (35.43)	24,62 (54.29)	35,88 (79.09)	49,00 (108.03)	65,68 (144.81)	85,94 (189.46)	109,67 (241.78)				
12	9,39 (20.70)	12,12 (26.71)	16,86 (37.17)	25,73 (56.72)	37,45 (82.57)	51,12 (112.69)	68,30 (150.58)	89,09 (196.41)	113,43 (250.08)				
13		12,72 (28.04)	17,65 (38.91)	26,84 (59.17)	40,36 (88.98)	53,23 (117.36)	70,91 (156.33)	92,25 (203.37)	117,21 (258.40)				
14		13,31 (29.34)	18,45 (40.68)	27,94 (61.60)	41,94 (92.46)	55,35 (122.02)	73,52 (162.08)	95,41 (210.34)	120,97 (266.70)	187,09 (412.47)			
15			19,24 (42.42)	29,05 (64.05)	43,51 (95.92)	57,45 (126.66)	76,13 (167.83)	98,56 (217.29)	124,74 (274.99)	192,40 (424.16)	273,50 (602.97)		
16			20,03 (44.16)	30,16 (66.48)	45,08 (99.38)	59,57 (131.32)	78,74 (173.60)	101,72 (224.26)	128,49 (283.27)	197,70 (435.85)	280,62 (618.67)	385,67 (850.25)	
17			20,82 (45.90)	31,26 (68.91)	46,66 (102.86)	63,34 (139.64)	81,34 (179.33)	104,87 (231.20)	132,25 (291.57)	203,00 (447.54)	287,73 (634.35)	394,62 (870.00)	
18			21,61 (47.64)	32,36 (71.34)	48,23 (106.32)	65,46 (144.31)	85,72 (188.98)	109,34 (241.06)	136,02 (299.86)	208,30 (459.23)	294,86 (650.05)	403,57 (889.73)	534,65 (1,178.70)
19			22,40 (49.38)	33,47 (73.79)	49,79 (109.78)	67,57 (148.97)	88,33 (194.73)	112,50 (248.03)	139,77 (308.14)	213,60 (470.92)	301,97 (665.72)	412,52 (909.45)	545,64 (1,202.94)
20			23,19 (51.12)	34,57 (76.22)	51,36 (113.24)	69,69 (153.63)	90,94 (200.50)	115,66 (254.99)	144,35 (318.25)	218,90 (482.59)	309,08 (681.40)	421,46 (929.16)	556,63 (1,227.15)
21				35,68 (78.65)	52,93 (116.69)	71,80 (158.29)	93,55 (206.25)	118,82 (261.96)	148,13 (326.56)	224,44 (494.80)	316,19 (697.08)	430,41 (948.88)	567,62 (1,251.39)
22				37,79 (83.31)	54,50 (120.15)	73,91 (162.95)	96,17 (212.02)	121,98 (268.93)	151,89 (334.86)	229,75 (506.52)	323,29 (712.74)	439,34 (968.59)	578,60 (1,275.60)
23				38,90 (85.76)	56,07 (123.61)	76,03 (167.62)	98,78 (217.77)	125,15 (275.90)	155,65 (343.16)	235,06 (518.23)	330,75 (729.19)	448,29 (988.32)	589,59 (1,299.82)
24				40,00 (88.19)	59,34 (130.82)	78,13 (172.26)	101,39 (223.52)	128,30 (282.85)	159,42 (351.46)	240,37 (529.92)	337,88 (744.89)	457,23 (1,008.02)	600,56 (1,324.01)
25				41,11 (90.62)	60,92 (134.30)	80,25 (176.92)	103,99 (229.27)	131,46 (289.81)	163,18 (359.75)	245,68 (541.63)	345,00 (760.59)	466,60 (1,028.67)	611,55 (1,348.23)
26					62,48 (137.76)	82,36 (181.58)	106,61 (235.04)	134,61 (296.76)	166,95 (368.05)	250,98 (553.32)	352,12 (776.29)	475,56 (1,048.42)	622,52 (1,372.42)
27					64,05 (141.21)	84,47 (186.22)	109,22 (240.79)	137,77 (303.73)	170,71 (376.35)	256,28 (565.01)	359,24 (791.99)	484,51 (1,068.17)	634,13 (1,398.03)
28					65,62 (144.67)	86,58 (190.88)	111,83 (246.53)	140,92 (310.67)	174,47 (384.65)	261,59 (576.70)	366,36 (807.69)	493,46 (1,087.90)	645,14 (1,422.28)
29					67,19 (148.13)	88,69 (195.52)	114,43 (252.28)	144,08 (317.64)	178,23 (392.92)	266,90 (588.41)	373,48 (823.39)	502,41 (1,107.62)	656,13 (1,446.52)
30					68,76 (151.59)	90,80 (200.19)	117,03 (258.01)	147,23 (324.59)	181,99 (401.22)	272,20 (600.10)	380,59 (839.07)	511,37 (1,127.37)	667,13 (1,470.76)
31						92,91 (204.83)	119,64 (263.76)	150,38 (331.53)	185,75 (409.52)	277,50 (611.79)	387,72 (854.77)	520,32 (1,147.10)	678,13 (1,495.02)
32							122,25 (269.51)	153,54 (338.50)	189,51 (417.79)	282,80 (623.46)	394,83 (870.44)	529,26 (1,166.83)	689,12 (1,519.26)
33							124,85 (275.26)	156,69 (345.45)	193,27 (426.09)	288,10 (635.15)	401,94 (886.12)	538,21 (1,186.55)	700,12 (1,543.49)
34							127,45 (280.98)	159,84 (352.39)	197,02 (434.37)	293,40 (646.84)	409,05 (901.80)	547,16 (1,206.28)	711,11 (1,567.73)
35							130,06 (286.73)	162,99 (359.34)	200,78 (442.64)	298,69 (658.51)	416,16 (917.48)	556,10 (1,225.99)	722,09 (1,591.95)
36							132,66 (292.46)	170,50 (375.90)	210,43 (463.92)	304,00 (670.19)	423,27 (933.16)	565,05 (1,245.71)	733,09 (1,616.18)

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Table 7: mass (continued)

Length Code (1/16")	Mass (kg/1000 parts)For information only												
	6	7	8	10	12	14	Ø code (1/32")						
							16	18	20	24	28	32	36
37							133,70 (294.76)	168,46 (371.39)	208,51 (459.69)	302,54 (666.99)	422,56 (931.59)	565,18 (1,246.01)	734,31 (1,618.88)
38							171,48 (378.05)	212,12 (467.64)	307,65 (678.25)	429,45 (946.78)	573,89 (1,265.21)	745,03 (1,642.51)	
39							174,49 (384.68)	215,73 (475.60)	312,77 (689.54)	436,35 (961.99)	582,59 (1,284.39)	755,76 (1,666.17)	
40							177,51 (391.34)	219,34 (483.56)	323,93 (714.14)	443,24 (977.18)	591,29 (1,303.57)	766,48 (1,689.80)	
41							180,53 (398.00)	222,95 (491.52)	329,06 (725.45)	450,14 (992.39)	599,99 (1,322.75)	777,20 (1,713.43)	
42							226,56 (499.48)	334,18 (736.74)	457,03 (1,007.58)	608,69 (1,341.93)	787,91 (1,737.04)		
43									339,30 (748.03)	463,92 (1,022.77)	617,38 (1,361.09)	798,63 (1,760.68)	
44									344,43 (759.34)	470,81 (1,037.96)	626,08 (1,380.27)	809,34 (1,784.29)	
45									349,55 (770.63)	477,70 (1,053.15)	634,77 (1,399.43)	820,06 (1,807.92)	
46									354,67 (781.91)	484,59 (1,068.34)	643,47 (1,418.61)	830,77 (1,831.53)	
47									359,79 (793.20)	491,48 (1,083.53)	652,16 (1,437.77)	841,48 (1,855.15)	
48									364,91 (804.49)	498,36 (1,098.70)	660,85 (1,456.92)	852,19 (1,878.76)	
49									370,03 (815.78)	505,25 (1,113.89)	669,54 (1,476.08)	862,90 (1,902.37)	
50									375,15 (827.06)	518,94 (1,144.07)	678,23 (1,495.24)	873,60 (1,925.96)	
51									380,26 (838.33)	525,84 (1,159.28)	686,92 (1,514.40)	885,37 (1,951.91)	
52									385,38 (849.62)	532,74 (1,174.49)	700,52 (1,544.38)	896,10 (1,975.56)	
53									390,50 (860.91)	539,64 (1,189.70)	709,23 (1,563.58)	906,83 (1,999.22)	
54										546,54 (1,204.91)	717,93 (1,582.76)	917,56 (2,022.87)	
55										553,44 (1,220.13)	726,64 (1,601.97)	928,29 (2,046.53)	
56										560,34 (1,235.34)	735,35 (1,621.17)	939,01 (2,070.16)	
57										567,24 (1,250.55)	744,05 (1,640.35)	949,74 (2,093.82)	
58										574,13 (1,265.74)	752,75 (1,659.53)	960,47 (2,117.47)	
59										581,03 (1,280.95)	761,46 (1,678.73)	971,19 (2,141.11)	
60										770,16 (1,697.91)	981,91 (2,164.74)		
61										778,86 (1,717.09)	992,64 (2,188.40)		
62										787,56 (1,736.27)	1 003,36 (2,212.03)		
63										796,26 (1,755.45)	1 014,08 (2,235.66)		
64										804,96 (1,774.63)	1 024,80 (2,259.30)		
65										813,66 (1,793.81)	1 035,52 (2,282.93)		
66												1 046,24 (2,306.56)	
67												1 056,96 (2,330.20)	
68												1 067,67 (2,353.81)	
69												1 078,39 (2,377.44)	

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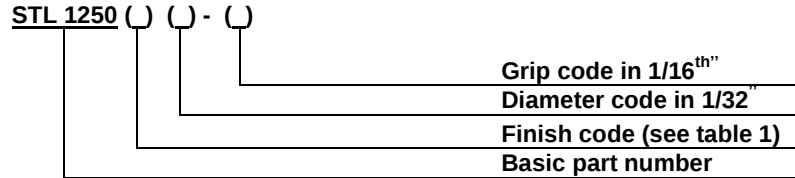


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INCONEL pin shear 125 ksi min
3/32 grip variation
1st oversize**

STL1250

3. DESIGNATION



Example:

STL1250P10 – 34 : SLEEVE TAPER-HI-LITE[®] fastener system protruding head 1st oversize (+1/64" diameter), 0.6% minimum interference fit, Inconel pin with HK1NC + cetyl alcohol lube and stainless steel passivated sleeve, diameter 10/32" and 34/16" length.

4. MARKING

Designation and manufacturer identification per EN2424 style B with 0.25 mm (.01 inch) max depth, bolt only. Marking location as specified on Figure 1.

5. QUALIFICATION AND ACCEPTANCE

The fastener shall meet all the inspection requirements of LISI AEROSPACE Product Specification STL-TS01.

6. INSTALLATION

Refer to STL-IS10.

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**SLEEVE TAPER-HI-LITE[®],
PROTRUDING HEAD
INCONEL pin shear 125 ksi min
3/32 grip variation
1st oversize**

STL1250

Issue	Date	Modifications	Justification
A	SEPT 21 st 2010	First release	
B	MAR 21 st 2011	K added L dim changed in ref Modification of view A-A H changed in ref. table (G+B) added	Improvement for better understanding (no design change)
C	APR 5 th 2012	P dim corrected ASTER [®] codification modified	To be in accordance with definition drawings

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