

GENERAL NOTES: 1. Concentricity: "A" to "D" diameter within .010 FIM. 2. Dimensions in inches and to be met after finish. ② 3. Surface texture per ASME B46.1.

- - 4. Hole preparation per HSL/HPL-IS01: PULL-STEM™ / PULL-IN™ fastener installation specification for HSL/HPL pins.
 - 5. HPL1424 is the oversize replacement for HPL1414.
 - 6. Use HPL1434 for oversize replacement.
- Bornel is sold separately.
 8. Product in accordance with LISI AEROSPACE Product Specification N°415.
- <u>9</u> One line indicates Blanc Aero Industries, France as manufacturer.

 <u>10</u> The maximum allowable installation load must not exceed the
- maximum load values in table or thread/mandrel failure may occur.
- 11 After February 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in the European Union.

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-IN" AND "HPL", ARE TRADEMARKS OF HI-SHEAR CORPORATION							
DRAWN BY	DATE A 2012-06-21	PULL-STEM™ PIN					
		SLEF-ALIGNING TENSION HEAD					
APPROVED	DATE		4.0.				
J.GOYER	2012-06-21	NICKEL BASE ALLOY (INCONEL 7					
		1/16 GRIP VARIATION, 1/64 OVERS	SIZE				
REVISION	DATE	DRAWING NUMBER					
2	F.CARINGELLA 2017-10-30	HPL1424 10	F 2				

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			FINISH TAB	LE			
Γ	Part	Finish, Lube, ID Code	Finish	Lube	Idenitfication		
	Inconel Pin	11 _{SU}	HI-KOTE™ 1 Aluminum Pigmented Coating per Hi-Shear Spec. 294	Cetyl alcohol lube per Hi-Shear	Blue color on pin end		
		NSU	HI-KOTE™ 1 NC Aluminum Pigmented Coating per Hi-Shear Spec. 294				
	Titanium Washer	11 APW	HI-KOTE™ 1 Aluminum Pigmented Coating per Hi-Shear Spec. 294	Cetyl alcohol lube per Hi-Shear	White spot on outside diameter		
		NAPW	HI-KOTE™ 1 NC Aluminum Pigmented Coating per Hi-Shear Spec. 294	Spec. 305			
			m alloy per AMS4928 or AM4967.				
EAT TREAT		Pin = 220,000 psi tensile minimum and 125,000 psi shear minimum. Washer = 160,000 psi tensile minimum and 95,000 psi shear minimum.					
CODE	First dash number indicates nominal diameter in 1/32nds of the pin which HPL1424 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.						
TO ORDER		NSU 18 NAP					

DRAWING NUMBER

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