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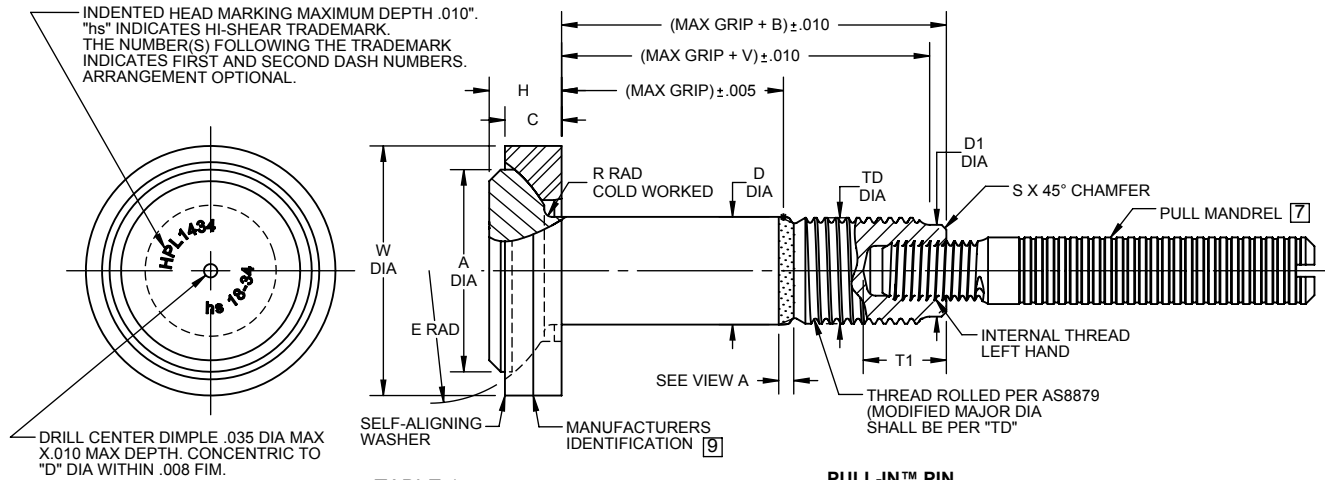


TABLE 1

PULL-IN™ PIN

EXAMPLE OF PULL-IN™ PIN AND NUT/COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA REF	B REF	D DIA	TD DIA	D1 DIA	W DIA	H MAX	S CHAMFER REF	V REF	E RAD	R RAD ROLLED	C REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND ¹⁰			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS MAX
															T1 MAX	THREAD SIZE UNJF-2B	LOAD POUNDS MAX			
18	19/32	1.051	.845	.5927 .5917	.5550 .5500	.4783 .4764	1.307 1.300	.382	.020	.701	.688	.040 .025	.303	.5625-18 UNJF-3A	.465	5/16-SP	11,500	69,200	44,321	15,700
20	21/32	1.130	.935	.6552 .6542	.6180 .6120	.5413 .5394	1.437 1.430	.405	.020	.733	.750	.040 .025	.319	.6250-18 UNJF-3A	.520	3/8-SP	14,200	84,600	49,458	16,816
24	25/32	1.291	1.125	.7802 .7792	.7430 .7370	.6575 .6555	1.689 1.681	.547	.020	.927	.875	.045 .030	.358	.7500-16 UNJF-3A	.625	7/16-SP	19,109	119,800	81,469	28,500
28	29/32	1.449	1.315	.9052 .9042	.8680 .8610	.7717 .7697	1.921 1.913	.634	.020	1.021	1.000	.050 .035	.390	.8750-14 UNJF-3A	.725	1/2-SP	31,500	160,100	112,121	38,210
32	1-1/32	1.602	1.500	1.0302 1.0292	.9930 .9860	.8819 .8799	2.134 2.126	.712	.020	1.151	1.125	.060 .045	.437	1.0000-12 UNJF-3A	.830	9/16-SP	38,218	207,400	132,100	48,900

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions in inches and to be met after finish.
 - ③ 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. HPL1434 is the oversize replacement for HPL1424.
 6. Use HPL1444 for oversize replacement.
 - ⑦ 7. Mandrel is sold separately.
 8. Product in accordance with LISI AEROSPACE Product Specification N°415.
 - ⑨ 9. One line indicates Blanc Aero Industries, France as manufacturer.
 - ⑩ 10. The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.
 - ⑪ 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 "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY ASSYSTEM	DATE 2012-05-21	TITLE PULL-IN™ PIN SELF-ALIGNING TENSION HEAD INTERFERENCE FIT NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED JGOYER	DATE 2012-05-21	DRAWING NUMBER HPL1434	
REVISION ②	DATE F.CARINGELLA 2017-10-26	1 OF 2	

FINISH TABLE

Part	Finish, Lube, ID Code	Finish	Lube	Identification
Inconel Pin	11 SU	HI-KOTE™ 1 Aluminum Pigmented Coating per Hi-Shear Spec. 294	Cetyl alcohol lube per Hi-Shear Spec. 305	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 Spec. 305	White spot on outside diameter
	NAPW	HI-KOTE™ 1 NC Aluminum Pigmented Coating per Hi-Shear Spec. 294		

MATERIAL: Pin = Nickel base alloy (Inconel 718) per AMS5662 or AMS5962.
 Washer = 6Al-4V Titanium alloy per AMS4928 or AM4967.

HEAT 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 HPL1434 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See "Finish" note for explanation of code letters.

HOW TO ORDER Pin-Washer Assembly Part Number
 © **EXAMPLE:** HPL1434 NSU 18 NAPW 34

└─── 34/16 Maximum Grip Length
 └─── Washer finish code
 └─── 18/32 or 9/16 Nominal Diameter Pin
 └─── Finish Code
 └─── Pin Basic Part Number

HPL1434

DRAWING NUMBER

HPL1434

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