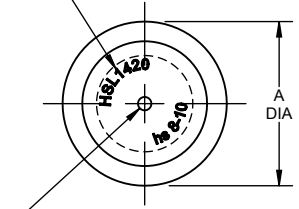
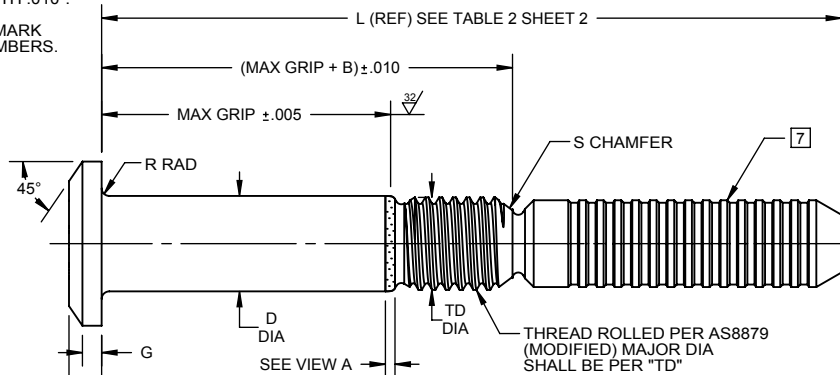


INDENTED HEAD MARKING MAXIMUM DEPTH .010".
 "hs" INDICATES HI-SHEAR TRADEMARK.
 THE NUMBER(S) FOLLOWING THE TRADEMARK
 INDICATES FIRST AND SECOND DASH NUMBERS.
 ARRANGEMENT OPTIONAL.



DRILL CENTER DIMPLE
 .035 MAX DIA X .010 MAX DEPTH.
 CONCENTRIC TO "A" DIA WITHIN
 .008 FIM



PULL-STEM™ PIN

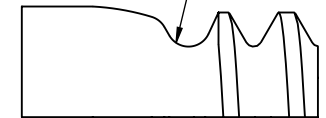
TABLE 1

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFID	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS MAX
6	13/64	.337 .357	.300	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32 X 45°	.1900-32 UNJF-3A	8,100	4,350	1,560
7	15/64	.410 .390	.315	.2338 .2328	.2100 .2070	.040	.081 .071	.025 .015	1/32 X 45°	.2160-28 UNJF-3A	10,646	5,634	1,972
8	17/64	.440 .415	.330	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32 X 45°	.2500-28 UNJF-3A	13,800	7,750	2,800
10	21/64	.505 .475	.390	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64 X 45°	.3125-24 UNJF-3A	21,100	12,605	4,420
12	25/64	.600 .565	.430	.3901 .3891	.3680 .3640	.075	.140 .130	.030 .020	3/64 X 45°	.3750-24 UNJF-3A	30,000	19,176	6,840
14	29/64	.676 .641	.495	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64 X 45°	.4375-20 UNJF-3A	40,300	25,815	9,270
16	33/64	.770 .735	.535	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64 X 45°	.5000-20 UNJF-3A	52,500	34,300	12,300

PULL-STEM™ PIN AND NUT/COLLAR AFTER ASSEMBLY

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

THIS AREA OR SPECIAL CONFIGURATION
 AND COLD WORKING TO MEET PHYSICAL
 REQUIREMENTS.



VIEW A

HI-LITE™ THREAD TRANSITION AREA.
 SEE SPECIFICATION FOR INSPECTION

- GENERAL NOTES:**
- Concentricity: "A" to "D" diameter within .010 FIM.
 - Dimensions in inches and to be met after finish.
 - Surface texture per AMSE B46.1.
 - Hole preparation per HSL/HPL-IS01: PULL-STEM™ / PULL-IN™ fastener installation specification for HSL/HPL pins.
 - HSL1420 is the oversize replacement for HSL1410.
 - Use HSL1430 for oversize replacement.
 - Coating and lube not mandatory on pintail.
 - Product in accordance with LISI AEROSPACE Product Specification N°415

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HSL1420 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See "Finish" note for explanation of code letters.

HOW TO ORDER
 ① **EXAMPLE:**

Pin Part Number
 HSL1420NAP8-8
 — 8/16 or 1/2 Maximum Grip Length
 — 8/32 or 1/4 Nominal Diameter Pin
 — Finish Code
 — Pin Basic Part Number

MATERIAL: Pin = Nickel base alloy (Inconel 718) per AMS5662 or AMS5962.

HEAT TREAT: Pin = 220,000 psi tensile minimum and 125,000 psi shear minimum.

FINISH: HSL1420NAP()-() = HI-KOTE™1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

"HI-KOTE", "HI-LITE", "PULL-STEM" AND "HSL",
 ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY F.CARINGELLA	DATE 2016-02-15	TITLE PULL-STEM™ PIN PROTRUDING TENSION HEAD BREAK STEM, INTERFERENCE FIT NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED C.REITZ	DATE 2016-02-15	
REVISION ①	DATE F.CARINGELLA 2017-10-27	DRAWING NUMBER HSL1420

TABLE 2

SECOND DASH NUMBER	L REF						
	-6 DIA.	-7 DIA.	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.
1	-	-	-	-	-	-	-
2	1.000	1.000	1.000	-	-	-	-
3	1.125	1.125	1.125	1.250	-	-	-
4	1.250	1.250	1.250	1.375	1.375	-	-
5	1.375	1.375	1.375	1.500	1.500	1.625	-
6	1.500	1.500	1.500	1.625	1.625	1.750	1.750
7	1.625	1.625	1.625	1.750	1.750	1.875	1.875
8	1.750	1.750	1.750	1.875	1.875	2.000	2.000
9	1.875	1.875	1.875	2.000	2.000	2.125	2.125
10	2.000	2.000	2.000	2.125	2.125	2.250	2.250
11	2.125	2.125	2.125	2.250	2.250	2.375	2.375
12	2.250	2.250	2.250	2.375	2.375	2.500	2.500
13	2.375	2.375	2.375	2.500	2.500	2.625	2.625
14	2.500	2.500	2.500	2.625	2.625	2.750	2.750
15	2.625	2.625	2.625	2.750	2.750	2.875	2.875
16	2.750	2.750	2.750	2.875	2.875	3.000	3.000
17	2.875	2.875	2.875	3.000	3.000	3.125	3.125
18	3.000	3.000	3.000	3.125	3.125	3.250	3.250
19	3.125	3.125	3.125	3.250	3.250	3.375	3.375
20	3.250	3.250	3.250	3.375	3.375	3.500	3.500
21	3.375	3.375	3.375	3.500	3.500	3.625	3.625
22	3.500	3.500	3.500	3.625	3.625	3.750	3.750
23	3.625	3.625	3.625	3.750	3.750	3.875	3.875
24	3.750	3.750	3.750	3.875	3.875	4.000	4.000
25	-	-	-	4.000	4.000	4.125	4.125
26	-	-	-	4.125	4.125	4.250	4.250
27	-	-	-	4.250	4.250	4.375	4.375
28	-	-	-	4.375	4.375	4.500	4.500
29	-	-	-	-	4.500	4.625	4.625
30	-	-	-	-	4.625	4.750	4.750
31	-	-	-	-	4.750	4.875	4.875
32	-	-	-	-	4.875	5.000	5.000
33	-	-	-	-	5.000	5.125	5.125
34	-	-	-	-	5.125	5.250	5.250
35	-	-	-	-	5.250	5.375	5.375
36	-	-	-	-	5.375	5.500	5.500
37	-	-	-	-	5.500	5.625	5.625
38	-	-	-	-	5.625	5.750	5.750
39	-	-	-	-	5.750	5.875	5.875
40	-	-	-	-	5.875	6.000	6.000
41	-	-	-	-	6.000	6.125	6.125
42	-	-	-	-	6.125	6.250	6.250
43	-	-	-	-	6.250	6.375	6.375
44	-	-	-	-	6.375	6.500	6.500

HSL1420

DRAWING NUMBER

HSL1420

2 OF 2