lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company
Design Holder
CAGE No. 73197

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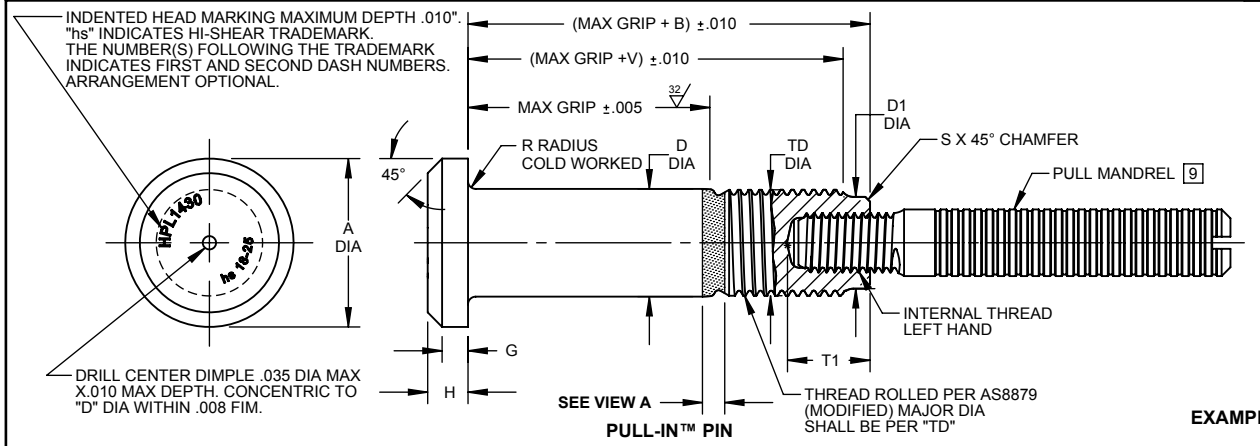
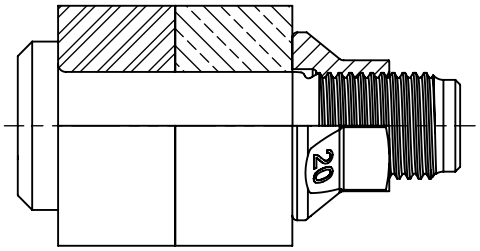
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES

①



PULL-IN™ PIN



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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	D1 DIA	G REF	H	R RAD ROLLED	S CHAMFER REF	V REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND [7]			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS MAX
													T1 MAX	THREAD SIZE UNJF-2B	LOAD POUNDS MAX			
18	9/16	.900 .865	.844	.5927 .5917	.5550 .5500	.4783 .4764	.125	.210 .200	.040 .025	.020	.701	.5625-18 UNJF-3A	.465	5/16-SP	11,500	69,200	44,321	15,700
20	5/8	.970 .935	.935	.6552 .6542	.6180 .6120	.5413 .5394	.140	.238 .228	.040 .025	.020	.733	.6250-18 UNJF-3A	.520	3/8-SP	14,200	84,600	49,458	16,816
24	3/4	1.185 1.145	1.125	.7802 .7792	.7430 .7370	.6575 .6555	.200	.335 .320	.045 .030	.020	.927	.7500-16 UNJF-3A	.625	7/16-SP	19,109	119,800	81,469	28,500
28	7/8	1.350 1.310	1.315	.9052 .9042	.8680 .8610	.7717 .7697	.250	.385 .370	.050 .035	.020	1.021	.8750-14 UNJF-3A	.725	1/2-SP	31,500	160,100	112,121	38,210
32	1	1.530 1.490	1.500	1.0302 1.0292	.9930 .9860	.8819 .8799	.300	.435 .420	.060 .045	.020	1.151	1.0000-12 UNJF-3A	.830	9/16-SP	38,218	207,400	132,100	48,900

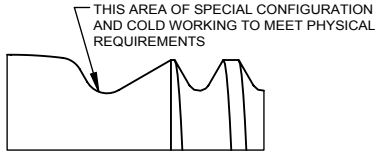
SEE NUT/COLLAR STANDARDS FOR STRENGTHS. LOWER STRENGTH (PIN OR NUT/COLLAR) DETERMINES SYSTEM STRENGTH.

GENERAL NOTES:
1. Concentricity: "A" dia to "D" diameter within .010 FIM.
2. Dimensions in inches and to be met after finish.
① 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. HPL1430 is the oversize replacement for HPL1420.
6. Use HPL1440 for oversize replacement.
[7] The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.
8. Product in accordance with LISI AEROSPACE Product Specification N°415.
[9] Mandrel is sold separately.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HPL1430 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

HOW TO ORDER

① **EXAMPLES:** Pin Part Number
HPL1430NAP18-25
- 25/16 Maximum Grip Length
- 18/32 or 9/16 Nominal Diameter Pin
- Finish Code
- Pin Basic Part Number



VIEW A

HI-LITE™ THREAD TRANSITION AREA
SEE SPECIFICATION FOR INSPECTION

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: HPL1430NAP( )-( ) = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

HPL1430NSU( )-( ) = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, with color blue on pin end, and cetyl alcohol lube per Hi-Shear Spec. 305.

DRAWN BY	DATE
F. CARINGELLA	2016-02-09
APPROVED	DATE
C. REITZ	2016-02-09
REVISION	DATE
①	F.CARINGELLA 2017-11-13

TITLE
PULL-IN™ PIN
PROTRUDING TENSION HEAD
INTERFERENCE FIT
NICKEL BASE ALLOY (INCONEL 718),
1/16 GRIP VARIATION, 1/32 OVERSIZE

DRAWING NUMBER
HPL1430

HPL1430