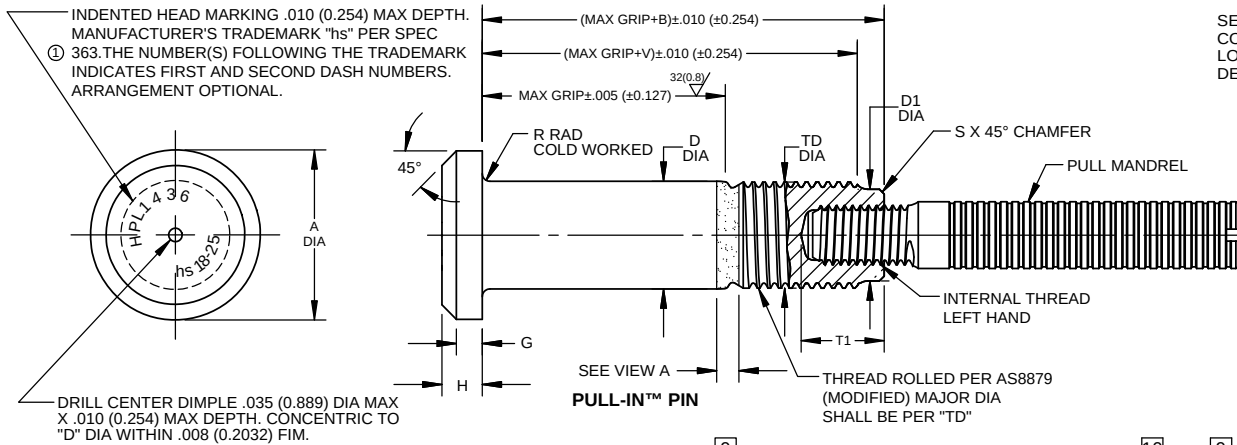
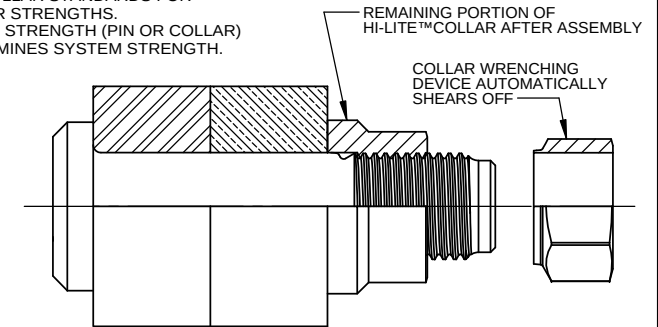


①

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LISI AEROSPACE website at:
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)

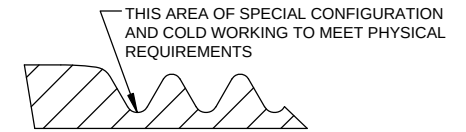


SEE COLLAR STANDARDS FOR
COLLAR STRENGTHS.
LOWER STRENGTH (PIN OR COLLAR)
DETERMINES SYSTEM STRENGTH.



① PULL-IN™ PIN AND 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	INTERNAL THREAD LEFT HAND			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION FATIGUE POUNDS MAX
		MAX	MIN		MAX	MIN	MAX	MIN	MAX	MIN		MAX	MIN	T1	THREAD SIZE UNJF-2B				LOAD POUNDS MAX					
16	17/32	.790 (20,07)	.755 (19,18)	.685 (17,40)	.5307 (13,480)	.5297 (13,454)	.4930 (12,522)	.4880 (12,395)	N/A		.100 (2,54)	.188 (4,78)	.178 (4,52)	.030 (0,76)	.020 (0,51)	.047 (1,19)	N/A	.5000-20UNJF-3A modified	.325 (8,26)	1/4-SP	8 835 (39 300)	42 000 (186 825)	25 600 (113 874)	8 900 (39 589)
18	19/32	.900 (22,86)	.865 (21,97)	.844 (21,44)	.5927 (15,055)	.5917 (15,029)	.5550 (14,097)	.5500 (13,970)	.4783 (12,150)	.4764 (12,100)	.125 (3,18)	.210 (5,33)	.200 (5,08)	.040 (1,02)	.025 (0,64)	.020 (0,51)	.701 (17,81)	.5625-18UNJF-3A modified	.465 (11,81)	5/16-SP	11 500 (51 155)	52 600 (233 976)	32 400 (144 122)	11 300 (50 265)
20	21/32	.970 (24,64)	.935 (23,75)	.935 (23,75)	.6552 (16,642)	.6542 (16,617)	.6180 (15,697)	.6120 (15,545)	.5413 (13,750)	.5394 (13,700)	.140 (3,56)	.238 (6,05)	.228 (5,79)	.040 (1,02)	.025 (0,64)	.020 (0,51)	.733 (18,63)	.6250-18UNJF-3A modified	.520 (13,21)	3/8-SP	14 200 (63 165)	64 300 (286 021)	41 000 (182 377)	14 400 (64 054)
24	25/32	1.185 (30,10)	1.145 (29,08)	1.125 (28,58)	.7802 (19,817)	.7792 (19,792)	.7430 (18,872)	.7370 (18,720)	.6575 (16,700)	.6555 (16,650)	.200 (5,08)	.335 (8,51)	.320 (8,13)	.045 (1,14)	.030 (0,76)	.020 (0,51)	.927 (23,54)	.7500-16UNJF-3A modified	.625 (15,88)	7/16-SP	19 109 (85 000)	91 000 (404 788)	59 500 (264 669)	21 000 (93 413)
28	29/32	1.350 (34,29)	1.310 (33,27)	1.315 (33,40)	.9052 (22,992)	.9042 (22,967)	.8680 (22,047)	.8610 (21,870)	.7717 (19,600)	.7697 (19,550)	.250 (6,35)	.385 (9,78)	.370 (9,40)	.050 (1,27)	.035 (0,89)	.020 (0,51)	1.021 (25,92)	.8750-14UNJF-3A modified	.725 (18,42)	1/2-SP	31 500 (140 119)	119 100 (529 783)	77 500 (344 737)	28 800 (128 109)
32	1-1/32	1.530 (38,86)	1.490 (37,85)	1.500 (38,10)	1.0302 (26,167)	1.0292 (26,142)	.9930 (25,222)	.9860 (25,045)	.8819 (22,400)	.8799 (22,350)	.300 (7,62)	.435 (11,05)	.420 (10,67)	.060 (1,52)	.045 (1,14)	.020 (0,51)	1.151 (29,22)	1.0000-12UNJF-3A modified	.830 (21,08)	9/16-SP	38 218 (170 000)	149 700 (665 899)	100 900 (448 825)	37 600 (167 253)



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 F.CARINGELLA	DATE 2016-02-01	TITLE PULL-IN™ PIN PROTRUDING TENSION HEAD INTERFERENCE FIT, TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED C.REITZ	DATE 2016-02-01	DRAWING NUMBER HPL1436	
REVISION ①	DATE M.BEARD 2017-11-03	1 OF 2	

- GENERAL NOTES:**
1. Concentricity: "A" dia to "D" diameter within .010 (0.254) FIM.
 2. Dimensions in inches (millimeters) and to be met after finish. Strengths and loads are in LBS. (N).
 - 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. HPL1436 is the oversize replacement for HPL1426.
 6. Use HPL1446 for oversize replacement.
 - ⑦ 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 9. For Dash code 16 only: D1 DIA & V not applicable since the pin end is fully threaded.
 - ⑩ 10. For Dash code 16 only: chamfer is as following: S x 37° CHAMFER.

MATERIAL: PIN = Titanium alloy 6Al-4V per AMS4928 or AMS4967

HEAT TREAT: PIN = 160,000 psi (1103 MPa) tensile minimum and 95,000 psi (655 MPa) shear minimum for size up to 3/4. 150,000 psi (1034 MPa) tensile and 90,000 psi (620 MPa) shear minimum for 7/8 and larger.

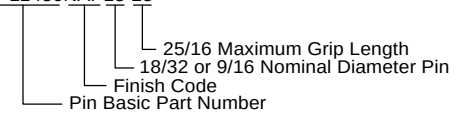
FINISH: HPL1436BJ()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HPL1436NAP()-() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HPL1436 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
 HPL1436NAP18-25



HPL1436

DRAWING NUMBER

HPL1436

2 OF 2