600 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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1

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.	(MAX GRIP +V) ±.010 MAX GRIP ±.005 R RAD COLD WORKED DIA TD DIA	1 A S X 45° CHAMFER PULL MANDREL [8] INTERNAL THREAD LEFT HAND	
DRILL CENTER DIMPLE .035 DIA MAX		DLLED PER AS8879 MAJOR DIA	
X.010 MAX DEPTH. CONCENTRIC TO "D" DIA WITHIN .008 FIM.	PULL-IN™ PIN	PER "TN"	OF PULL-IN™ PIN AND NUT/COLLAR AFTER ASSEMBLY

FIRST DASH	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	D1 DIA	G REF	н	R RAD ROLLED	S CHAMFER REF	V REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND 6			DOUBLE SHEAR	TEN SION POUNDS	TENSION- TENSION FATIGUE
NO.													T1 MAX	THREAD SIZE UNJF-2B	LOAD POUNDS MAX	POUNDS	MINIMUM	POUND S MAX
20	5/8	.995 .960	.935	.6865 .6855	.6180 .6120	.5413 .5394	.140	.238 .228	.040 .025	.020	.733	.6250-18 UNJF-3A	.520	3/8-SP	14,200	92,900	49,458	16,816
24	3/4	1.206 1.166	1.125	.8115 .8105	.7430 .7370	.6575 .6555	.200	.335 .320	.045 .030	.020	.927	.7500-16 UNJF-3A	.625	7/16-SP	19,109	129,800	81,469	28,500
28	7/8	1.372 1.331	1.315	.9365 .9355	.8680 .8610	.7717 .7697	.250	.385 .370	.050 .035	.020	1.021	.8750-14 UNJF-3A	.725	1/2-SP	31,500	172,600	112,121	38,210
32	1	1.552 1.512	1.500	1.0615 1.0605	.9930 .9860	.8819 .8799	.300	.435 .420	.060 .045	.020	1.151	1.0000-12 UNJF-3A	.830	9/16-SP	38,218	220,200	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.

 - ①3. 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. HPL1440 is the oversize replacement for HPL1430.
 - 6 The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.
 - 7. Product in accordance with LISI AEROSPACE Product Specification N°415.
 - 8 Mandrel is sold separately.

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

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

HPL1440NAP()-() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, FINISH:

and cetyl alcohol lube per Hi-Shear Spec. 305.

HPL1440NSU()-() = 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.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HPL1440 oversize pin replaces.

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

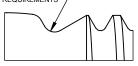
HOW TO ORDER

① EXAMPLES: Pin Part Number

HPL1440NAP20-25 25/16 Maximum Grip Length 20/32 or 5/8 Nominal Diameter Pin - Finish Code

Pin Basic Part Number

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	Г				
F.CARINGELLA						
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APPROVED	DATE	Ι.				
C. RIETZ	2016-02-09					
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PULL-IN™ PIN PROTRUDING TENSION HEAD INTERFERENCE FIT NICKEL BASE ALLOY (INCONEL 718) /16 GRIP VARIATION, 1/16 OVERSIZE

1 OF 1

DATE F.CARINGELLA **HPL1440** 2017-10-26

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