



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 [6]			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS MAX
													T1 MAX	THREAD SIZE UNJF-2B	LOAD POUNDS 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.
 - 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. 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.

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

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

"HI-KOTE", "HI-LITE", "PULL-IN" AND "HPL", ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY F.CARINGELLA	DATE 2016-02-09	TITLE PULL-IN™ PIN PROTRUDING TENSION HEAD INTERFERENCE FIT NICKEL BASE ALLOY (INCONEL 718) 1/16 GRIP VARIATION, 1/16 OVERSIZE
APPROVED C. RIETZ	DATE 2016-02-09	DRAWING NUMBER HPL1440
REVISION ①	DATE F.CARINGELLA 2017-10-26	1 OF 1