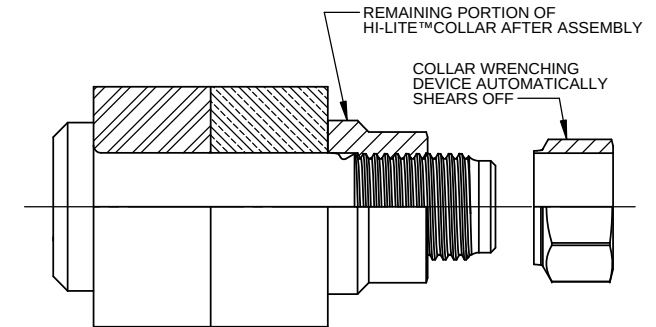
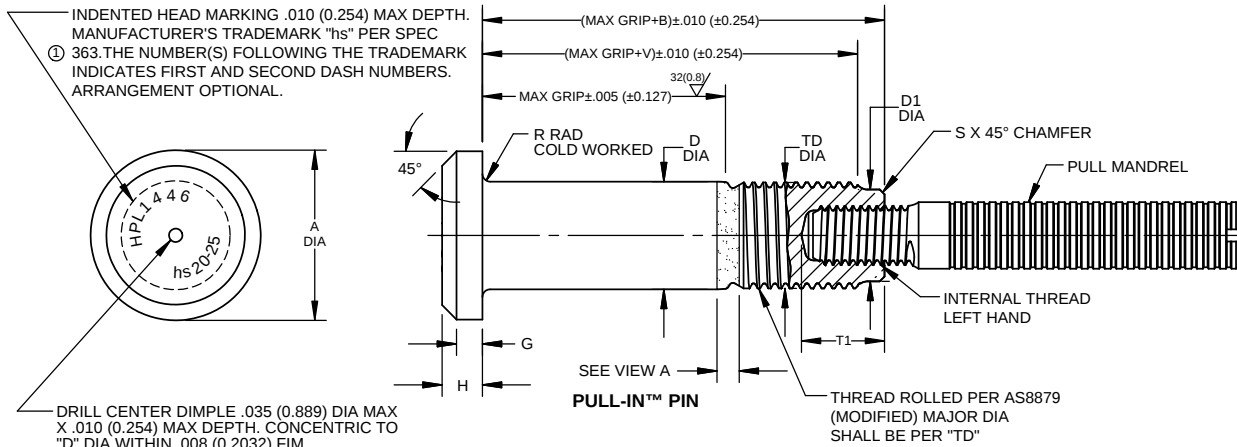


①

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



① PULL-IN™ PIN AND COLLAR AFTER ASSEMBLY

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

⑥

FIRST DASH NO.	PIN NOM DIA	A DIA		B	D DIA		TD DIA		D1 DIA		G	H		R RAD ROLLED		S CHAMFER	V	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	MAX	MIN				REF	REF	MAX			
		MAX																	MAX					
20	11/16	.995 (25,27)	.960 (24,38)	.935 (23,75)	.6865 (17,437)	.6855 (17,412)	.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)	70 500 (313 600)	41 000 (182 377)	14 400 (64 054)
24	13/16	1.206 (30,63)	1.166 (29,62)	1.125 (28,58)	.8115 (20,612)	.8105 (20,587)	.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)	98 600 (438 594)	59 500 (264 669)	21 000 (93 413)
28	15/16	1.372 (34,85)	1.331 (33,81)	1.315 (33,40)	.9365 (23,787)	.9355 (23,762)	.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)	123 700 (550 245)	77 500 (344 737)	28 800 (128 109)
32	1-1/16	1.552 (39,42)	1.512 (38,40)	1.500 (38,10)	1.0615 (26,962)	1.0605 (26,937)	.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)	163 800 (728 618)	100 900 (448 825)	37 600 (167 253)

- GENERAL NOTES:**
- Concentricity: "A" dia to "D" diameter within .010 (0.254) FIM.
 - Dimensions in inches (millimeters) and to be met after finish. Strengths and loads are in LBS. (N).
 - Surface texture per ASME B46.1.
 - Hole preparation per HSL/HPL-IS01: PULL-STEM™/ PULL-IN™ fastener installation specification for HSL/HPL pins.
 - HPL1446 is the oversize replacement for HPL1436.
 - The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.
 - Product in accordance with LISI AEROSPACE Product Specification N°415.

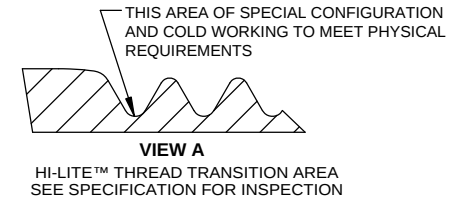
CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HPL1446 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER

① **EXAMPLE:**

Pin Part Number
HPL1446NAP20-25

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

"HI-KOTE", "HI-LITE", "PULL-IN" AND "HPL", ARE TRADEMARKS OF HI-SHEAR CORPORATION	
DRAWN BY F.CARINGELLA	DATE 2016-02-01
APPROVED C.REITZ	DATE 2016-02-01
REVISION ①	DATE M.BEARD 2017-11-06
TITLE PULL-IN™ PIN PROTRUDING TENSION HEAD INTERFERENCE FIT, TITANIUM 1/16 GRIP VARIATION, 1/16 OVERSIZE	
DRAWING NUMBER HPL1446	

1 OF 1