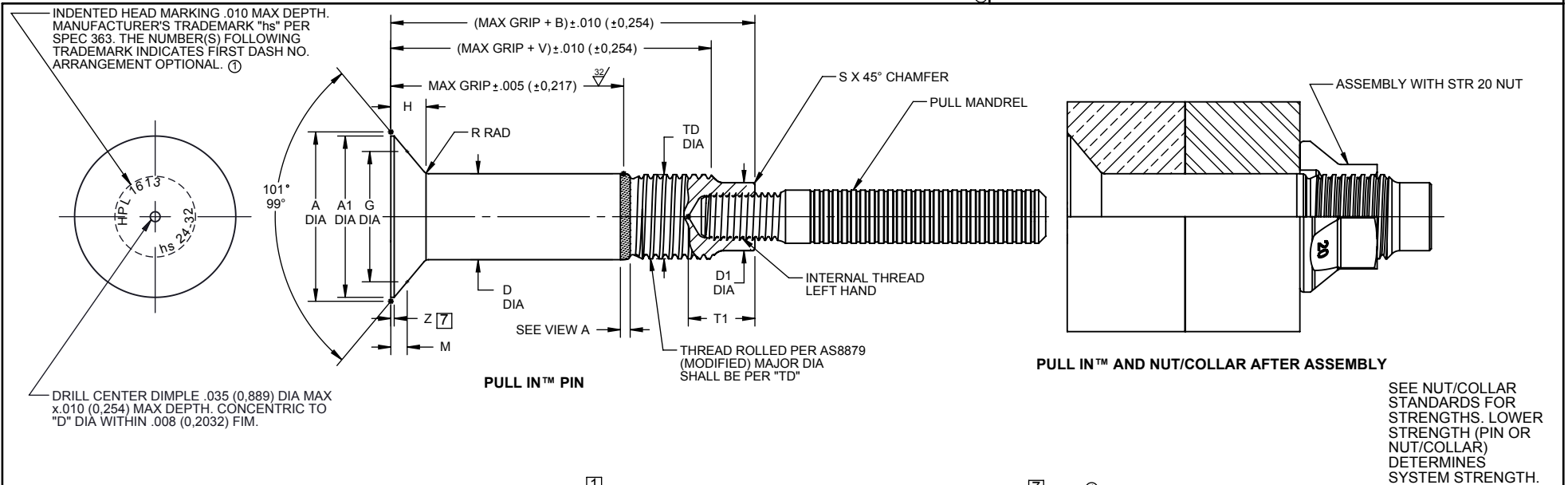




FIRST DASH NO.	PIN NOM DIA	A DIA MAX	A1 DIA MIN	B REF	D DIA		TD DIA		D1 DIA		F REF	G GAGE DIA		H REF	M GAGE PROT.		R RAD ROLLED		S CHAMFER REF	V REF	Z MAX	THREAD MODIFIED	INTERNAL THREAD LEFT HAND			DOUBLE SHEAR STRENGTH		TENSILE STRENGTH		TENSION FATIGUE LOAD	
					MAX	MIN	MAX	MIN	MAX	MIN		MAX	MIN		MAX	MIN	T1 MAX	THREAD SIZE UNJF-3B					LOAD MAX	MIN	MAX	MIN	MAX				
24	3/4	1.3000 (33.02)	1.251 (31.78)	1.125 (28.58)	.7802 (19.817)	.7792 (19.792)	.7430 (18.872)	.7370 (18.720)	.6575 (16.700)	.6555 (16.650)	.012 (0.30)	1.1124 (28.255)	1.1122 (28.250)	.215 (5.46)	.0776 (1.971)	.0716 (1.819)	.050 (1.270)	.040 (1.016)	.020 (0.51)	.927 (23.54)	.022 (0.559)	.7500-16 UNJF-3A	.625 (15.88)	7/16-SP	17 985 (80 000)	81 378 (361 989)	89 200 (396 782)	41 000 (182 377)	14 300 (63 610)		
28	7/8	1.5091 (38.33)	1.461 (37.11)	1.315 (33.40)	.9052 (22.992)	.9042 (22.967)	.8680 (22.047)	.8610 (21.870)	.7717 (19.600)	.7697 (19.550)	.014 (0.36)	1.3440 (34.138)	1.3438 (34.133)	.240 (6.10)	.0694 (1.763)	.0622 (1.580)	.050 (1.270)	.040 (1.016)	.020 (0.51)	1.021 (25.92)	.022 (0.559)	.6875-14 UNJF-3A	.725 (18.42)	1/2-SP	25 853 (115 000)	109 305 (486 213)	120 041 (533 969)	52 000 (231 308)	18 200 (80 958)		
32	1	1.7201 (43.69)	1.671 (42.44)	1.500 (38.10)	1.0302 (26.167)	1.0292 (26.142)	.9930 (25.222)	.9860 (25.045)	.8819 (22.400)	.8799 (22.350)	.014 (0.36)	1.5732 (39.959)	1.5730 (39.954)	.285 (7.24)	.0617 (1.567)	.0536 (1.361)	.050 (1.270)	.040 (1.016)	.020 (0.51)	1.151 (29.22)	.022 (0.559)	1.0000-12 UNJF-3A	.830 (21.08)	9/16-SP	31 473 (140 000)	141 650 (630 089)	155 377 (691 154)	67 000 (298 031)	20 100 (89 409)		

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within .005 (0,127) FIM.
 - "H" is dimensioned from maximum "D" diameter.
 - Hole preparation per NAS618.
 - Dimensions in inches (millimeters) and to be met after finish. Strengths and loads are in Lbs (N).
 - Surface texture per ASME B46.1.
 - Curved or flat edge manufacturer's option.
 - The maximum allowable installation load must not exceed the maximum load values in table or thread failure may occur.
 - Use HPL1713 for oversize replacement.

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

HOW TO ORDER

EXAMPLES:

Pin Part Number
HPL1613NKA24-32
8/16 or 1/2 Maximum Grip Length
3/4 or 12/16 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: 6AL-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: Anneal per Hi-Shear Spec. 391-1.

FINISH: HPL1613NKA() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

HPL1613NKW() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294, with color white on pin end and cetyl alcohol tube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 391-1, except as noted.

"HI-KOTE", "PULL-IN", "HPL", AND "HI-LITE" ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY ASSYTEM	DATE 2012-02-20	TITLE PULL IN™ PIN
APPROVED J. GOYER	DATE 2012-02-20	100° FLUSH SPECIAL SHEAR HEAD TITANIUM (ANNEALED), SPECIAL THREAD 1/16 GRIP VARIATION, 1/32 OVERSIZE SPECIAL HIGH INTERFERENCE FIT
REVISION 1	DATE K. TRAN 2017-11-20	DRAWING NUMBER HPL1613