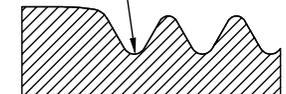


PULL-IN™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND [5]			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS
											T1 MAX	THREAD SIZE UNJF-3B	LOAD MAX			
20	11/16	.995 .960	.935	.6865 .6855	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.520	3/8-SP	14,200	70,500	38,360	13,470
24	13/16	1.206 1.166	1.125	.8115 .8105	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.625	7/16-SP	19,109	98,600	55,600	19,400
28	15/16	1.372 1.331	1.315	.9365 .9355	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.725	1/2-SP	31,500	123,700	67,900	25,200
32	17/16	1.552 1.512	1.500	1.0615 1.0605	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 37°	1.000-12 UNJF-3A	.830	9/16-SP	38,200	163,800	88,600	31,912

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

THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS.



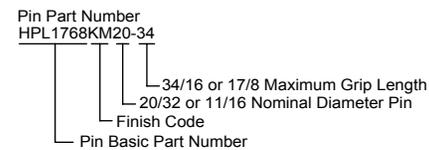
VIEW A

HI-LITE™ THREAD TRANSITION AREA. THIS AREA OF SPECIAL CONFIGURATION.

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
  2. Dimensions in inches and to be met after finish.
  3. Surface texture per ASME B46.1.
  4. Hole preparation per NAS618.
  5. The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.
  6. Oversize replacement for HPL1768, HPL868 and HPL968.
  7. After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HPL1768 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

**HOW TO ORDER**  
 [5] **EXAMPLE:**



**MATERIAL:** 6Al-4V titanium alloy per AMS4928, AMS4967 or British Standard 2TA 28.

**HEAT TREAT:** 160,000 psi tensile minimum and 95,000 psi shear minimum for sizes up to 3/4. 150,000 psi tensile and 90,000 psi shear minimum for 7/8 and larger.

**FINISH:** [7] HPL1768KM( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

**SPECIFICATION:** HI-LITE™ Product Specification HS412.

"HI-KOTE", "HI-LITE", "PULL-IN" AND "HPL" ARE TRADEMARKS OF HI-SHEAR CORPORATION	
DRAWN BY J.G. OBISPO	DATE 2004-03-15
APPROVED M. CAWLEY	DATE 2004-03-15
REVISION [5]	DATE K. TRAN 2017-10-26
TITLE PULL-IN™ PIN PROTRUDING TENSION HEAD 6AL-4V TITANIUM ALLOY, SPECIAL THREAD 1/16 GRIP VARIATION, 1/16 OVERSIZE SPECIAL HIGH INTERFERENCE FIT	
DRAWING NUMBER <b>HPL1768</b>	
1 OF 1	