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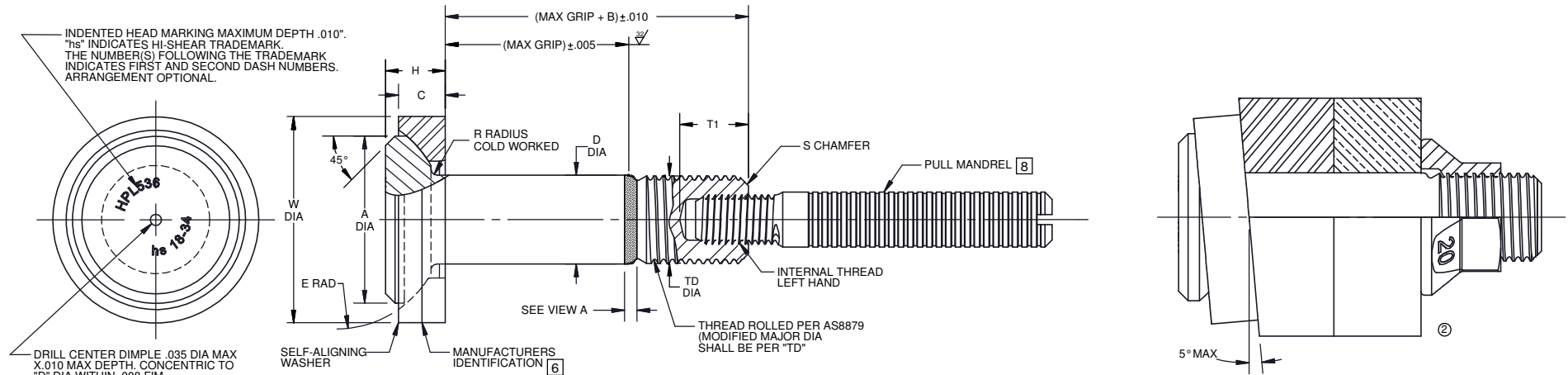


TABLE 1

FIRST DASH NO.	PIN NOM DIA	A DIA REF	B REF	C REF	D DIA		TD DIA	H MAX	R RAD	S CHAMFER REF	E RAD	W DIA	THREAD MODIFIED	INTERNAL THREAD LEFT HAND [5]			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-FATIGUE POUNDS MAX
					WITHOUT COATING OR FINISH	AFTER COATING OR FINISH								T1 MAX	THREAD SIZE UNJF-2B	LOAD POUNDS MAX			
18	9/16	1.051	.845	.303	.5615 .5610	.5615 .5605	.5537 .5500	.382	.040 .025	1/16 X 37°	.687	1.307 1.291	.5625-18 UNJF-3A	.465	5/16-SP	11,500	47,200	28,350	9,900
20	5/8	1.130	.935	.319	.6240 .6235	.6240 .6230	.6165 .6120	.406	.040 .025	1/16 X 37°	.750	1.437 1.421	.6250-18 UNJF-3A	.520	3/8-SP	14,200	58,300	38,360	13,470
24	3/4	1.291	1.125	.358	.7490 .7485	.7490 .7480	.7415 .7370	.547	.045 .030	1/16 X 37°	.875	1.689 1.673	.7500-16 UNJF-3A	.625	7/16-SP	19,109	83,900	55,600	19,400
28	7/8	1.449	1.315	.390	.8740 .8735	.8740 .8730	.8663 .8610	.634	.050 .035	5/64 X 37°	1.000	1.921 1.906	.8750-14 UNJF-3A	.725	1/2-SP	31,500	111,100	67,900	25,200
32	1	1.602	1.500	.437	.9990 .9985	.9990 .9980	.9913 .9860	.713	.060 .045	5/64 X 37°	1.125	2.134 2.118	1.0000-12 UNJF-3A	.830	9/16-SP	38,218	140,724	88,600	31,912

EXAMPLE OF PULL-IN™ PIN AND NUT/COLLAR AFTER ASSEMBLY

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

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② GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIM.
- Dimensions in inches, to be met after finish and before solid film lubricant, where applicable.
- Surface texture per ASME B46.1.
- Hole preparation per HSL/HPL-IS01: PULL-STEM™ / PULL-IN™ fastener installation specification for HSL/HPL pins.
- The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.
- One line indicates Blanc Aero Industries, France as manufacturer.
- Use HPL636 for oversize replacement.
- Mandrel is sold separately.
- After February 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in the European Union.

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



VIEW A

HI-LITE™ THREAD TRANSITION AREA
SEE SPECIFICATION FOR INSPECTION

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

DRAWN BY F.CARINGELLA	DATE 2017-03-22	TITLE PULL-IN™ PIN SELF-ALIGNING TENSION HEAD 6AL-4V TITANIUM ALLOY SPECIAL THREAD 1/16 GRIP VARIATION
APPROVED J.L.O	DATE 2017-03-22	
REVISION ②	DATE F.CARINGELLA 2017-03-22	DRAWING NUMBER HPL536

② **FINISH:**

PART DESCRIPTION	PART NUMBER	FINISH	LUBE	IDENTIFICATION
TITANIUM PIN	HPL536BM(-)(-)	HI-KOTE™ 1 NC ALUMINUM PIGMENTED COATING PER HI-SHEAR SPEC. 294	CETYL ALCOHOL LUBE PER HI-SHEAR SPEC. 305	WHITE COLOR ON THREAD END
	HPL536KM (-)(-) [9]	HI-KOTE™ 1 ALUMINUM PIGMENTED COATING PER HI-SHEAR SPEC. 294		
	HPL536NKM (-)(-)	HI-KOTE™ 1 NC ALUMINUM PIGMENTED COATING PER HI-SHEAR SPEC. 294		
TITANIUM WASHER	HPL536-()APW [9]	HI-KOTE™ 1 ALUMINUM PIGMENTED COATING PER HI-SHEAR SPEC. 294	CETYL ALCOHOL LUBE PER HI-SHEAR SPEC. 305	WHITE COLOR SPOT ON OUTSIDE DIAMETER
	HPL536-()NAPW	HI-KOTE™ 1 NC ALUMINUM PIGMENTED COATING PER HI-SHEAR SPEC. 294		

MATERIAL: Pin = 6AL-4V Titanium alloy per AMS4928, AMS4967 or British Standard 2TA 28.
Washer = 6Al-4V Titanium alloy per AMS4928 or AM4967 or British Standard 2TA 28.

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

② **SPECIFICATION:** PULL-IN™ Product Specification N°412.

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.

② **HOW TO ORDER**

EXAMPLE:

Pin-Washer Assembly Part Number
HPL536 KM 18 APW 34

└─ 34/16 or 17/8 Maximum Grip Length
└─ Washer finish code
└─ 18/32 or 9/16 Nominal Diameter Pin
└─ Pin Finish Code
└─ Pin Basic Part Number

HPL536

DRAWING NUMBER

HPL536

SHEET 2 OF 2