



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-TENSION FATIGUE POUNDS MAX
					WITHOUT COATING OR FINISH	AFTER COATING OR FINISH								T1 MAX	THREAD SIZE UNJF-2B	LOAD POUNDS MAX			
18	19/32	1.051	.845	.303	.5927 .5922	.5927 .5917	.5550 .5500	.382	.040 .025	1/16 X 37°	.687	1.307 1.291	.5625-18 UNJF-3A	.465	5/16-SP	11,500	52,600	28,350	9,900
20	21/32	1.130	.935	.319	.6552 .6547	.6552 .6542	.6180 .6120	.406	.040 .025	1/16 X 37°	.750	1.437 1.421	.6250-18 UNJF-3A	.520	3/8-SP	14,200	64,300	38,360	13,470
24	25/32	1.291	1.125	.358	.7802 .7797	.7802 .7792	.7430 .7370	.547	.045 .030	1/16 X 37°	.875	1.689 1.673	.7500-16 UNJF-3A	.625	7/16-SP	19,109	91,000	55,600	19,400
28	29/32	1.449	1.315	.390	.9052 .9047	.9052 .9042	.8680 .8610	.634	.050 .035	5/16 X 37°	1.000	1.921 1.906	.8750-14 UNJF-3A	.725	1/2-SP	31,500	119,100	67,900	25,200
32	1-1/32	1.602	1.500	.437	1.0302 1.0297	1.0302 1.0292	.9930 .9860	.713	.060 .045	5/16 X 37°	1.125	2.134 2.118	1.0000-12 UNJF-3A	.830	9/16-SP	38,218	149,700	88,600	31,912

PULL-IN™ PIN

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.

[2] [2] [2]

- ② GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within .010 FIM.
 2. Dimensions in inches, to be met after finish and before solid film lubricant, where applicable.
 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] The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.
 - [6] One line indicates Blanc Aero Industries, France as manufacturer.
 7. Use HPL1536 for oversize replacement.
 - [8] Mandrel is sold separately.
 - [9] 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
APPROVED J. LO	DATE 2017-03-22
REVISION 2	DATE F.CARINGELLA 2017-03-22
TITLE PULL-IN™ PIN SELF-ALIGNING TENSION HEAD 6AL-4V TITANIUM ALLOY SPECIAL THREAD 1/16 GRIP VARIATION, 1/32 OVERSIZE	
DRAWING NUMBER HPL736	

② **FINISH:**

PART DESCRIPTION	PART NUMBER	FINISH	LUBE	IDENTIFICATION
TITANIUM PIN	HPL736BM(-)(-)	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
	HPL736KM(-)(-) [9]	HI-KOTE™ 1 ALUMINUM PIGMENTED COATING PER HI-SHEAR SPEC. 294		
	HPL736NKM(-)(-)	HI-KOTE™ 1 NC ALUMINUM PIGMENTED COATING PER HI-SHEAR SPEC. 294		
TITANIUM WASHER	HPL736(-)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
	HPL736(-)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 of the pin which HPL736 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.

② **HOW TO ORDER**

EXAMPLE:

