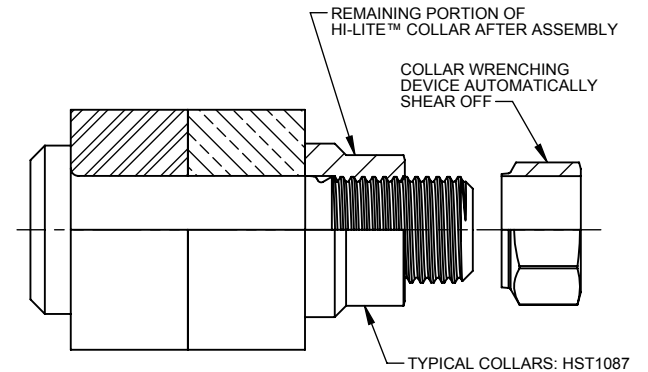


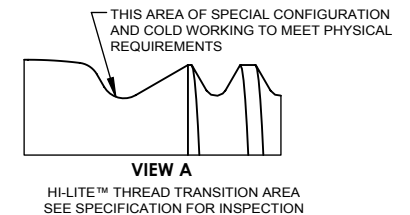
HI-LITE™ PULL-IN™ PIN



EXAMPLE OF HI-LITE™ 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 ROLLED	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS MAXIMUM
											T MIN	T1	THREAD SIZE			
18	9/16	.877 .842	.600	.5615 .5605	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.240	.340 .320	.2500-28UNJF-2B	9,450	47,200	28,330
20	5/8	.953 .918	.640	.6240 .6230	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.240	.340 .320	.2500-28UNJF-2B	9,450	58,300	38,340
24	3/4	1.150 1.110	.895	.7490 .7480	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.260	.385 .365	.3750-24UNJF-2B	14,175	83,900	55,600
28	7/8	1.330 1.290	1.000	.8740 .8730	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.380	.500 .480	.3750-24UNJF-2B	21,600	107,000	72,400
32	1	1.510 1.470	1.160	.9990 .9980	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 37°	1.0000-1 UNJF-3A	.450	.575 .555	.3750-24UNJF-2B	21,600	140,000	93,500
36	1-1/8	1.695 1.655	1.305	1.1240 1.1230	1.1170 1.1100	.350	.490 .475	.070 .055	5/64 x 37°	1.0125-12 UNJF-3A	.450	.575 .555	.3750-24UNJF-2B	21,600	178,000	119,600

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



HI-LITE™ THREAD TRANSITION AREA  
 SEE SPECIFICATION FOR INSPECTION

"HI-LITE", "HST", "HPL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY J.OBISPO	DATE 1991-10-08	TITLE HI-LITE™ PULL-IN™ PIN PROTRUDING TENSION HEAD TITANIUM ALLOY 1/16 GRIP VARIATION
APPROVED DAW	DATE 1991-10-10	
REVISION ⑩	DATE F.CARINGELLA 2017-10-12	DRAWING NUMBER <b>HPL756</b>

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
  2. Dimensions in inches and to be met after finish.
  - ⑩ 3. Surface texture per ASME B46.1.
  4. Hole preparation per NAS618.
  - ⑤ 5. The maximum allowable installation load must not exceed the maximum load values in table or thread/mandrel failure may occur.
  6. Use HPL856 for oversize replacement.
  - ⑦ 7. 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 European Union.

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

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

**FINISH:** ☒ HPL756AP( )-( ) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.  
☒ HPL756KM( )-( ) = 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 391, except fatigue loads as tabulated.

**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.  
 Code letter "A" following second dash number indicates assembly with HPM pull mandrell.

#### HOW TO ORDER

##### ⑩ EXAMPLES:

Pin Part Number

HPL756KM18-8A

