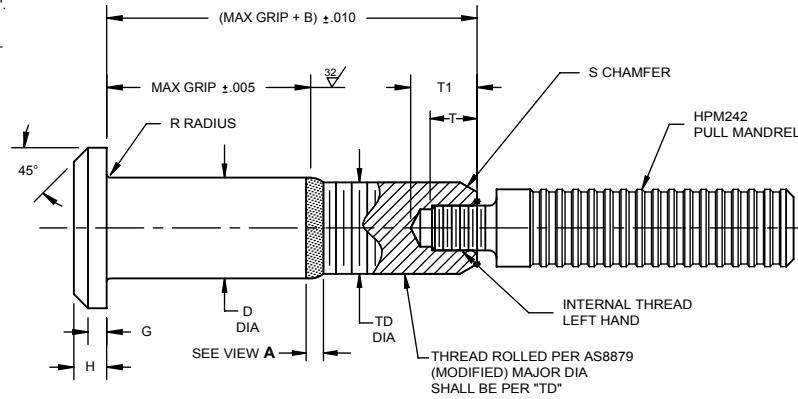
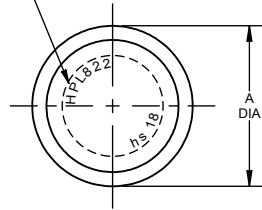
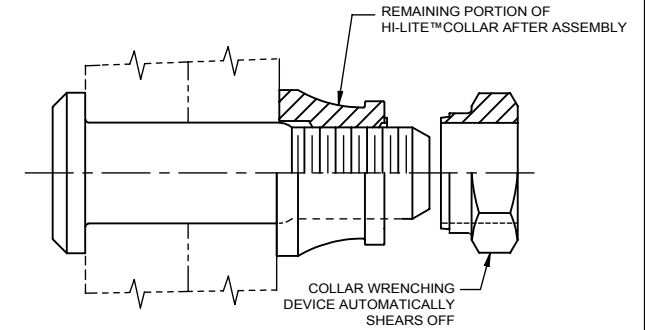


⑤

INDENTED HEAD MARKING MAXIMUM DEPTH .010".
 "hs" INDICATES HI-SHEAR TRADEMARK.
 THE NUMBER(S) FOLLOWING THE TRADEMARK
 INDICATES FIRST DASH NUMBER. ARRANGEMENT
 OPTIONAL. INDENTATION IS .050-.060 DIAMETER
 x .020-.030 DEPTH.



PULL-IN™ PIN



PULL-IN™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	K MAX	R RAD	S CHAMFER REF	THREAD MODIFIED	INTERNAL THREAD LEFT HAND			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
												T MIN	T1 MAX	THREAD SIZE		
18	9/16	.877 .842	.770	.5615 .5605	.5550 .5500	.115	.210 .200	.039	.040 .025	1/16 x 45°	.5625-18 UNJF-3A	.280	.456	.312-24UNJF-2B	62,100	43,500
20	5/8	.953 .905	.825	.6240 .6230	.6180 .6120	.130	.238 .228	.044	.040 .025	1/16 x 45°	.6250-18 UNJF-3A	.280	.456	.312-24UNJF-2B	76,700	54,600

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within .010 FIM.
- ⑤ 2. Dimensions are in inches and to be met after finish.
- ⑤ 3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Lead radius must be tangent to "D" diameter at maximum grip.
6. Use HPL832 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: Nickel Base Alloy per AMS5662.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: ⑦ HPL822AP() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
 ⑦ HPL822AG() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color code orange on the thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

HPL822DL() = Kalgard FA or EM620C solid film lube per AS5272, Type I and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 391.

CODE:

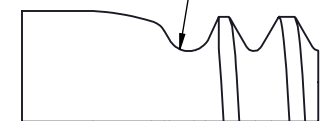
First dash number indicates nominal diameter in 1/32nds.
 Second dash number indicates maximum grip in 1/16ths.
 See "Finish" note for explanation of code letters.
 Code letter "A" following second dash number indicates assembly with HPM pull mandrel.

HOW TO ORDER

EXAMPLE:

Pin Part Number
 ⑤ HPL822DL18-8A
 Assembled with HPM Pull Mandrel (Optional)
 8/16 or 1/2 Maximum Grip Length
 18/32 or 9/16 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

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



VIEW A

HI-LITE™ THREAD TRANSITION AREA. SEE SPECIFICATION FOR INSPECTION

⑤

"HI-KOTE", "HI-LITE", "PULL-IN" AND "HPL" ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F. OBISPO	DATE 1995-08-08	TITLE PULL-IN™ PIN PROTRUDING TENSION HEAD NICKEL BASE ALLOY (INCONEL 718) SPECIAL THREAD 1/16 GRIP VARIATION	
APPROVED J. RAUSCH	DATE 1995-08-09		
REVISION ⑤	DATE F. CARINELLA 2019-04-22	DRAWING NUMBER HPL822	

1 OF 1