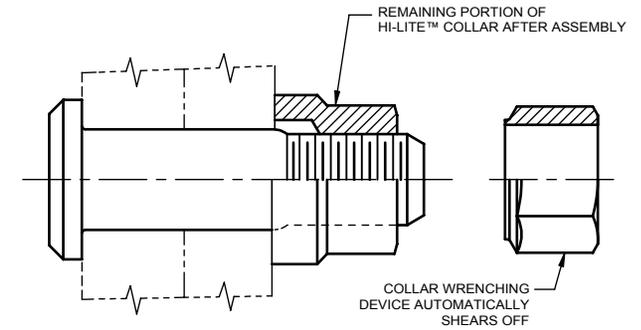
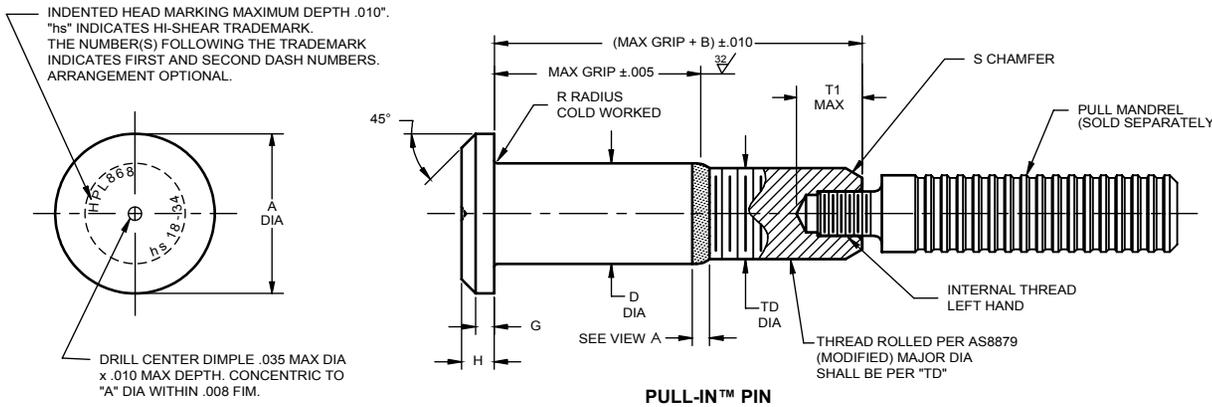


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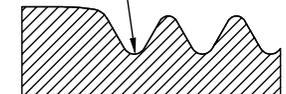


PULL-IN™ PIN AND COLLAR AFTER ASSEMBLY

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			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE POUNDS
											T1 MAX	THREAD SIZE UNJF-3B	LOAD MAX			
18	37/64	.877 .842	.844	.5771 .5761	.5550 .5500	.125	.210 .200	.040 .025	1/16 x 37°	.5625-18 UNJF-3A	.465	5/16-SP	11,500	49,900	28,350	9,900
20	41/64	.953 .918	.935	.6396 .6386	.6180 .6120	.140	.238 .228	.040 .025	1/16 x 37°	.6250-18 UNJF-3A	.520	3/8-SP	14,200	61,200	38,360	13,470
24	49/64	1.150 1.110	1.125	.7646 .7636	.7430 .7370	.200	.335 .320	.045 .030	1/16 x 37°	.7500-16 UNJF-3A	.625	7/16-SP	19,109	87,400	55,600	19,400
28	57/64	1.330 1.290	1.315	.8896 .8886	.8680 .8610	.250	.385 .370	.050 .035	5/64 x 37°	.8750-14 UNJF-3A	.725	1/2-SP	31,500	115,000	67,900	25,200
32	1-1/64	1.510 1.470	1.500	1.0146 1.0136	.9930 .9860	.300	.435 .420	.060 .045	5/64 x 37°	1.000-12 UNJF-3A	.830	9/16-SP	38,200	145,200	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 are 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. Use HPL968 for oversize replacement.
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.

**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.

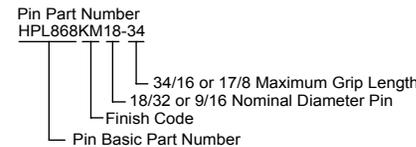
**FINISH:** [7] HPL868KM(-) = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color white on thread end, and cetyl alcohol lube per Hi-Shear Spec. 305.

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

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HPL868 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

**HOW TO ORDER**

**EXAMPLE:**



<b>"HI-KOTE", "HI-LITE", "PULL-IN" AND "HPL" ARE TRADEMARKS OF HI-SHEAR CORPORATION</b>	
DRAWN BY J.F. OBISPO	DATE 2004-03-15
APPROVED M. CAWLEY	DATE 2004-03-15
REVISION 4	DATE K. TRAN 2017-10-27
TITLE <b>PULL-IN™ PIN</b> PROTRUDING TENSION HEAD 6AL-4V TITANIUM ALLOY, SPECIAL THREAD 1/16 GRIP VARIATION, 1/64 OVERSIZE SPECIAL HIGH INTERFERENCE FIT DRAWING NUMBER <b>HPL868</b>	
1 OF 1	