2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA a LISI AEROSPACE Company

Design Holder

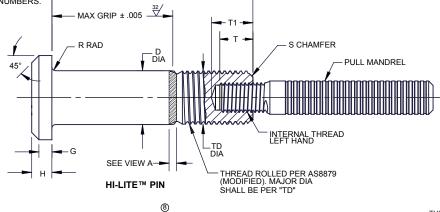
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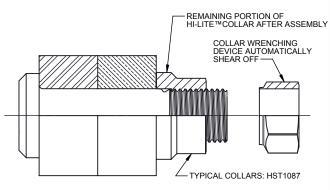
For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:

HTTP://WWW.LISI-AEROSPACE.COM/LICENSES

(8)

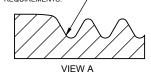
INDENTED HEAD MARKING .010 MAX DEPTH. MANUFACTURER'S TRADEMARK "hs" PER SPEC 363.THE NUMBER(S) FOLLOWING THE TRADEMARK	(MAX GRIP + B) ± .010
INDICATES FIRST AND SECOND DASH NUMBERS. ARRANGEMENT OPTIONAL. (8)	MAX GRIP ± .005
	R RAD D D D D D D D D D D D D
45°	
DIA DIA	
	INTERNAL THREAD LEFT HAND DIA
— н —	SEE VIEW A → THREAD ROLLED PER AS8879 (MODIFIED). MAJOR DIA SHALL BE PER "TD"





HI-LITE™ PIN AND COLLAR AFTER ASSEMBLY

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



HI-LITE™ THREAD TRANSITION AREA. THIS AREA OF SPECIAL CONFIGURATION. SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

INTERNAL THREAD LEFT HAND 5 FIRST PIN R S TD В DASH NOM CHAMFER THREAD RAD Н DIA REF DIA DIA REF MODIFIED LOAD NO. DIA ROLLEI REF THREAD SIZE MIN 1.150 7490 .7430 .335 .045 .7500-16 UNJF-3A .385 .260 24 3/4 .895 .200 1/16 x 37 3/8-24UNJF-2B 14,175 1 110 7480 .7370 030 365 1.330 .8740 .8680 .385 .050 .8750-14 .500 28 7/8 1.000 .250 5/64 x 37° .380 3/8-24UNJF-2B 21,600 UNJF-3A 1.290 .8730 .8610 .370 .035 .480 1.510 .9990 .9930 .435 .060 1.0000-12 .575 .300 32 1 160 5/64 x 37° .450 3/8-24UNJF-2B 21,600 9980 UNJF-3A .9860 .045 555 1 470 .420

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIM.
 Dimensions 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 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 allov per AMS4928, AMS4967 or British Standard 2TA 28.

HEAT TREAT: Anneal per Hi-Shear Spec. 391-1.

FINISH: ® 6 HPL956AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

®6 HPL956KM()-() = 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 391-1, except as noted.®

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 (8) EXAMPLES:

Pin Part Number HPL956KM24-8A Assembled with HPM Pull Mandrel (Optional) 8/16 or 1/2 Maximum Grip Length └24/32 or 3/4 Nominal Diameter Pin ® Finish Code Pin Basic Part Number

Pin and Collar Assembly Part Number Combination HPL956KM1087-18-8

Size and Grip Length. See Above Example Collar Part Number Pin Part Number

"HI-LITE", "HST", AND "HI-KOTE". ARE TRADEMARKS OF HI-SHEAR CORPÓRATION

DRAWN BY	DATE	TITLE
J.OBISPO	1991-10-08	HI-LITE™ PIN
		PROTRUDING TENSION HEAD
APPROVED	DATE	TITANILIM ALLOY (ANNIEALED)
DAW	1991-10-10	TITANIUM ALLOY (ANNEALED)
	1001 10 10	1/16 GRIP VARIATION
REVISION	DATE	DRAWING NUMBER
(8)	F.CARINGELLA	LIDI OEG
	2017-12-11	TPL930 10F1

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