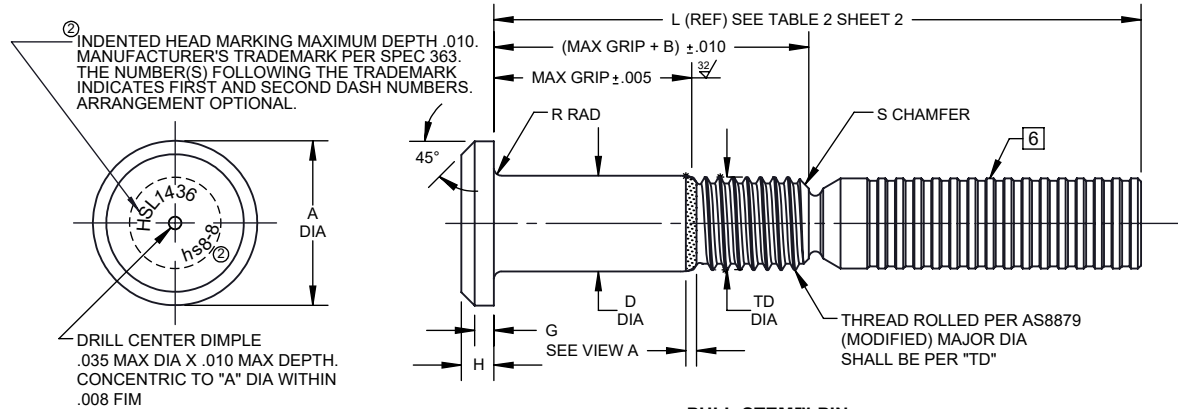




PULL-STEM™ PIN

8

TABLE 1

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA	TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM	TENSION-TENSION FATIGUE LBS. MAX
8	9/32	.460 .435	.330	.2807 .2797	.2440 .2410	.045	.090 .080	.025 .015	1/32 x 37°	.2500-28 UNJF-3A	11,800	5,820	1,950
10	11/32	.520 .490	.390	.3432 .3422	.3060 .3020	.055	.112 .102	.030 .020	3/64 x 37°	.3125-24 UNJF-3A	17,600	9,200	3,140
12	13/32	.620 .585	.430	.4057 .4047	.3680 .3640	.075	.140 .130	.030 .020	3/64 x 37°	.3750-24 UNJF-3A	24,600	14,000	4,850
14	15/32	.695 .660	.495	.4682 .4672	.4310 .4260	.095	.160 .150	.030 .020	3/64 x 37°	.4375-20 UNJF-3A	32,700	18,900	6,540
16	17/32	.790 .755	.535	.5307 .5297	.4930 .4880	.095	.188 .178	.030 .020	3/64 x 37°	.5000-20 UNJF-3A	42,000	25,600	8,900

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIM.
- Dimensions in inches and to be met after finish.
- Surface texture per ASME B46.1.
- Hole preparation per HSL/HPL-IS01: PULL-STEM™ /PULL-IN™ fastener installation specification for HSL/HPL pins.
- HSL1436 is the oversize replacement for HSL1426.
- Coating and lube not mandatory on pintail.
- Product in accordance with LISI AEROSPACE Product Specification N°415.
- For NKV finish only, D DIA MAX to be reduced by .0005, and D DIA to be met before finish.
- US patent 9447809; other foreign patents granted and pending property of LISI AEROSPACE. Specific License with LISI AEROSPACE is required to manufacture PULL-STEM™ pin with NKV finish.

CODE:

First dash number indicates nominal diameter in 1/32nds of the pin which HSL1436 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths.
 See "Finish" note for explanation of code letters.

HOW TO ORDER EXAMPLE:

Pin Part Number
 HSL1436NAP8-8
 8/16 or 1/2 Maximum Grip Length
 8/32 or 1/4 Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

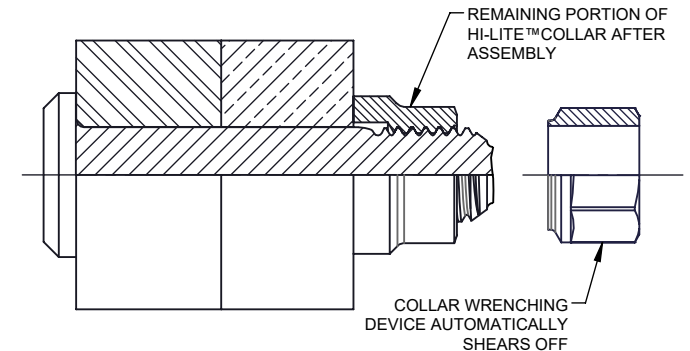
MATERIAL: Pin = Titanium alloy 6Al-4V per AMS4928 or AMS4967.

HEAT TREAT: Pin = 160,000 psi tensile minimum and 95,000 psi shear minimum.

FINISH: HSL1436NAP()-() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

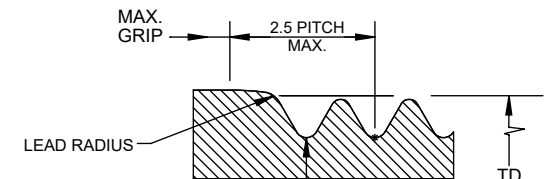
HSL1436BJ()-() = I.V.D. aluminum coating per MIL-DTL-83488, Type II, Class 3, and cetyl alcohol lube per Hi-Shear Spec. 305.

② HSL1436NKV()-() = HI-KOTE™ 1 NC aluminum coating per Hi-Shear Spec. 294 on threads plus four longitudinal stripes on shank, and cetyl alcohol lube per Hi-Shear Spec. 305.



PULL-STEM™ PIN AND COLLAR AFTER ASSEMBLY

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



VIEW A

HI-LITE™ THREAD TRANSITION AREA THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS. SEE SPECIFICATION FOR INSPECTION.

"HI-KOTE", "HI-LITE", "PULL-STEM" AND "HSL", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY F. CARINGELLA	DATE 2016-01-28	TITLE PULL-STEM™ PIN PROTRUDING TENSION HEAD BREAK STEM, INTERFERENCE FIT TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED C. REITZ	DATE 2016-01-28	DRAWING NUMBER HSL1436	
REVISION 2	DATE D. PEÑA 2020-12-18	1 OF 2	

TABLE 2

SECOND DASH NUMBER	L REF				
	-8 DIA.	-10 DIA.	-12 DIA.	-14 DIA.	-16 DIA.
1	-	-	-	-	-
2	1.000	-	-	-	-
3	1.125	1.250	-	-	-
4	1.250	1.375	1.375	-	-
5	1.375	1.500	1.500	1.625	-
6	1.500	1.625	1.625	1.750	1.750
7	1.625	1.750	1.750	1.875	1.875
8	1.750	1.875	1.875	2.000	2.000
9	1.875	2.000	2.000	2.125	2.125
10	2.000	2.125	2.125	2.250	2.250
11	2.125	2.250	2.250	2.375	2.375
12	2.250	2.375	2.375	2.500	2.500
13	2.375	2.500	2.500	2.625	2.625
14	2.500	2.625	2.625	2.750	2.750
15	2.625	2.750	2.750	2.875	2.875
16	2.750	2.875	2.875	3.000	3.000
17	2.875	3.000	3.000	3.125	3.125
18	3.000	3.125	3.125	3.250	3.250
19	3.125	3.250	3.250	3.375	3.375
20	3.250	3.375	3.375	3.500	3.500
21	3.375	3.500	3.500	3.625	3.625
22	3.500	3.625	3.625	3.750	3.750
23	3.625	3.750	3.750	3.875	3.875
24	3.750	3.875	3.875	4.000	4.000
25	-	4.000	4.000	4.125	4.125
26	-	4.125	4.125	4.250	4.250
27	-	4.250	4.250	4.375	4.375
28	-	4.375	4.375	4.500	4.500
29	-	-	4.500	4.625	4.625
30	-	-	4.625	4.750	4.750
31	-	-	4.750	4.875	4.875
32	-	-	4.875	5.000	5.000
33	-	-	5.000	5.125	5.125
34	-	-	5.125	5.250	5.250
35	-	-	5.250	5.375	5.375
36	-	-	5.375	5.500	5.500
37	-	-	5.500	5.625	5.625
38	-	-	5.625	5.750	5.750
39	-	-	5.750	5.875	5.875
40	-	-	5.875	6.000	6.000
41	-	-	6.000	6.125	6.125
42	-	-	6.125	6.250	6.250
43	-	-	6.250	6.375	6.375
44	-	-	6.375	6.500	6.500

DRAWING NUMBER

HSL1436

2 OF 2