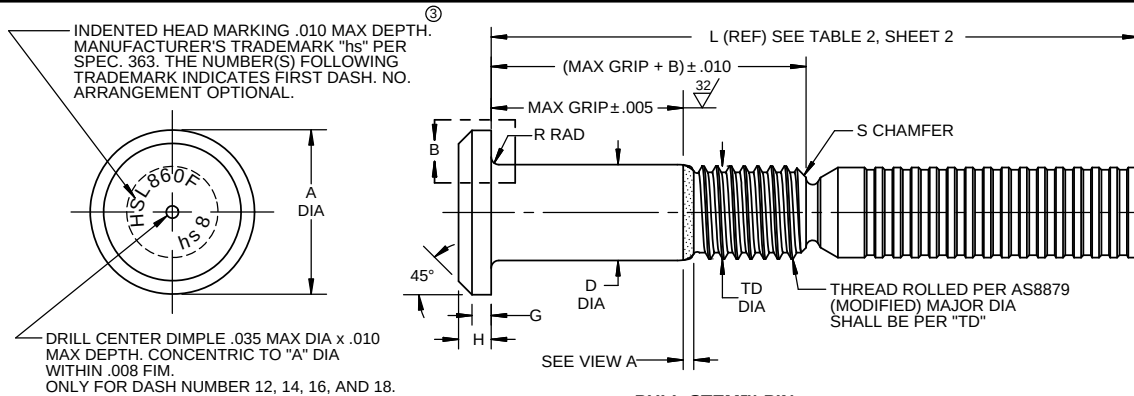


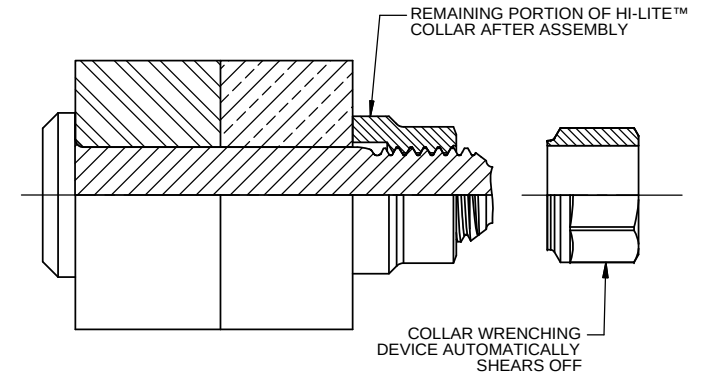


PULL-STEM™ PIN

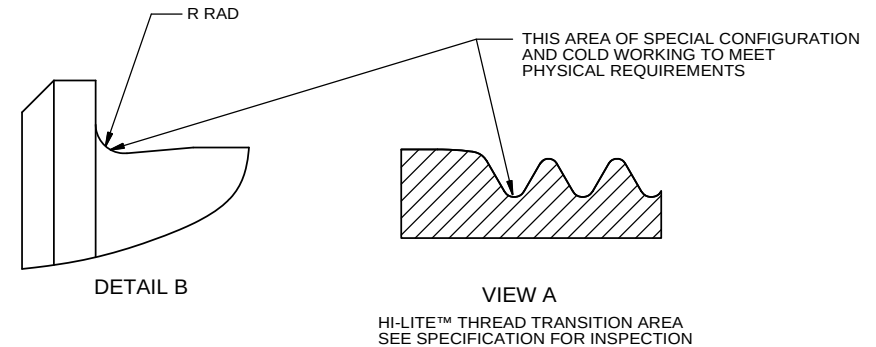
TABLE 1

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
6	7/32	.390 .370	.300	.2182 .2172	.1840 .1810	.035	.074 .064	.020 .010	1/32 x 37°	.1900-32 UNJF-3A	7,100	3,180	1,050
8	9/32	.460 .435	.330	.2807 .2797	.2440 .2410	.045	.090 .080	.020 .010	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
18	19/32	.900 .865	.610	.5927 .5917	.5550 .5500	.125	.210 .200	.035 .025	1/16 x 37°	.5625-18 UNJF-3A	52,600	32,400	11,381

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



PULL-STEM™ PIN AND COLLAR AFTER ASSEMBLY



- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within .010 FIM.
 - ③ 2. Dimensions are in inches and to be met after finish.
 - ③ 3. Surface texture per ASME B46.1.
 4. Hole preparation per NAS618.
 5. This PULL-STEM™ Pin is to be used in combination with a HI-LITE™ Collar.
 7. This PULL-STEM™ Pin to be used in interference fit holes only.
 8. Oversize replacement for HSL756F and HSL856F.
 - ③ 9 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 or AMS4967.

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum).

FINISH: HSL860AP()-()F = HI-KOTE™ 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

③ 9 HSL860NAP()-()F = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification HS412, except fillet per Detail B.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HSL860F oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See "Finish" note for explanation of code letters.

HOW TO ORDER
③ **EXAMPLE:**

Pin Part Number
HSL860AP8-8F
└─ 8/16 or 1/2 Maximum Grip Length
└─ 8/32 or 1/4 Nominal Diameter Pin
└─ Finish Code
└─ Pin Basic Part Number

"HI-KOTE", "HI-LITE", "PULL-STEM" AND "HSL", ARE TRADEMARKS OF HI-SHEAR CORPORATION			
DRAWN BY J.F.OBISPO	DATE 2004-03-01	TITLE PULL-STEM™ PIN PROTRUDING TENSION HEAD BREAK STEM, INTERFERENCE FIT SPECIAL, TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE	
APPROVED M.CAWLEY	DATE 2004-03-01		
REVISION ③	DATE M.BEARD 2017-10-31	DRAWING NUMBER HSL860F	

TABLE 2

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

HSL860F

DRAWING NUMBER

HSL860F

2 OF 2