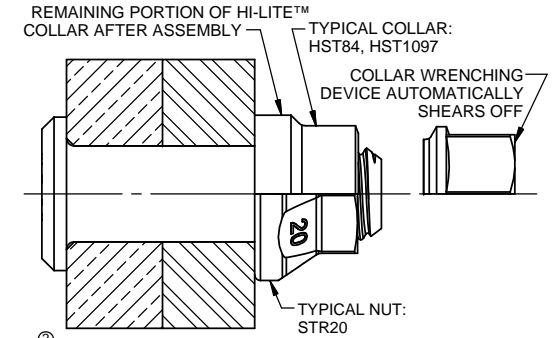
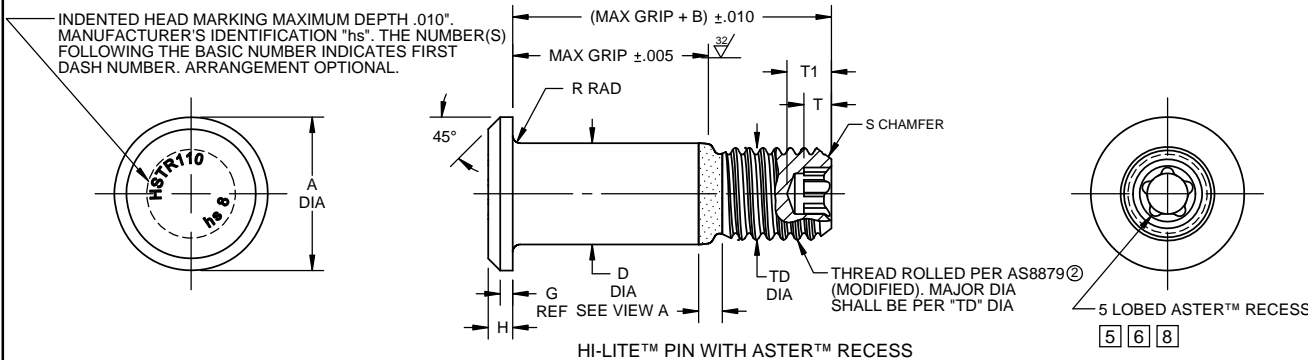


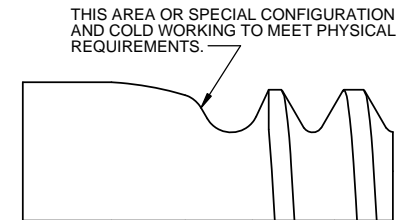
②

For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://WWW.LISI-AEROSPACE.COM/LICENSES)



RECOMMENDED COLLAR OR NUT FOR ASSEMBLY

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



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

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	ASTER™ RECESS			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT ALUMINUM COATING	WITH ALUMINUM COATING							RECESS SIZE CODE	T1 DEPTH MAX	T DEPTH MIN		
5																
NOTE: USE HSTR10() J6(-)																
6	13/64	.315 .295	.300	.2026 .2021	.2026 .2016	.1840 .1810	.025	.055 .045	.025 .015	1/32 X 37°	.1900-32 UNJF-3A	A5L-06	.116	.069	6,130	2,500
7	15/64	.351 .331	.315	.2338 .2333	.2338 .2328	.2100 .2070	.032	.059 .049	.025 .015	1/32 X 37°	.2160-28 UNJF-3A	A5L-07	.117	.069	8,100	3,100
8	17/64	.412 .387	.330	.2651 .2646	.2651 .2641	.2440 .2410	.030	.069 .059	.025 .015	1/32 X 37°	.2500-28 UNJF-3A	A5L-08	.118	.069	10,490	4,300
10	21/64	.505 .475	.390	.3276 .3271	.3276 .3266	.3060 .3020	.035	.078 .068	.030 .020	3/64 X 37°	.3125-24 UNJF-3A	A5L-10	.127	.070	16,000	6,300
12	25/64	.600 .565	.430	.3901 .3896	.3901 .3891	.3680 .3640	.040	.088 .078	.030 .020	3/64 X 37°	.3750-24 UNJF-3A	A5L-12	.147	.087	22,700	8,700
14	29/64	.676 .641	.495	.4526 .4521	.4526 .4516	.4310 .4260	.045	.105 .093	.030 .020	3/64 X 37°	.4375-20 UNJF-3A	A5L-14	.196	.116	30,600	12,100
16	33/64	.770 .735	.535	.5151 .5146	.5151 .5141	.4930 .4880	.050	.115 .103	.030 .020	3/64 X 37°	.5000-20 UNJF-3A	A5L-16	.236	.139	39,600	15,300

- GENERAL NOTES:**
1. Concentricity: "A" diameter 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. US patent 6632057; other US & foreign patents granted and pending property of LISI AEROSPACE.
 6. Broach petals removed.
 7. Oversize replacement for HSTR10. Use HSTR410 for oversize replacement.
 8. Identification colorant is not allowed in the ASTER™ Recess.

MATERIAL: 6Al-4V titanium alloy per AMS4928 or AMS4967.

HEAT TREAT: 160,000 psi tensile minimum (95,000 psi shear minimum for sizes up to 3/4).

FINISH: HSTR110NKJ()(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

HSTR110NKK()(-) = Sulfuric acid anodizing per ISO8080 and HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

HSTR110NKL()(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LITE™ Product Specification 410.
ASTER™ Recess per A5L-QA02.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HSTR110 oversize pin replaces. Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER
② **EXAMPLES:** Pin Part Number
HSTR110 NKJ 8-8

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

"HI-LITE", "HSTR", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION. ASTER™ IS A TRADEMARK OF LISI AEROSPACE.			
DRAWN BY F.CARINGELLA	DATE 2016-07-07	TITLE HI-LITE™ PIN, ASTER™ RECESS PROTRUDING SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE	
APPROVED C.REITZ	DATE 2016-07-07		
REVISION ②	DATE M.BEARD 2017-11-27	DRAWING NUMBER HSTR110 1 OF 1	