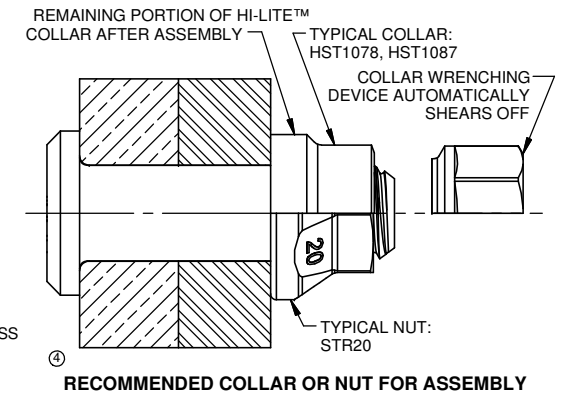
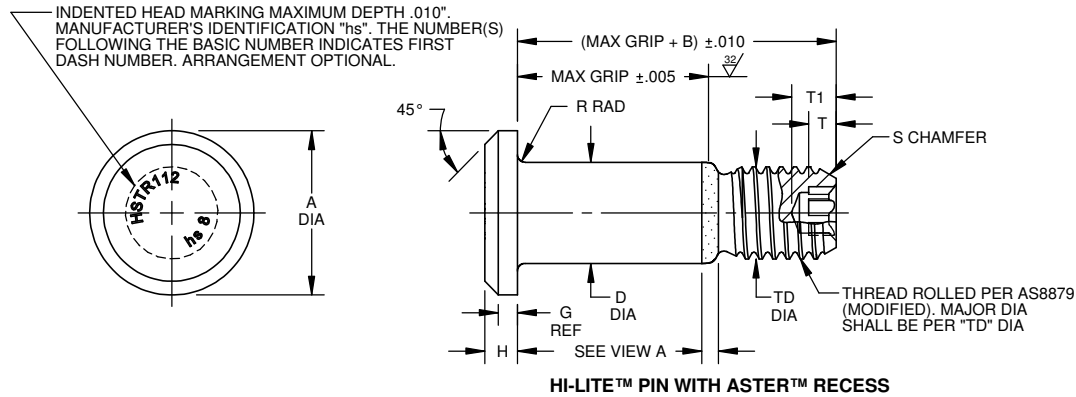


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[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)

④



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. 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 HSTR12()6-()															
6	13/64	.377 .357	.300	.2026 .2021	.2026 .2016	.1840 .1810	.035	.074 .064	.025 .015	1/32 X 37°	.1900-32 UNJF-3A	A5L-06	.116	.069	6,130	3,180
7	15/64	.410 .390	.315	.2338 .2333	.2338 .2328	.2100 .2070	.040	.081 .071	.025 .015	1/32 X 37°	.2160-28 UNJF-3A	A5L-07	.117	.069	8,100	4,000
8	17/64	.440 .415	.330	.2651 .2646	.2651 .2641	.2440 .2410	.045	.090 .080	.025 .015	1/32 X 37°	.2500-28 UNJF-3A	A5L-08	.118	.069	10,490	5,820
10	21/64	.505 .475	.390	.3276 .3271	.3276 .3266	.3060 .3020	.055	.112 .102	.030 .020	3/64 X 37°	.3125-24 UNJF-3A	A5L-10	.127	.070	16,000	9,200
12	25/64	.600 .565	.430	.3901 .3896	.3901 .3891	.3680 .3640	.075	.140 .130	.030 .020	3/64 X 37°	.3750-24 UNJF-3A	A5L-12	.147	.087	22,700	14,000
14	29/64	.676 .641	.510	.4526 .4521	.4526 .4516	.4310 .4260	.095	.160 .150	.030 .020	3/64 X 37°	.4375-20 UNJF-3A	A5L-14	.196	.116	30,600	18,900
16	33/64	.770 .735	.610	.5151 .5146	.5151 .5141	.4930 .4880	.095	.188 .178	.030 .020	3/64 X 37°	.5000-20 UNJF-3A	A5L-16	.236	.139	39,600	25,600

"HI-LITE", "HSTR", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION. ASTER™ IS A TRADEMARK OF LISI AEROSPACE.

DRAWN BY F.CARINGELLA	DATE 2014-11-03	TITLE HI-LITE™ PIN, ASTER™ RECESS PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED C. REILTZ	DATE 2016-04-04	
REVISION ④	DATE F.CARINGELLA 2017-11-28	DRAWING NUMBER HSTR112

1 OF 2

GENERAL NOTES:

1. Concentricity: "A" diameter to "D" diameter within .010 FIM.
2. Dimensions are in inches and to be met after finish.
- ④ 3. Surface texture per ASME B46.1.
4. Hole preparation per NAS618.
5. Removed.
- ⑥ 6. US patent 6632057; other US & foreign patents granted and pending property of LISI AEROSPACE.
- ⑦ 7. Broach petals removed.
8. Oversize replacement for HSTR12. Use HSTR412 for next oversize replacement.
- ④ ⑨ 9. 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: HSTR112NKJ()-() = 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.

HSTR112NKK()-() = 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.

HSTR112NKL()-() = 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 HSTR112 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

④ **EXAMPLES:**

Pin Part Number
 HSTR112 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

HSTR112