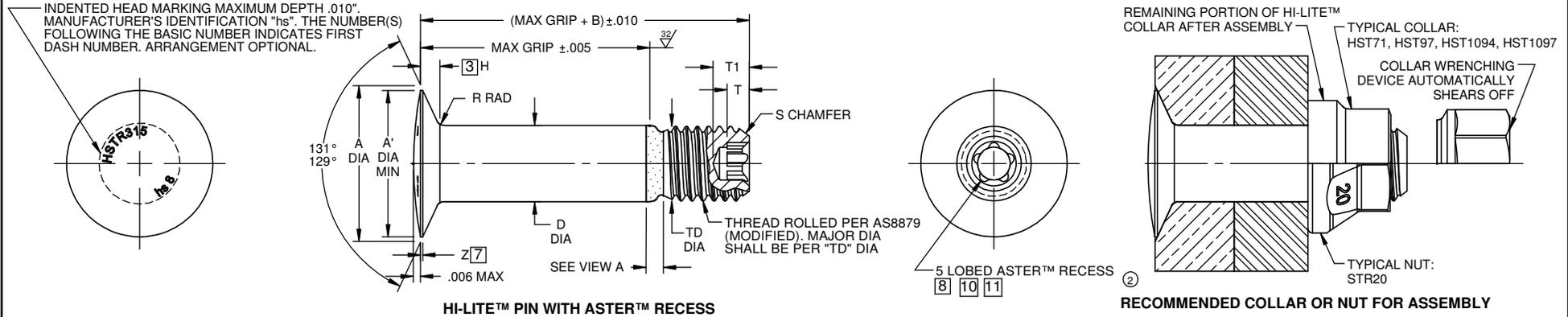


For the current list of licensed manufacturers, please visit the
 LISI AEROSPACE website at:
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://WWW.LISI-AEROSPACE.COM/LICENSES)



FIRST DASH NO.	PIN NOM DIA	A DIA	A' DIA MIN	B REF	D DIA		TD DIA	F REF	H	R RAD	Z MAX	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	5/32								.3939 .3308	.305	.280		
6	3/16	.3911 .3825	.332	.290	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32 X 37°	.1900-32 UNJF-3A	A5L-06	.116	.069	5,380	2,000
7	7/32	.4468 .4382	.387	.305	.2182 .2177	.2182 .2172	.2100 .2070	.005	.0535 .0516	.030 .020	.015	1/32 X 37°	.2160-28 UNJF-3A	A5L-07	.117	.069	7,194	2,600
8	1/4	.5111 .5026	.451	.320	.2495 .2490	.2495 .2485	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32 X 37°	.2500-28 UNJF-3A	A5L-08	.118	.069	9,300	3,700
10	5/16	.6037 .5951	.544	.380	.3120 .3115	.3120 .3110	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64 X 37°	.3125-24 UNJF-3A	A5L-10	.127	.070	14,600	5,000
12	3/8	.7090 .7005	.649	.420	.3745 .3740	.3745 .3735	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64 X 37°	.3750-24 UNJF-3A	A5L-12	.147	.087	21,000	7,200
14	7/16	.8526 .8419	.780	.485	.4370 .4365	.4370 .4360	.4310 .4260	.009	.0969 .0944	.050 .040	.022	3/64 X 37°	.4375-20 UNJF-3A	A5L-14	.196	.116	28,600	10,000
16	1/2	.9576 .9468	.880	.525	.4995 .4990	.4995 .4985	.4930 .4880	.010	.1068 .1043	.050 .040	.022	3/64 X 37°	.5000-20 UNJF-3A	A5L-16	.236	.139	37,300	13,500

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

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



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

HSTR315

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

DRAWN BY F.CARINGELLA	DATE 2016-04-14	TITLE HI-LITE™ PIN, ASTER™ RECESS 130° FLUSH CROWN SHEAR HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED C.REITZ	DATE 2016-04-14	DRAWING NUMBER HSTR315
REVISION 2	DATE 2017-11-28	1 OF 2

- GENERAL NOTES:**
- 1 Head edge out of roundness shall not exceed "F".
 - 2 Concentricity: Conical surface of head to "D" diameter within .003 FIM.
 - 3 "H" is dimensioned from maximum "D" diameter.
 - 4 Dimensions are in inches and to be met after finish.
 - 5 Surface texture per ASME B46.1.
 - 6 .Hole preparation per NAS618.
 - 7 Curved or flat edge manufacturer's option.
 - 8 US patent 6632057; other US & foreign patents granted and pending property of LISI AEROSPACE.
 - 9 Use HSTR415 for oversize replacement.
 - 10 Broach petals removed.
 - 11 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). ②

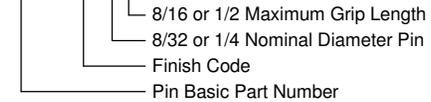
- FINISH:**
- HSTR315NKJ(-)(-) = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HSTR315NKK(-)(-) = Sulfuric acid anodizing per ISO8080 and HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
 - HSTR315NKL(-)(-) = 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.
Second dash number indicates maximum grip in 1/16ths.
See Finish note for explanation of code letters.

HOW TO ORDER Pin Part Number

② **EXAMPLES:** HSTR315 NKJ 8-8



HSTR315

DRAWING NUMBER

HSTR315

2 OF 2