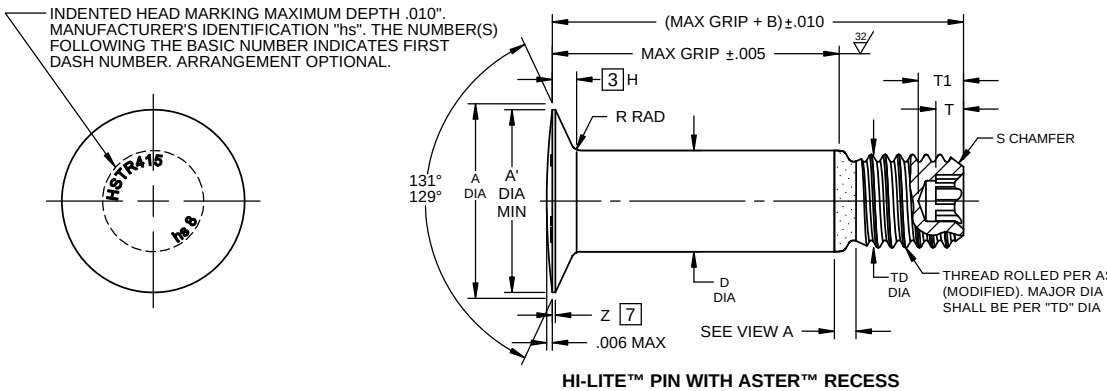
lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

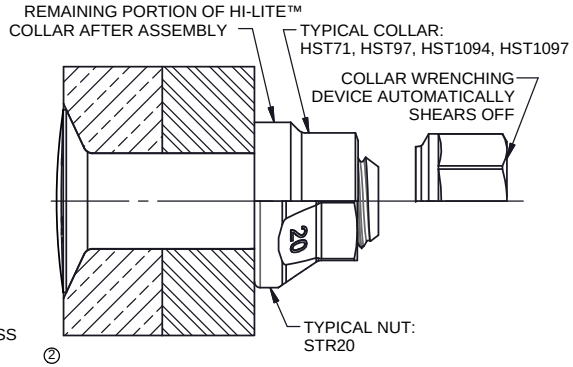
Design Holder

CAGE No. 73197

② For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES



HI-LITE™ PIN WITH ASTER™ RECESS

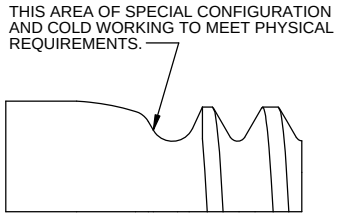


② **RECOMMENDED COLLAR OR NUT FOR ASSEMBLY**

[1] [7]

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	NOTE: USE HSTR315( )6-( )																	
6	13/64	.3911 .3825	.332	.300	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0440 .0420	.030 .020	.015	1/32 X 37°	.1900-32 UNJF-3A	A5L-06	.116	.069	6,130	2,000
7	15/64	.4468 .4382	.387	.315	.2338 .2333	.2338 .2328	.2100 .2070	.006	.0535 .0516	.030 .020	.015	1/32 X 37°	.2160-28 UNJF-3A	A5L-07	.117	.069	8,100	2,600
8	17/64	.5111 .5026	.451	.330	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0580 .0560	.030 .020	.015	1/32 X 37°	.2500-28 UNJF-3A	A5L-08	.118	.069	10,490	3,700
10	21/64	.6037 .5951	.544	.390	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0650 .0630	.040 .030	.015	3/64 X 37°	.3125-24 UNJF-3A	A5L-10	.127	.070	16,000	5,000
12	25/64	.7090 .7005	.649	.430	.3901 .3896	.3901 .3891	.3680 .3640	.008	.0750 .0730	.040 .030	.015	3/64 X 37°	.3750-24 UNJF-3A	A5L-12	.147	.087	22,700	7,200
14	29/64	.8526 .8419	.780	.495	.4526 .4521	.4526 .4516	.4310 .4260	.009	.0930 .0910	.050 .040	.020	3/64 X 37°	.4375-20 UNJF-3A	A5L-14	.196	.116	30,600	10,000
16	33/64	.9576 .9468	.880	.535	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1030 .1010	.050 .040	.022	3/64 X 37°	.5000-20 UNJF-3A	A5L-16	.236	.139	39,600	13,500

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

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

DRAWN BY F.CARINGELLA DATE 2016-04-15	TITLE: HI-LITE™ PIN, ASTER™ RECESS 130° FLUSH CROWN SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE
APPROVED C.REITZ DATE 2016-04-15	
REVISION ② DATE M.BEARD 2017-11-28	DRAWING NUMBER HSTR415 1 OF 2

HSTR415

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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. ② 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. Oversize replacement for HSTR315. Use HSTR515 for oversize replacement.
10. Broach petals removed.
11. ② 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:

HSTR415NKJ( )-( ) = 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.

HSTR415NKK( )-( ) = 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.

HSTR415NKL( )-( ) = 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 this HSTR415 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
HSTR415 NKJ 8-8
- 8-8: 8/16 or 1/2 Maximum Grip Length
- 8: 8/32 or 1/4 Nominal Diameter Pin
- NKJ: Finish Code
- HSTR415: Pin Basic Part Number

HSTR415

DRAWING NUMBER
HSTR415