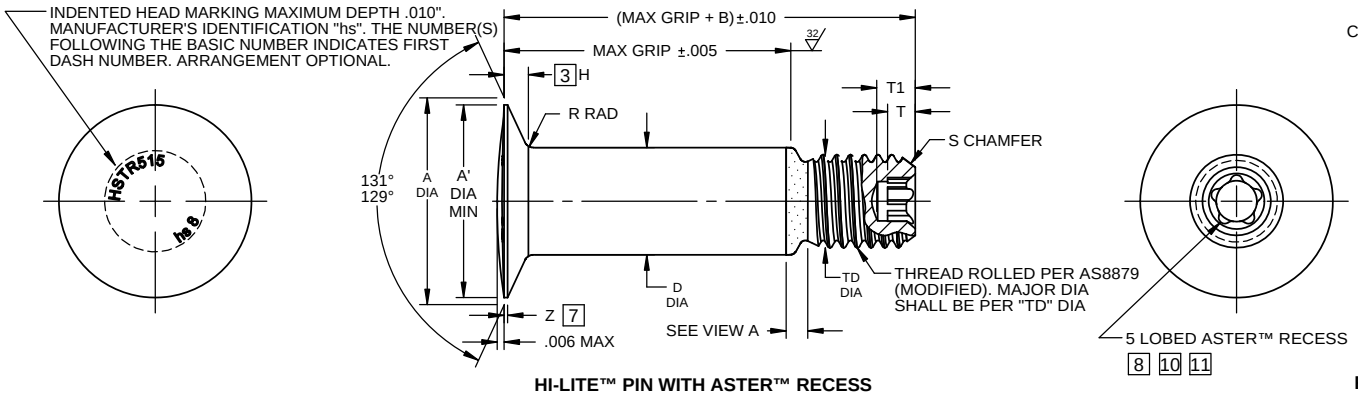
lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.

HI-SHEAR Corporation, USA
a LISI AEROSPACE Company

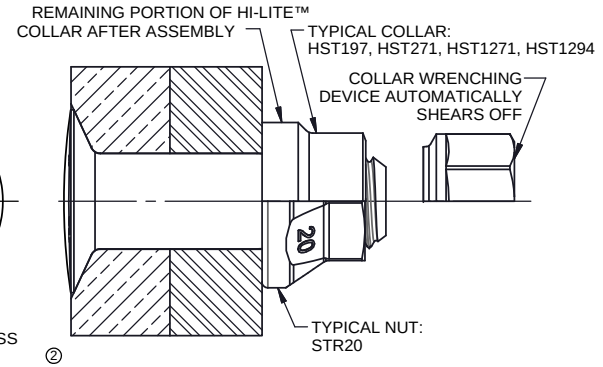
Design Holder

CAGE No. 73197

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



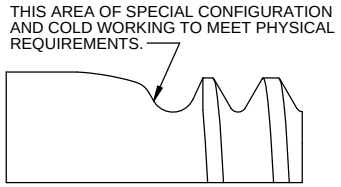
HI-LITE™ PIN WITH ASTER™ RECESS



② **RECOMMENDED COLLAR OR NUT FOR ASSEMBLY**

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

FIRST DASH NO.	PIN NOM DIA	A DIA	A' DIA MIN	B REF	D DIA WITHOUT ALUMINUM COATING	D DIA WITH ALUMINUM COATING	TD DIA	F REF	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	ASTER™ RECESS SIZE CODE	ASTER™ RECESS T1 DEPTH MAX	ASTER™ RECESS T DEPTH MIN	DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
5	NOTE: USE HSTR415( )6-( )																	
6	7/32	.4198 .4112	.361	.300	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0405 .0385	.030 .020	.015	1/32 X 37°	.1900-32 UNJF-3A	A5L-06	.116	.069	7,100	2,000
7	NOTE: USE HSTR315( )8-( )																	
8	9/32	.5423 .5337	.482	.330	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0542 .0522	.030 .020	.015	1/32 X 37°	.2500-28 UNJF-3A	A5L-08	.118	.069	11,800	3,700
10	11/32	.6349 .6263	.575	.390	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0612 .0592	.040 .030	.015	3/64 X 37°	.3125-24 UNJF-3A	A5L-10	.127	.070	17,600	5,000
12	13/32	.7402 .7316	.680	.430	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0712 .0692	.040 .030	.015	3/64 X 37°	.3750-24 UNJF-3A	A5L-12	.147	.087	24,600	7,200
14	15/32	.8526 .8419	.780	.495	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0899 .0874	.050 .040	.022	3/64 X 37°	.4375-20 UNJF-3A	A5L-14	.196	.116	32,700	10,000
16	17/32	.9576 .9468	.880	.535	.5307 .5302	.5307 .5297	.4930 .4880	.010	.0998 .0973	.050 .040	.022	3/64 X 37°	.5000-20 UNJF-3A	A5L-16	.236	.139	42,000	13,500



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, 1/32 OVERSIZE
APPROVED C.REITZ DATE 2016-04-15	
REVISION ② DATE M.BEARD 2017-11-29	DRAWING NUMBER: HSTR515 1 OF 2

HSTR515

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

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 HSTR415.
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: ② 160,000 psi tensile minimum.

FINISH:

HSTR515NKJ( )-( ) = 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.

HSTR515NKK( )-( ) = 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.

HSTR515NKL( )-( ) = 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 HSTR515 oversize pin replaces. 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:** HSTR515 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

HSTR515

DRAWING NUMBER
HSTR515 2 OF 2