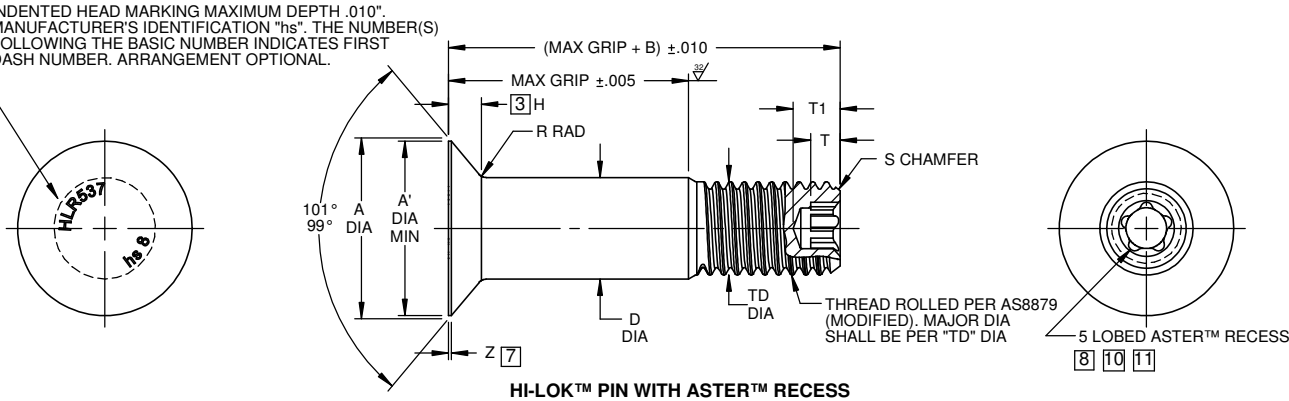


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 LISI AEROSPACE website at:  
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)

②

INDENTED HEAD MARKING MAXIMUM DEPTH .010".  
 MANUFACTURER'S IDENTIFICATION "hs". THE NUMBER(S)  
 FOLLOWING THE BASIC NUMBER INDICATES FIRST  
 DASH NUMBER. ARRANGEMENT OPTIONAL.

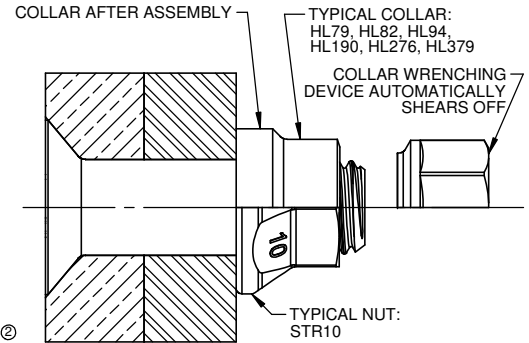


HI-LOK™ PIN WITH ASTER™ RECESS

①

⑦

REMAINING PORTION OF HI-LOK™  
 COLLAR AFTER ASSEMBLY



RECOMMENDED COLLAR OR NUT FOR ASSEMBLY

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 HLR523( )6-( )																	
6	13/64	.3536 .3486	.322	.325	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0633 .0612	.030 .020	.015	1/32 X 37°	.1900-32 UNJF-3A	A5L-06	.116	.069	6,130	2,590
7	15/64	.4007 .3959	.382	.355	.2338 .2333	.2338 .2328	.2100 .2070	.006	.0704 .0684	.030 .020	.015	1/32 X 37°	.2160-28 UNJF-3A	A5L-07	.117	.069	8,100	3,400
8	17/64	.4732 .4682	.442	.395	.2651 .2646	.2651 .2641	.2440 .2410	.006	.0873 .0852	.030 .020	.015	1/32 X 37°	.2500-28 UNJF-3A	A5L-08	.118	.069	10,490	4,760
10	21/64	.5619 .5569	.531	.500	.3276 .3271	.3276 .3266	.3060 .3020	.007	.0983 .0962	.040 .030	.015	3/64 X 37°	.3125-24 UNJF-3A	A5L-10	.127	.070	16,000	7,100
12	25/64	.6912 .6862	.660	.545	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1263 .1242	.040 .030	.015	3/64 X 37°	.3750-24 UNJF-3A	A5L-12	.147	.087	22,700	10,600
14	29/64	.8041 .7969	.756	.635	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1474 .1444	.050 .040	.022	3/64 X 37°	.4375-20 UNJF-3A	A5L-14	.196	.116	30,600	14,450
16	33/64	.9166 .9095	.868	.685	.5151 .5146	.5151 .5141	.4930 .4880	.010	.1685 .1655	.050 .040	.022	3/64 X 37°	.5000-20 UNJF-3A	A5L-16	.236	.139	39,600	19,550

②

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

HLR537

"HI-LOK", "HLR", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION. ASTER™ IS A TRADEMARK OF LISI AEROSPACE.	
DRAWN BY F.CARINGELLA	DATE 2016-04-27
APPROVED C.REITZ	DATE 2016-04-27
REVISION ②	DATE F.CARINGELLA 2017-12-06
TITLE HI-LOK™ PIN, ASTER™ RECESS 100° FLUSH MS20426 HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE	
DRAWING NUMBER <b>HLR537</b>	
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.
  - ② 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. Oversize replacement replacement for HLR523. Use HLR823 for oversize replacement.
  - 10 Broach petals removed.
  - ② 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:** HLR537NKJ( )-( ) = 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.

HLR537NKK( )-( ) = 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.

HLR537NKL( )-( ) = 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-LOK™ Product Specification 409.  
 ASTER™ Recess per A5L-QA02.

**CODE:** First dash number indicates nominal diameter in 1/32nds of the pin which HLR537 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:** HLR537 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

HLR537

DRAWING NUMBER

**HLR537**

2 OF 2