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

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HTTP://WWW.LISI-AEROSPACE.COM/LICENSES

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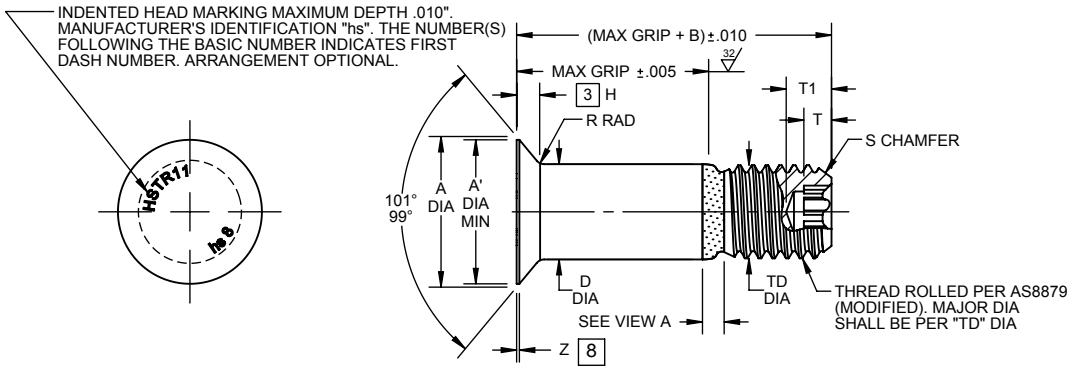
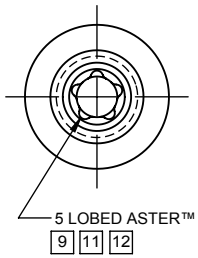
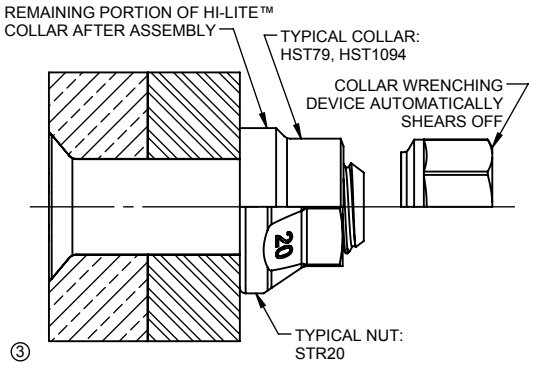


HI-LITE™ PIN WITH ASTER™ RECESS





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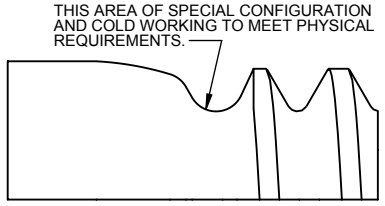
RECOMMENDED COLLAR OR NUT FOR ASSEMBLY

1 8

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	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	5/32	.2612 .2564	.242	.280	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0410 .0390	.025 .015	.010	1/32 X 37°	.1640-32 UNJC-3A	A5L-05	.118	.072	4,010	1,650
6	3/16	.3016 .2966	.270	.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	.3403 .3355	.309	.305	.2182 .2177	.2182 .2172	.2100 .2070	.005	.0512 .0492	.030 .020	.015	1/32 X 37°	.2160-28 UNJF-3A	A5L-07	.117	.069	7,194	3,100
8	1/4	.3948 .3898	.363	.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	.4739 .4689	.442	.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	.5604 .5554	.529	.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	.6680 .6620	.620	.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	.7540 .7480	.706	.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.



VIEW A

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

DRAWN BY	DATE	TITLE
F.CARINGELLA	2016-03-29	HI-LITE™ PIN, ASTER™ RECESS 100° FLUSH SHEAR HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED	DATE	
C. RIETZ	2016-03-29	
REVISION	DATE	DRAWING NUMBER
③	F.CARINGELLA 2017-11-27	**HSTR11**

1 OF 2

HSTR11

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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.
③ 5. Surface texture per ASME B46.1.
6. Hole preparation per NAS618.
7. Removed
8. Curved or flat edge manufacturer's option.
9. US patent 6632057; other US & foreign patents granted and pending property of LISI AEROSPACE.
10. Use HSTR111 for oversize replacement.
11. Broach petals removed.
③ 12. Identification colorant is not allowed in the ASTER™ Recess.

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
③ **EXAMPLES:**

PIN PART NUMBER
HSTR11 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

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:

HSTR11NKJ( )-( ) = 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.

HSTR11NKK( )-( ) = 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.

HSTR11NKL( )-( ) = 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.