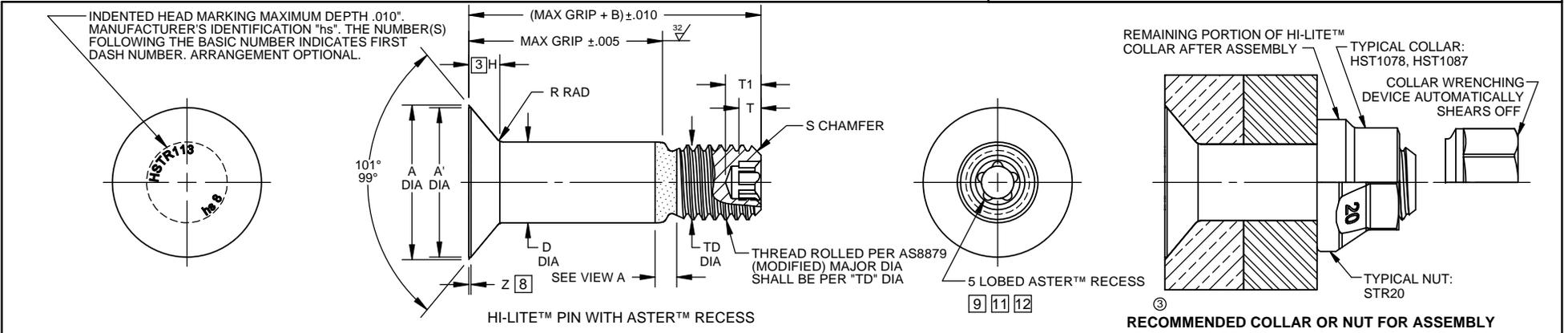


③ For the current list of licensed manufacturers, please visit the LISI AEROSPACE website at:  
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FIRST DASH NO.	PIN NOM DIA	A DIA	A' DIA MIN	B REF	D DIA		TD DIA	F	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	ASTER™ RECESS			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
					WITHOUT ALUMINUM COATING	WITH ALUMINUM COATING								RECESS SIZE CODE	T1 DEPTH MAX	T DEPTH MIN		
5	NOTE: USE HSTR13( )6(-)																	
6	13/64	.3813 .3765	.350	.300	.2026 .2021	.2026 .2016	.1840 .1810	.005	.0750 .0730	.030 .020	.015	1/32 X 37°	.1900-32 UNJF-3A	A5L-06	.116	.069	6,130	3,180
7	15/64	.4425 .4378	.413	.315	.2338 .2333	.2338 .2328	.2100 .2070	.006	.0900 .0880	.030 .020	.015	1/32 X 37°	.2160-28 UNJF-3A	A5L-07	.117	.069	8,100	4,000
8	17/64	.5066 .5018	.475	.330	.2651 .2646	.2651 .2641	.2440 .2410	.006	.1013 .0993	.030 .020	.015	1/32 X 37°	.2500-28 UNJF-3A	A5L-08	.118	.069	10,490	5,820
10	21/64	.6335 .6287	.602	.390	.3276 .3271	.3276 .3266	.3060 .3020	.007	.1283 .1263	.040 .030	.015	3/64 X 37°	.3125-24 UNJF-3A	A5L-10	.127	.070	16,000	9,200
12	25/64	.7604 .7556	.729	.430	.3901 .3896	.3901 .3891	.3680 .3640	.008	.1553 .1533	.040 .030	.015	3/64 X 37°	.3750-24 UNJF-3A	A5L-12	.147	.087	22,700	14,000
14	29/64	.8884 .8812	.840	.510	.4526 .4521	.4526 .4516	.4310 .4260	.009	.1828 .1798	.050 .040	.022	3/64 X 37°	.4375-20 UNJF-3A	A5L-14	.196	.116	30,600	18,900
16	33/64	1.0139 1.0068	.969	.610	.5151 .5146	.5151 .5141	.4930 .4880	.010	.2365 .2335	.050 .040	.022	3/64 X 37°	.5000-20 UNJF-3A	A5L-16	.236	.139	39,600	25,600

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

THIS AREA OR SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS.



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

HSTR113

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

DRAWN BY F.CARINGELLA	DATE 2014-11-03	TITLE HI-LITE™ PIN, ASTER RECESS
APPROVED C.REITZ	DATE 2016-04-04	100° FLUSH MS24694 TENSION HEAD TITANIUM 1/16 GRIP VARIATION, 1/64 OVERSIZE
REVISION 3	DATE M.BEARD 2017-11-28	DRAWING NUMBER <b>HSTR113</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.
  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. Oversize replacement for HSTR13. Use HSTR413 for oversize replacement.
  11. Broach petals removed.
  12. 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:** HSTR113NKJ(-) = 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.
- HSTR113NKK(-) = 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.
- HSTR113NKL(-) = 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 HSTR113 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

③ **EXAMPLES:** HSTR113 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

HSTR113

DRAWING NUMBER

**HSTR113**

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