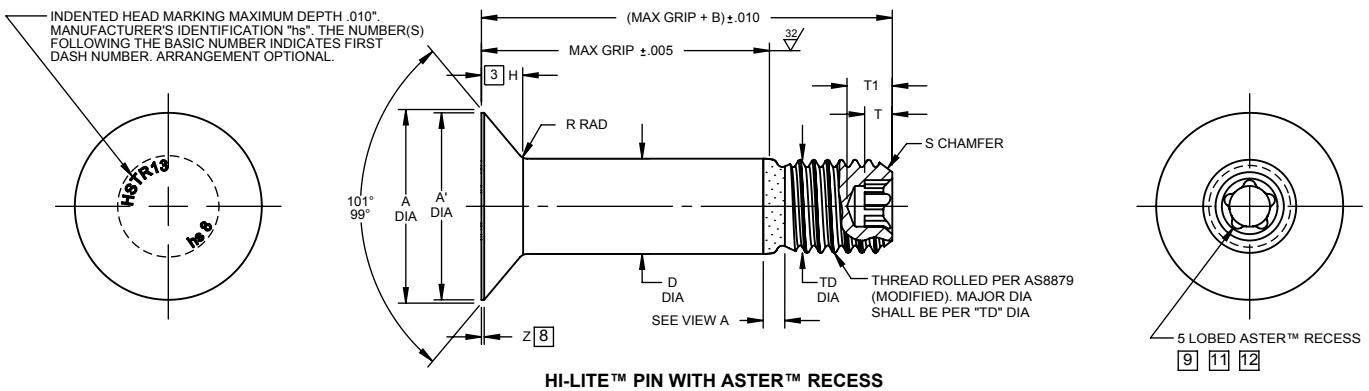
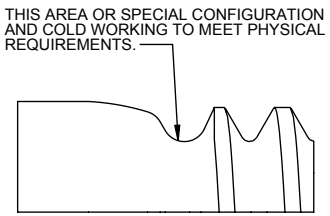
lisi AEROSPACE
hi-shear corporation
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509 U.S.A.



HI-LITE™ PIN WITH ASTER™ RECESS

	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 [1]	H	R RAD	Z MAX [8]	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	.3304 .3256	.311	.280	.1635 .1630	.1635 .1625	.1595 .1570	.004	.0700 .0680	.025 .015	.012	1/32 X 37°	.1640-32 UNJC-3A	A5L-05	.118	.072	4,010	2,180
	6	3/16	.3813 .3765	.350	.290	.1895 .1890	.1895 .1885	.1840 .1810	.005	.0805 .0785	.030 .020	.015	1/32 X 37°	.1900-32 UNJF-3A	A5L-06	.116	.069	5,380	3,180
③	7	7/32	.4425 .4378	.413	.305	.2182 .2177	.2182 .2172	.2100 .2070	.006	.0940 .0920	.030 .020	.015	1/32 X 37°	.2160-28 UNJF-3A	A5L-07	.117	.069	7,194	4,000
	8	1/4	.5066 .5018	.475	.320	.2495 .2490	.2495 .2485	.2440 .2410	.006	.1080 .1060	.030 .020	.015	1/32 X 37°	.2500-28 UNJF-3A	A5L-08	.118	.069	9,300	5,820
	10	5/16	.6335 .6287	.602	.380	.3120 .3115	.3120 .3110	.3060 .3020	.007	.1350 .1330	.040 .030	.015	3/64 X 37°	.3125-24 UNJF-3A	A5L-10	.127	.070	14,600	9,200
	12	3/8	.7604 .7556	.729	.420	.3745 .3740	.3745 .3735	.3680 .3640	.008	.1620 .1600	.040 .030	.015	3/64 X 37°	.3750-24 UNJF-3A	A5L-12	.147	.087	21,000	14,000
③	14	7/16	.8884 .8812	.840	.500	.4370 .4365	.4370 .4360	.4310 .4260	.009	.1895 .1865	.050 .040	.022	3/64 X 37°	.4375-20 UNJF-3A	A5L-14	.196	.116	28,600	18,900
③	16	1/2	1.0139 1.0068	.969	.600	.4995 .4990	.4995 .4985	.4930 .4880	.010	.2160 .2130	.050 .040	.022	3/64 X 37°	.5000-20 UNJF-3A	A5L-16	.236	.139	37,300	25,600



VIEW A

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

HSTR13

DRAWN BY: F. CARINGELLA — DATE: 8/29/12	TITLE: HI-LITE™ PIN, ASTER™ RECESS 100° FLUSH MS24694 TENSION HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED: C. REITZ — DATE: 3/29/16	
REVISION: ③ — DATE: F.C. 3/17/16	DRAWING NUMBER: HSTR13

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③ **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 ANSI B46.1.
6. HOLE PREPARATION PER NAS618.
7. ③ 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 HSTR113 FOR OVERSIZE REPLACEMENT.
11. BROACH PETALS REMOVED.
12. NO IDENTIFICATION COLORANT IS ALLOWED IN THE ASTER™ RECESS.

MATERIAL: 6AL-4V TITANIUM ALLOY PER AMS4928 OR AMS4967.

③ **HEAT TREAT:** 160,000 PSI TENSILE MINIMUM (95,000 PSI SHEAR MINIMUM FOR SIZES UP TO 3/4)

FINISH: HSTR13NKJ( )-( ) = 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.

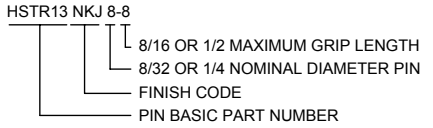
HSTR13NKK( )-( ) = SULFURIC ACID ANODIZING PER ISO8080 AND HI-KOTE™ 1 NC ALUMINUM PIGMENTED COATING PER HI-SHEAR SPEC. 294 ON THREADS ONLY WITH COLOR SILVER ON THREAD END AND CETYL ALCOHOL LUBE PER HI-SHEAR SPEC. 305.

HSTR13NKL( )-( ) = 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.

③ **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 EXAMPLES: PIN PART NUMBER ONLY



HSTR13

REVISION	DRAWING NUMBER
③	HSTR13