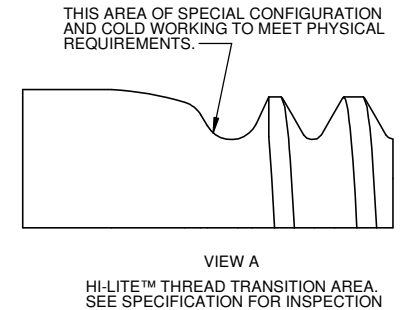


FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	ASTER™ RECESS			DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
				WITHOUT ALUMINUM COATING	WITH ALUMINUM COATING							RECESS SIZE CODE	T1 DEPTH MAX	T DEPTH MIN		
5	5/32	.262 .242	.280	.1635 .1630	.1635 .1625	.1595 .1570	.020	.047 .037	.025 .015	1/32 X 37°	.1640-32 UNJC-3A	A5L-05	.118	.072	4,010	1,940
6	3/16	.315 .295	.290	.1895 .1890	.1895 .1885	.1840 .1810	.025	.055 .045	.025 .015	1/32 X 37°	.1900-32 UNJF-3A	A5L-06	.116	.069	5,380	2,500
7	7/32	.351 .331	.305	.2182 .2177	.2182 .2172	.2100 .2070	.035	.059 .049	.025 .015	1/32 X 37°	.2160-28 UNJF-3A	A5L-07	.117	.069	7,194	3,100
8	1/4	.412 .387	.320	.2495 .2490	.2495 .2485	.2440 .2410	.030	.069 .059	.025 .015	1/32 X 37°	.2500-28 UNJF-3A	A5L-08	.118	.069	9,300	4,300
10	5/16	.505 .475	.380	.3120 .3115	.3120 .3110	.3060 .3020	.035	.078 .068	.030 .020	3/64 X 37°	.3125-24 UNJF-3A	A5L-10	.127	.070	14,600	6,300
12	3/8	.600 .565	.420	.3745 .3740	.3745 .3735	.3680 .3640	.040	.088 .078	.030 .020	3/64 X 37°	.3750-24 UNJF-3A	A5L-12	.147	.087	21,000	8,700
14	7/16	.676 .641	.485	.4370 .4365	.4370 .4360	.4310 .4260	.045	.105 .093	.030 .020	3/64 X 37°	.4375-20 UNJF-3A	A5L-14	.196	.116	28,600	12,100
16	1/2	.770 .735	.525	.4995 .4990	.4995 .4985	.4930 .4880	.050	.115 .103	.030 .020	3/64 X 37°	.5000-20 UNJF-3A	A5L-16	.236	.139	37,300	15,300



GENERAL NOTES:

1. CONCENTRICITY: "A" DIAMETER TO "D" DIAMETER WITHIN .010 FIM.
2. DIMENSIONS ARE IN INCHES AND TO BE MET AFTER FINISH.
3. SURFACE TEXTURE PER ANSI B46.1.
4. HOLE PREPARATION PER NAS618.
5. REMOVED
6. US PATENT 6632057; OTHER US & FOREIGN PATENTS GRANTED AND PENDING PROPERTY OF LISI AEROSPACE.
7. BROACH PETALS REMOVED.
8. USE HSTR110 FOR OVERSIZE REPLACEMENT.
9. NO IDENTIFICATION COLORANT IS 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; 90,000 PSI SHEAR MINIMUM FOR 7/8 AND LARGER)

FINISH: HSTR10NKJ(-) = 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.

HSTR10NKK(-) = 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.

HSTR10NKL(-) = 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.
SECOND DASH NUMBER INDICATES MAXIMUM GRIP IN 1/16THS.
SEE FINISH NOTE FOR EXPLANATION OF CODE LETTERS.

HOW TO ORDER

PIN PART NUMBER ONLY

EXAMPLES:

HSTR10 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

"HI-LITE", "HSTR", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION. ASTER™ IS A TRADEMARK OF LISI AEROSPACE.		
DRAWN BY F. CARINGELLA	DATE 3/29/16	TITLE HI-LITE™ PIN, ASTER™ RECESS PROTRUDING SHEAR HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED C. REITZ	DATE 3/29/16	
REVISION ②	DATE F.C. 7/7/16	DRAWING NUMBER HSTR10