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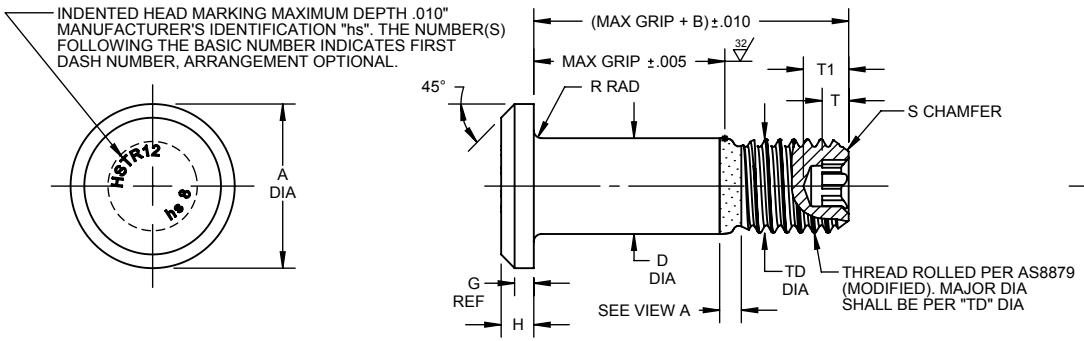
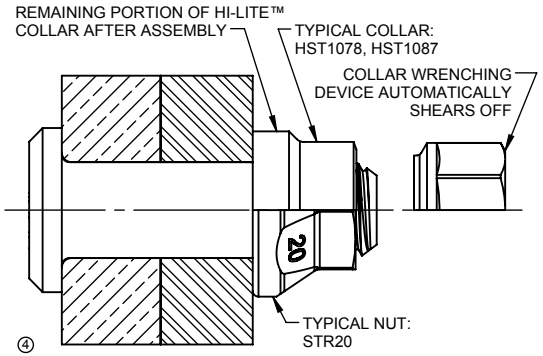
HTTP://WWW.LISI-AEROSPACE.COM/LICENSES

④



HI-LITE™ PIN WITH ASTER™ RECESS

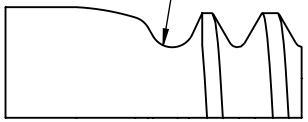


④ **RECOMMENDED COLLAR OR NUT FOR ASSEMBLY**

FIRST DASH NO.	PIN NOM DIA	A DIA	B REF	D DIA WITHOUT ALUMINUM COATING	D DIA WITH ALUMINUM COATING	TD DIA	G REF	H	R RAD	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	.322 .306	.280	.1635 .1630	.1635 .1625	.1595 .1570	.030	.065 .055	.025 .015	1/32 X 37°	.1640-32 UNJC-3A	A5L-05	.118	.072	4,010	2,180
6	3/16	.377 .357	.290	.1895 .1890	.1895 .1885	.1840 .1810	.035	.074 .064	.025 .015	1/32 X 37°	.1900-32 UNJF-3A	A5L-06	.116	.069	5,380	3,180
7	7/32	.410 .390	.305	.2182 .2177	.2182 .2172	.2100 .2070	.040	.081 .071	.025 .015	1/32 X 37°	.2160-28 UNJF-3A	A5L-07	.117	.069	7,194	4,000
8	1/4	.440 .415	.320	.2495 .2490	.2495 .2485	.2440 .2410	.045	.090 .080	.025 .015	1/32 X 37°	.2500-28 UNJF-3A	A5L-08	.118	.069	9,300	5,820
10	5/16	.505 .475	.380	.3120 .3115	.3120 .3110	.3060 .3020	.055	.112 .102	.030 .020	3/64 X 37°	.3125-24 UNJF-3A	A5L-10	.127	.070	14,600	9,200
12	3/8	.600 .565	.420	.3745 .3740	.3745 .3735	.3680 .3640	.075	.140 .130	.030 .020	3/64 X 37°	.3750-24 UNJF-3A	A5L-12	.147	.087	21,000	14,000
14	7/16	.676 .641	.500	.4370 .4365	.4370 .4360	.4310 .4260	.095	.160 .150	.030 .020	3/64 X 37°	.4375-20 UNJF-3A	A5L-14	.196	.116	28,600	18,900
16	1/2	.770 .735	.600	.4995 .4990	.4995 .4985	.4930 .4880	.095	.188 .178	.030 .020	3/64 X 37°	.5000-20 UNJF-3A	A5L-16	.236	.139	37,300	25,600

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

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



VIEW A

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

GENERAL NOTES:
1. Concentricity: "A" diameter to "D" diameter within .010 FIM.
2. Dimensions are in inches and to be met after finish.
④ 3. Surface texture per ASME 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 HSTR112 for oversize replacement.
④ 9 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 Pin Part Number
④ **EXAMPLES:** HSTR12 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: HSTR12NKJ( )-( ) = 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.

HSTR12NKK( )-( ) = 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.

HSTR12NKL( )-( ) = 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.

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

DRAWN BY	DATE	TITLE
F.CARINGELLA	2012-10-01	HI-LITE™ PIN, ASTER™ RECESS PROTRUDING TENSION HEAD TITANIUM 1/16 GRIP VARIATION
APPROVED	DATE	
C REITZ	2016-03-29	
REVISION	DATE	DRAWING NUMBER
④	F.CARINGELLA 2017-11-28	**HSTR12** 1 OF 1

HSTR12