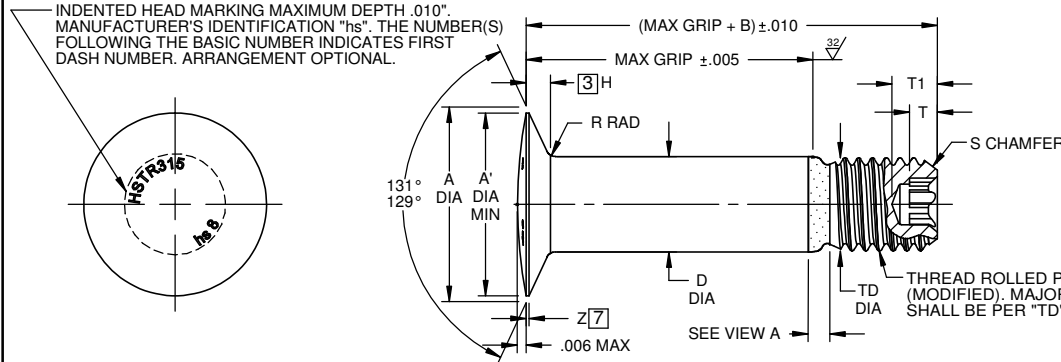
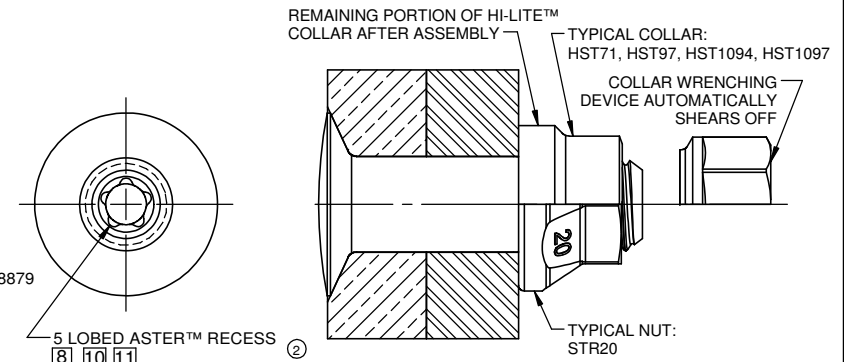


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HI-LITE™ PIN WITH ASTER™ RECESS

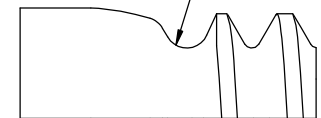


RECOMMENDED COLLAR OR NUT FOR ASSEMBLY

| FIRST DASH NO. | PIN NOM DIA | A DIA | A' DIA MIN | B REF | D DIA | | TD DIA | F REF | 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 | 5/32 | .3393 .3308 | .305 | .280 | .1635 .1630 | .1635 .1625 | .1595 .1570 | .004 | .0410 .0390 | .025 .015 | .012 | 1/32 X 37° | .1640-32 UNJC-3A | A5L-05 | .118 | .072 | 4,010 | 1,650 |
| 6 | 3/16 | .3911 .3825 | .332 | .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 | .4468 .4382 | .387 | .305 | .2182 .2177 | .2182 .2172 | .2100 .2070 | .005 | .0535 .0516 | .030 .020 | .015 | 1/32 X 37° | .2160-28 UNJF-3A | A5L-07 | .117 | .069 | 7,194 | 2,600 |
| 8 | 1/4 | .5111 .5026 | .451 | .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 | .6037 .5951 | .544 | .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 | .7090 .7005 | .649 | .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 | .8526 .8419 | .780 | .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 | .9576 .9468 | .880 | .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.

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



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

HSTR315

| | | |
|---|------------------------------------|--|
| "HI-LITE", "HSTR", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION. ASTER™ IS A TRADEMARK OF LISI AEROSPACE. | | |
| DRAWN BY F.CARINGELLA | DATE 2016-04-14 | TITLE HI-LITE™ PIN, ASTER™ RECESS 130° FLUSH CROWN SHEAR HEAD TITANIUM 1/16 GRIP VARIATION |
| APPROVED C.REITZ | DATE 2016-04-14 | |
| REVISION 2 | DATE F.CARINGELLA 2017-11-28 | DRAWING NUMBER HSTR315 |

- 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 Curved or flat edge manufacturer's option.
 - 8 US patent 6632057; other US & foreign patents granted and pending property of LISI AEROSPACE.
 - 9 Use HSTR415 for oversize replacement.
 - 10 Broach petals removed.
 - 11 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). ②

FINISH: HSTR315NKJ()-() = 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.

HSTR315NKK()-() = 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.

HSTR315NKL()-() = 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
 ② **EXAMPLES:** HSTR315 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

HSTR315

DRAWING NUMBER

HSTR315

2 OF 2