

1																			7																		
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	NOTE: USE HSTR111()6-()																																				
6	7/32	.3303 .3253	.299	.300	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0470 .0450	.030 .020	.015	1/32 X 37°	.1900-32 UNJF-3A	A5L-06	.116	.069	7,100	2,000																			
7	NOTE: USE HSTR111()8-()																																				
8	9/32	.4260 .4210	.395	.330	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0610 .0590	.030 .020	.015	1/32 X 37°	.2500-28 UNJF-3A	A5L-08	.118	.069	11,800	3,700																			
10	11/32	.5051 .5001	.474	.390	.3432 .3427	.3432 .3422	.3060 .3020	.007	.0680 .0660	.040 .030	.015	3/64 X 37°	.3125-24 UNJF-3A	A5L-10	.127	.070	17,600	5,000																			
12	13/32	.5916 .5866	.560	.430	.4057 .4052	.4057 .4047	.3680 .3640	.008	.0780 .0760	.040 .030	.015	3/64 X 37°	.3750-24 UNJF-3A	A5L-12	.147	.087	24,600	7,200																			
14	15/32	.6992 .6932	.651	.495	.4682 .4677	.4682 .4672	.4310 .4260	.009	.0970 .0945	.050 .040	.022	3/64 X 37°	.4375-20 UNJF-3A	A5L-14	.196	.116	32,700	10,000																			
16	17/32	.7852 .7792	.737	.535	.5307 .5302	.5307 .5297	.4930 .4880	.010	.1070 .1045	.050 .040	.022	3/64 X 37°	.5000-20 UNJF-3A	A5L-16	.236	.139	42,000	13,200																			

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



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

HSTR411

"HI-LITE", "HSTR", AND "HI-KOTE" ARE TRADEMARKS OF HI-SHEAR CORPORATION. ASTER™ IS A TRADEMARK OF LISI AEROSPACE.		
DRAWN BY F.CARINGELLA	DATE 2016-07-07	TITLE HI-LITE™ PIN, ASTER™ RECESS 100° FLUSH SHEAR HEAD TITANIUM 1/16 GRIP VARIATION, 1/32 OVERSIZE
APPROVED C.REITZ	DATE 2016-07-07	
REVISION 2	DATE F.CARINGELLA 2017-11-27	DRAWING NUMBER HSTR411

- 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 Oversize replacement for HSTR111.
 - 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 for sizes up to 3/4).

FINISH: HSTR411NKJ()-() = 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.

HSTR411NKK()-() = 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.

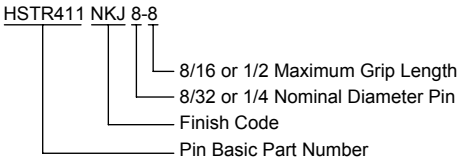
HSTR411NKL()-() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

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 HSTR411 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER

② **EXAMPLES:** PIN PART NUMBER



HSTR411

DRAWING NUMBER

HSTR411

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