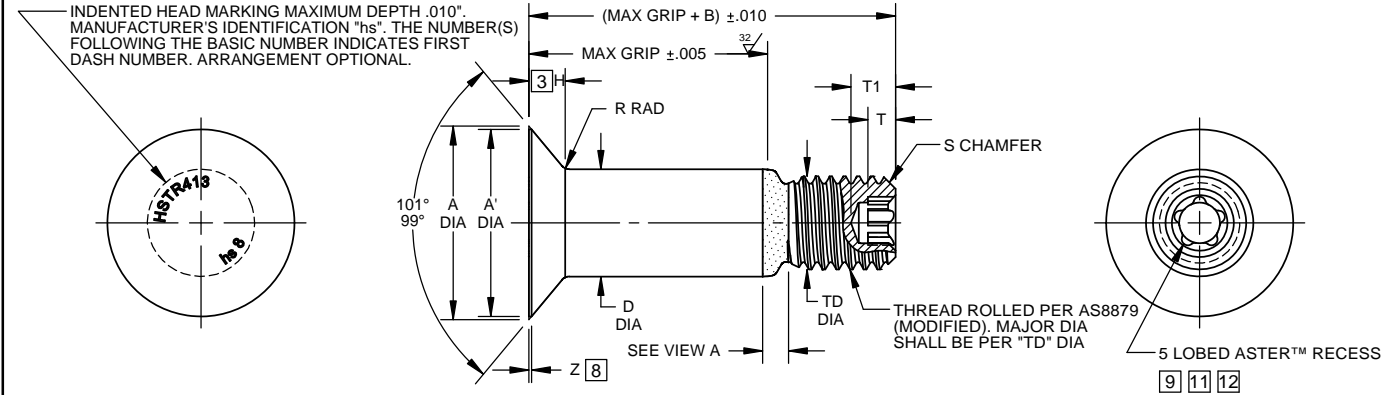
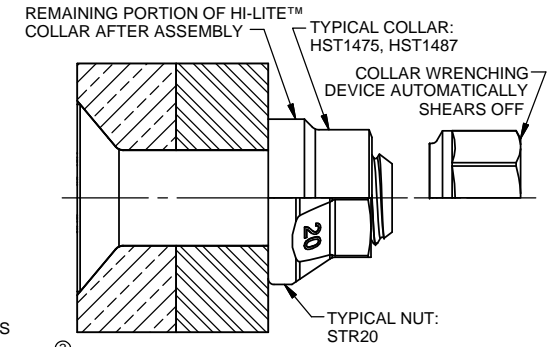


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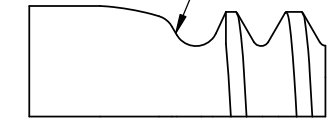
HI-LITE™ PIN WITH ASTER™ RECESS



RECOMMENDED COLLAR OR NUT FOR ASSEMBLY

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

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



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

FIRST DASH NO.	PIN NOM DIA	A DIA	A' DIA MIN	B REF	D DIA		TD DIA	F	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 HSTR113()6(-)																	
6	7/32	.3813 .3765	.350	.300	.2182 .2177	.2182 .2172	.1840 .1810	.005	.0684 .0664	.030 .020	.015	1/32 X 37°	.1900-32 UNJF-3A	A5L-06	.116	.069	7,100	3,180
7	NOTE: USE HSTR13()8(-)																	
8	9/32	.5066 .5018	.475	.330	.2807 .2802	.2807 .2797	.2440 .2410	.006	.0948 .0928	.030 .020	.015	1/32 X 37°	.2500-28 UNJF-3A	A5L-08	.118	.069	11,800	5,820
10	11/32	.6335 .6287	.602	.390	.3432 .3427	.3432 .3422	.3060 .3020	.007	.1218 .1198	.040 .030	.015	3/64 X 37°	.3125-24 UNJF-3A	A5L-10	.127	.070	17,600	9,200
12	13/32	.7604 .7556	.729	.430	.4057 .4052	.4057 .4047	.3680 .3640	.008	.1488 .1468	.040 .030	.015	3/64 X 37°	.3750-24 UNJF-3A	A5L-12	.147	.087	24,600	14,000
14	15/32	.8884 .8812	.840	.510	.4682 .4677	.4682 .4672	.4310 .4260	.009	.1763 .1733	.050 .040	.022	3/64 X 37°	.4375-20 UNJF-3A	A5L-14	.196	.116	32,700	18,900
16	17/32	1.0139 1.0068	.969	.610	.5307 .5302	.5307 .5297	.4930 .4880	.010	.2027 .1997	.050 .040	.022	3/64 X 37°	.5000-20 UNJF-3A	A5L-16	.236	.139	42,000	25,600

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

DRAWN BY F.CARINGELLA	DATE 2014-11-03	TITLE HI-LITE™ PIN, ASTER™ RECESS
APPROVED C.REITZ	DATE 2014-11-03	100° FLUSH MS24694 TENSION HEAD TITANIUM
REVISION 3	DATE M.BEARD 2017-11-28	1/16 GRIP VARIATION, 1/32 OVERSIZE
		DRAWING NUMBER HSTR413

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 5. Surface texture per ASME B46.1.
6. Hole preparation per NAS618.
7. 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. Oversize replacement for HSTR113.
11. Broach petals removed.
- ⑤ 12. 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: HSTR413NKJ()-() = 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.

HSTR413NKK()-() = 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.

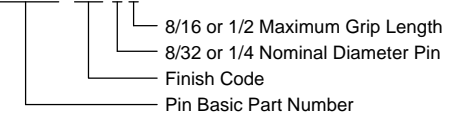
HSTR413NKL()-() = HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on threads only with color silver on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.

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 HSTR413 oversize pin replaces.
 Second dash number indicates maximum grip in 1/16ths. See Finish note for explanation of code letters.

HOW TO ORDER Pin Part Number

③ **EXAMPLES:** HSTR413 NKJ 8-8



HSTR413

DRAWING NUMBER

HSTR413

2 OF 2