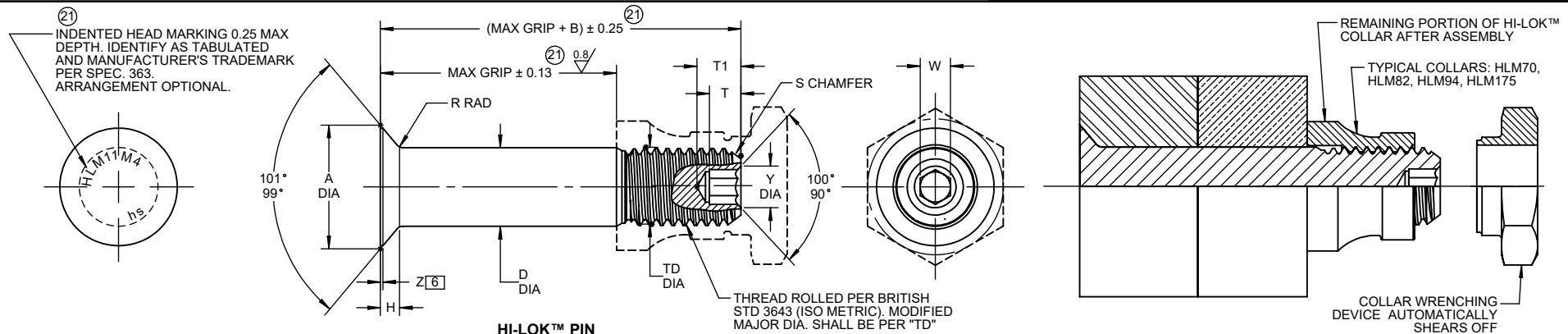




HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	HEAD MARKING	A DIA	B REF	D DIA		TD DIA	F REF	H	R RAD	Z MAX	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					WITHOUT COATING	AFTER COATING								W HEX	T DEPTH MIN.	T1 DEPTH MAX.	Y DIA		
04	4	HLM11M4	6.49 6.35	8.35	3.990 3.978	3.990 3.965	3.91 3.86	0.11	1.05 0.99	0.65 0.40	0.25	0.8 x 37°	M4 x 0.7-4h	1.64 1.61	1.80	2.95	2.30 1.90	16400	6200
05	5	HLM11M5	7.85 7.71	8.65	4.990 4.978	4.990 4.965	4.90 4.84	0.13	1.20 1.14	0.75 0.50	0.38	0.8 x 37°	M5 x 0.8-4h	2.05 2.01	2.00	3.05	3.05 2.60	25700	9300
06	6	HLM11M6	9.68 9.54	10.70	5.990 5.978	5.990 5.965	5.88 5.81	0.16	1.55 1.49	0.75 0.50	0.38	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.25	3.40	3.60 3.10	37000	14700
08	8	HLM11M8 x 1	12.73 12.59	12.95	7.987 7.972	7.987 7.962	7.88 7.80	0.18	1.99 1.93	1.00 0.75	0.38	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	2.80	4.15	4.60 4.05	65800	24400
10	10	HLM11M10 x 1	15.68 15.54	15.20	9.987 9.972	9.987 9.962	9.88 9.80	0.21	2.39 2.33	1.00 0.75	0.38	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	3.80	5.35	5.55 5.00	102900	37800
12	12	HLM11M12 x 1.25	18.42 18.28	18.15	11.984 11.966	11.984 11.959	11.87 11.76	0.23	2.70 2.64	1.25 1.00	0.56	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	4.55	6.30	6.45 5.90	148100	52000

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

- GENERAL NOTES:**
- Head edge out of roundness shall not exceed "F".
 - Concentricity: Conical surface of head to "D" diameter within 0.08 FIM.
 - Dimensions are in millimeters and to be met after finish.
 - Surface texture per ISO/R468.
 - "H" is dimensioned from maximum "D" diameter.
 - Curved or flat edge manufacturer's option.
 - Use HLM311 for oversize replacement.
 - After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating will be replaced by REACH compliant HI-KOTE™ 1 NC aluminum pigmented coating per Hi-Shear Spec. 294 on fasteners coated in European Union.

MATERIAL: 6AL-4V titanium alloy per AMS4928 or AMS4967 for all sizes.
 6AL-6V-2Sn titanium alloy per AMS4971 is acceptable for -10 and larger size.

HEAT TREAT: 655 MPa shear minimum.

FINISH: HLM11-()-() = Surface coating per Hi-Shear Spec. 306, Type I, color blue-violet (equivalent to LN9368 Blatt 4), and cetyl alcohol lube per Hi-Shear Spec. 305.

[8] HLM11AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ Product Specification M342.

CODE: First dash number indicates nominal diameter in 1 mm.
 Second dash number indicates maximum grip in 1 mm.
 See Finish note for explanation of code letters.

**HOW TO ORDER
 EXAMPLE:**

Pin Part Number
 HLM11AP04-8
 8 mm Maximum Grip Length
 4 mm Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY J.F. OBISPO	DATE 2015-02-09	TITLE HI-LOK™ PIN (METRIC SERIES) 100° FLUSH SHEAR HEAD TITANIUM 1mm GRIP VARIATION
APPROVED R. TING	DATE 1970-04-20	
REVISION (21)	DATE K. MURKER 2019-12-04	DRAWING NUMBER HLM11