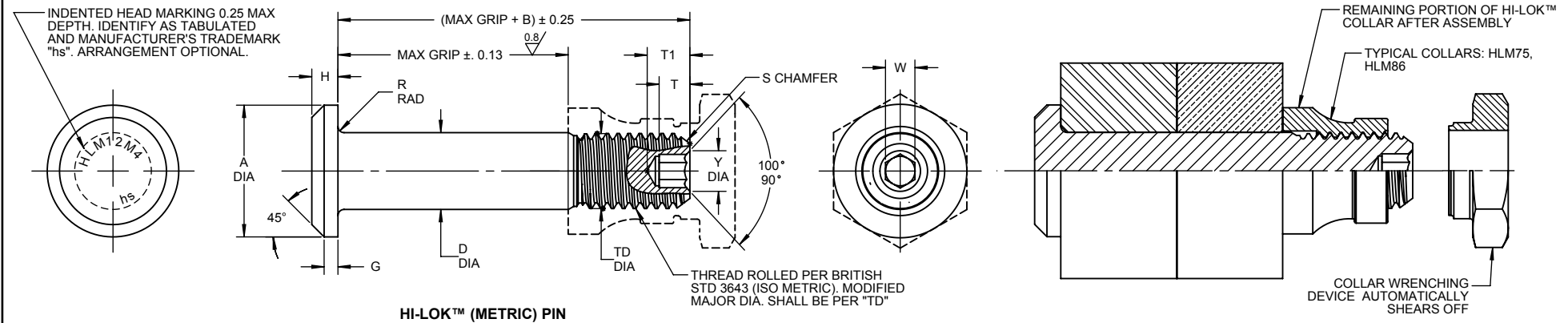


18



HI-LOK™ (METRIC) PIN

HI-LOK™ (METRIC) PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	PIN NOM DIA	HEAD MARKING	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	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	HLM12M4	8.15 7.75	8.35	3.990 3.978	3.990 3.965	3.91 3.86	0.9	1.60 1.40	0.65 0.40	0.8 x 37°	M4 x 0.7-4h	1.64 1.61	1.80	2.95	2.30 1.90	16400	9800
05	5	HLM12M5	9.75 9.25	8.65	4.990 4.978	4.990 4.965	4.90 4.84	1.0	1.90 1.65	0.65 0.40	0.8 x 37°	M5 x 0.8-4h	2.05 2.01	2.00	3.05	3.05 2.60	25700	15600
06	6	HLM12M6	10.90 10.40	10.70	5.990 5.978	5.990 5.965	5.88 5.81	1.3	2.30 2.05	0.65 0.40	0.8 x 37°	M6 x 1.0-4h	2.46 2.40	2.25	3.40	3.60 3.10	37000	22200
08	8	HLM12M8 X 1	12.85 12.25	12.95	7.987 7.972	7.987 7.962	7.88 7.80	1.6	3.05 2.80	0.75 0.50	1.2 x 37°	M8 x 1.0-4h	3.29 3.22	2.80	4.15	4.60 4.05	65800	42000
10	10	HLM12M10 X 1	16.20 15.40	15.20	9.987 9.972	9.987 9.962	9.88 9.80	1.9	3.75 3.50	0.75 0.50	1.2 x 37°	M10 x 1.0-4h	4.11 4.02	3.80	5.35	5.55 5.00	102900	68000
12	12	HLM12M12 X 1.25	18.80 18.00	18.15	11.984 11.966	11.984 11.959	11.87 11.76	2.3	4.45 4.20	0.75 0.50	1.2 x 37°	M12 x 1.25-4h	4.90 4.81	4.55	6.30	6.45 5.90	148100	100200

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within 0.25 FIM.
 2. Dimensions are in millimeters and to be met after finish.
 3. Surface texture per ISO/R468.
 4. Use HLM312 for oversize replacement.
 5. After February, 21st of 2015, HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294 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:** HLM12-()-() = 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.
- 5 HLM12AP()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.
- 5 HLM12AT()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294.
- 5 HLM12AZ()-() = HI-KOTE™ 1 aluminum pigmented coating per Hi-Shear Spec. 294, with color black on thread end, 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

18 **EXAMPLE:** Pin Part Number
HLM12AP8-8

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 VAN	DATE 1970-04-17	TITLE HI-LOK™ PIN (METRIC SERIES) PROTRUDING TENSION HEAD TITANIUM 1 mm GRIP VARIATION
J.F.OBISPO	2014-09-11	
APPROVED R. TING	DATE 1970-04-20	DRAWING NUMBER HLM12
REVISION 18	DATE F. CARINGELLA 2017-10-12	