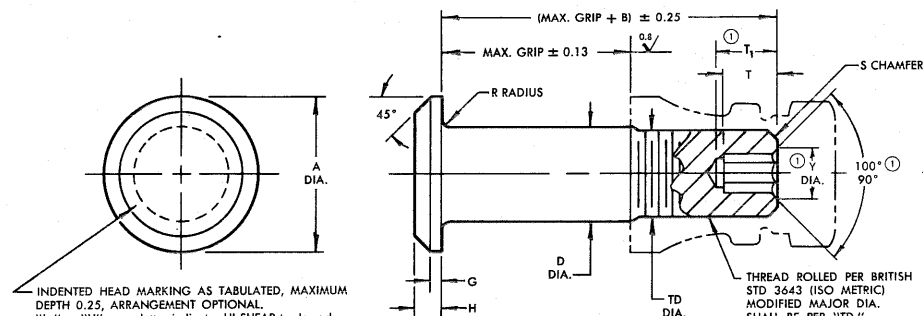


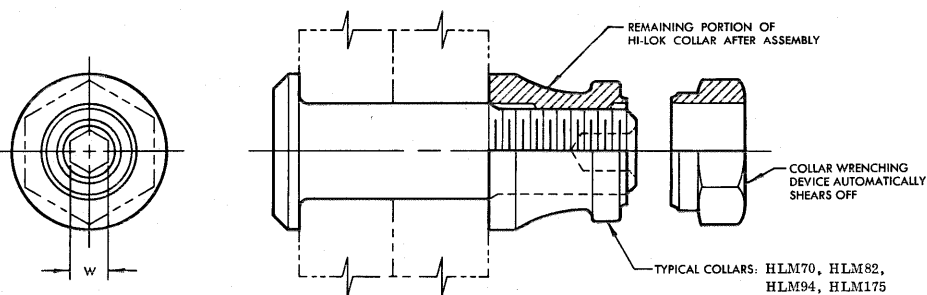
STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

① HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee)
 AIRCRAFT FASTENERS (Forged Parts) Ltd., U.K. (Licensee)
 Division of Hi-Shear Industries Inc., U.S.A. (Licensee)
 VOI-SHAK, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code I.D. No. 92215
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 TOKYO SCREW COMPANY, Japan (Licensee—Japan)
 WEST COAST AEROSPACE INC., U.S.A. (Licensee—Oversize Pins & Steel Collars)
 U.S. Federal Code I.D. No. 60516



HI-LOK PIN (METRIC)



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

FIRST DASH NO.	HEAD MARKING	NOM. DIA.	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
												* W HEX.	T HEX DEPTH MIN.	T ₁ DEPTH MAX.	Y DIA.		
-04	HLM18M4	4	6.65 6.25	8.35	3.990 3.965	3.91 3.86	0.6	1.20 0.95	0.65 0.40	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	1.80	2.95	2.30 1.90	16400	7800
-05	HLM18M5	5	8.15 7.65	8.65	4.990 4.965	4.90 4.84	0.8	1.40 1.15	0.65 0.40	0.8 x 45°	M5 x 0.8-4h	2.05 2.01	2.00	3.05	3.05 2.60	25700	11800
-06	HLM18M6	6	10.20 9.70	10.70	5.990 5.965	5.88 5.81	0.9	1.75 1.50	0.65 0.40	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.25	3.40	3.60 3.10	37000	18200
-08	HLM18M8 x 1	8	12.85 12.25	12.95	7.987 7.962	7.88 7.80	1.0	2.20 1.95	0.75 0.50	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	2.80	4.15	4.60 4.05	65800	31600
-10	HLM18M10 x 1	10	16.20 15.40	15.20	9.987 9.962	9.88 9.80	1.3	2.65 2.40	0.75 0.50	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	3.80	5.35	5.55 5.00	102900	48900
-12	HLM18M12 x 1.25	12	18.80 18.00	18.15	11.984 11.969	11.87 11.76	1.5	2.95 2.70	0.75 0.50	1.2 x 45°	M12 x 1.25-4h	4.90 4.81	4.55	6.30	6.45 5.90	148100	66700

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

- ① GENERAL NOTES:
1. Concentricity: "A" to "D" diameter within 0.25 FIR.
 2. Dimensions to be met after finish.
 3. Surface texture per ISO/R468.
 4. Use HLM118 for oversize replacement.
 5. Parts made prior to this revision are OK to use.

MATERIAL: Alloy steel per Spec. MIL-S-5000, MIL-S-5626 or MIL-S-6049.

HEAT TREAT: 655 N/mm² shear minimum per Spec. MIL-H-6875.

FINISH: HLM18-()-() = Cadmium plate per Spec. QQ-P-416, Type I, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLM18PB-()-() = Cadmium plate per Spec. QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lok Product Specification No. 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

EXAMPLES:

Pin Part Number Only
 HLM18-04-8
 — 8 mm Maximum Grip Length
 — 4 mm Nominal Diameter Pin
 — Pin Part Number

Pin and Collar Assembly Part Number Combination
 HLM1870-04-8
 — Size and Grip Length, See Above Example
 — Collar Part Number
 — Pin Part Number

* INCH STANDARD HEX.

U.S. patents 3,390,906; and foreign patents. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.	
DRAWN VAN 12-14-72	DATE 12-14-72
APPROVED R.E.P. 12-19-72	DATE 12-19-72
REVISION ①	DATE D. P. S. 6-10-83
hi-lok® PIN (METRIC SERIES) PROTRUDING SHEAR HEAD ALLOY STEEL 1 mm GRIP VARIATION DRAWING NUMBER HLM18	