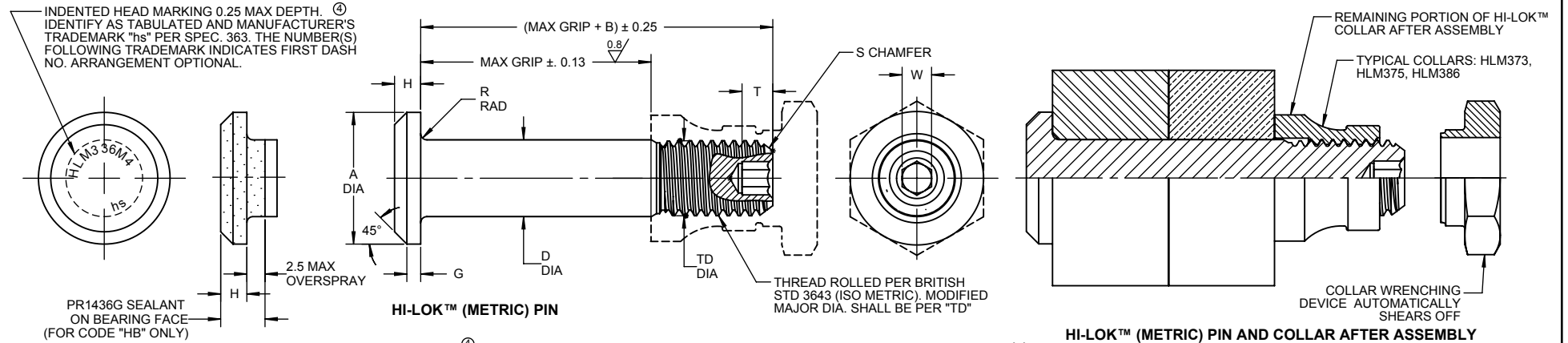


④



FIRST DASH NO.	HEAD MARKING	PIN 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
					HLM336	HLM336HB HLM336TB HLM336HK							* W HEX	T DEPTH		
04	HLM336M4	4.5	8.65 8.25	9.0	4.490 4.478	4.490 4.465	3.91 3.86	0.9	1.60 1.40	0.65 0.40	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	2.05 1.65	27400	13600
05	HLM336M5	5.5	10.25 9.75	9.4	5.490 5.478	5.490 5.465	4.90 4.84	1.0	1.90 1.65	0.65 0.40	0.8 x 45°	M5 x 0.8-4h	2.05 2.01	2.55 2.00	40900	22000
06	HLM336M6	6.5	11.40 10.90	11.7	6.490 6.478	6.490 6.465	5.88 5.81	1.3	2.30 2.05	0.65 0.40	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	57100	31100
08	HLM336M8 X 1	8.5	13.35 12.75	14.0	8.487 8.472	8.487 8.462	7.88 7.80	1.6	3.05 2.80	0.75 0.50	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	97600	58000
10	HLM336M10 X 1	10.5	16.70 15.90	16.2	10.487 10.472	10.487 10.462	9.88 9.80	1.9	3.75 3.50	0.75 0.50	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	148900	90800
12	HLM336M12 X 1.25	12.5	19.30 18.50	19.4	12.484 12.466	12.484 12.459	11.87 11.76	2.3	4.45 4.20	0.75 0.50	1.2 x 45°	M12 x 1.25-4h	4.90 4.81	5.10 4.55	211100	130700

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

GENERAL NOTES: 1. Concentricity: Head to "D" diameter within 0.25 FIR.
 ④ 2. Dimensions are in millimeters and to be met after finish.
 3. Surface texture per ISO/R468.
 4. Use HLM636 for oversize replacement.

MATERIAL: PH13-8Mo stainless steel per Spec. AMS5629

HEAT TREAT: 860 MPa shear minimum.

FINISH: ④ HLM336()-() = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLM336TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLM336HB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and apply precoat No. PR1436G sealant (.051-.127 mm thick) plus cetyl alcohol lube per Hi-Shear Spec. 305.
 ④ HLM336HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LOK™ Product Specification M342.

CODE: First dash number indicates nominal diameter in 1 mm which HLM336 oversize pin replaces.
 Second dash number indicates maximum grip in 1 mm.
 See Finish note for explanation of code letters.

HOW TO ORDER
 ④ **EXAMPLE:**

Pin Part Number
 HLM336TB8-8
 8 mm Maximum Grip Length
 Replaces 4 mm Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number
 Pin and Collar Assembly Part Number combination
 HLM336373-04-8
 Size and Grip Length, See Above Example
 Collar Part Number
 Pin Part Number

* Inch standard hex.
 ** The Double Shear values shown are based on cross sectional area for nominal diameter pin.

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY D.P.S.	DATE 1977-05-18	TITLE HI-LOK™ PIN (METRIC SERIES) PROTRUDING TENSION HEAD PH13-8Mo STAINLESS STEEL 1 mm GRIP VARIATION 0.5 mm OVERSIZE
APPROVED R. TING	DATE 1977-05-19	
REVISION ④	DATE F. CARINGELLA 2017-10-02	DRAWING NUMBER HLM336