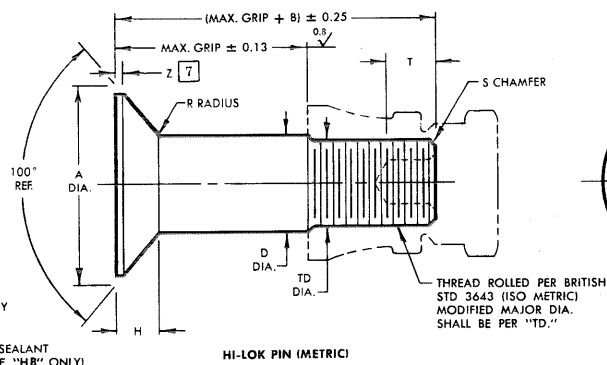
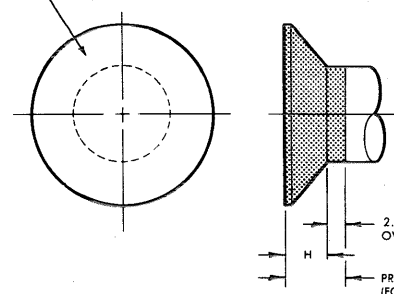
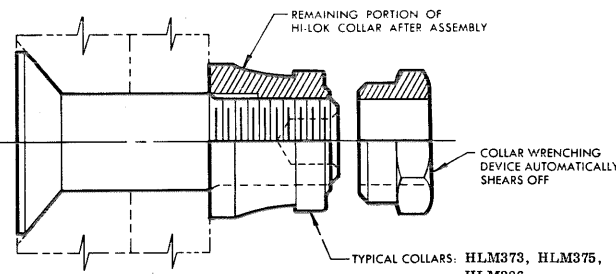
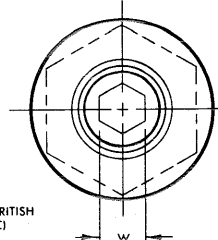


INDENTED HEAD MARKING AS TABULATED, MAXIMUM DEPTH 0.25, ARRANGEMENT OPTIONAL.
"hs" indicates HI-SHEAR trademark.
"VS" indicates VOI-SHAN trademark.
"SPS" indicates STANDARD PRESSED STEEL trademark.



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.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET		* * DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					HLM337	HLM337TB OR HLM337HB								W * HEX.	T DEPTH		
-04	HLM337M4	4.5	8.63 8.49	9.0	4.490 4.478	4.490 4.465	3.91 3.86	0.11	1.74 1.68	0.65 0.40	0.25	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	2.05 1.65	27400	13600
-05	HLM337M5	5.5	10.63 10.49	9.4	5.490 5.478	5.490 5.465	4.90 4.84	0.13	2.16 2.10	0.75 0.50	0.38	0.8 x 45°	M5 x 0.8-4h	2.05 2.01	2.55 2.00	40900	22000
-06	HLM337M6	6.5	12.63 12.49	11.7	6.490 6.478	6.490 6.465	5.88 5.81	0.16	2.58 2.52	0.75 0.50	0.38	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	57100	31100
-08	HLM337M8 x 1	8.5	16.63 16.49	14.0	8.487 8.472	8.487 8.462	7.88 7.80	0.18	3.42 3.36	1.00 0.75	0.38	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	97600	58000
-10	HLM337M10 x 1	10.5	20.63 20.49	16.2	10.487 10.472	10.487 10.462	9.88 9.80	0.21	4.26 4.20	1.00 0.75	0.38	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	148900	90800
-12	HLM337M12 x 1.25	12.5	24.63 24.49	19.4	12.484 12.466	12.484 12.459	11.87 11.76	0.23	5.10 5.04	1.25 1.00	0.56	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. Head edge out of roundness shall not exceed "F,"
2. Concentricity: Conical surface of head to "D" diameter within 0.13 FIR.
3. "H" is dimensioned from maximum "D" diameter.
4. Dimensions to be met after finish.
5. Surface texture per ISO/R468.
6. Use HLM637 for oversize replacement.
7. Curved or flat edge manufacturer's option.

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

HEAT TREAT: 860 MPa shear minimum.

FINISH: HLM337-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM337TB-()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM337HB-()-() = 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.

SPECIFICATION: Hi-Lok Product Specification No. M342.

CODE: First dash number indicates nominal diameter in 1 mm which HLM337 oversize pin replaces.
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

HLM337-04-8

8 mm Maximum Grip Length

Replaces 4 mm Nominal Diameter Pin

Pin Part Number

Pin and Collar Assembly Part Number Combination

HLM337373-04-8

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.

U.S. patents 2,882,773; 2,927,491; 2,940,495; 3,027,789; 3,138,987; design patent 191,883; other U.S. and Foreign patents granted and pending; property of Hi-Shear Corporation. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.	
DRAWN DATE D.P.S. 5-18-77	hi-lok® PIN (METRIC SERIES)
APPROVED DATE R.L.P. 5-19-77	100° FLUSH TENSION HEAD PH13-8Mo STAINLESS STEEL 1 mm GRIP VARIATION 0.5 mm OVERSIZE
REVISION DATE 3 D.P.S. 12-13-78	DRAWING NUMBER HLM 337