



HI-LOK PIN AND COLLAR AFTER ASSEMBLY

HI-LOK PIN (METRIC)

SEE COLLAR STANDARDS FOR
COLLAR STRENGTHS. LOWER STRENGTH
COLLAR STRENGTH DETERMINES
SYSTEM STRENGTH.

FIRST DASH NO.	HEAD MARKING	NOA. DIA.	A DIA.	B REF.	D DIA. WITHOUT FILM DIA.	D DIA. WITH FILM DIA.	TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET		DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
														W HEX	T DEPTH		
-04	HLM341M4	4.5	6.99	9.0	4.478	4.465	3.91	0.11	1.05	0.65	0.25	0.8 x 45°	M4 x 0.7-4h	1.64	2.05	20800	6200
-05	HLM341M5	5.5	8.35	9.4	5.490	5.480	4.90	0.13	1.20	0.75	0.38	0.8 x 45°	M5 x 0.8-4h	2.06	2.55	31100	9300
-06	HLM341M6	6.5	10.18	11.7	6.490	6.485	5.88	0.16	1.55	0.75	0.38	0.8 x 45°	M6 x 1.0-4h	2.46	2.80	43500	14700
-08	HLM341M8 x 1	8.5	13.23	14.0	8.487	8.487	7.88	0.18	1.99	1.00	0.38	1.2 x 45°	M8 x 1.0-4h	3.29	3.35	74300	24400
-10	HLM341M10 x 1	10.5	16.18	16.2	10.487	10.487	9.88	0.21	2.39	1.00	0.38	1.2 x 45°	M10 x 1.0-4h	4.11	4.35	113400	37800
-12	HLM341M12 x 1.25	12.5	18.92	19.4	12.484	12.484	11.87	0.23	2.70	1.25	0.56	1.2 x 45°	M12 x 1.25-4h	4.90	5.10	160800	52000

- GENERAL NOTES:
- Head edge out of roundness shall not exceed "F."
 - Concentricity: Conical surface of head to "D" diameter within 0.13 FIR.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ISO/DR221.
 - Curved or flat edge manufacturer's option.
 - Use HLM641 for oversize replacement.

MATERIAL: A-286 high temperature alloy per Spec. AMS5737 or AMS5731.

HEAT TREAT: 655 N/mm² shear minimum at room temperature.

FINISH: HLM341(-) (-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM341TF(-) (-) = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.

SPECIFICATION: Hi-Lok Product Specification No. M342.

CODE: First dash number indicates nominal diameter in 1 mm which HLM341 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
HLM341-04-8
Replaces 8 mm Maximum Grip Length
Replaces 4 mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HLM341370-04-8

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. patent: 2,882,773; 2,927,491; 2,945,495; 3,027,789; 3,138,987; design patent 191,883; other U.S. and Foreign patents granted and pending.
Hi-Shear Corporation, "Hi-Lok" and "Ht" are Registered Trademarks of Hi-Shear Corporation.

DATE	1-25-77
APPROVED	<i>[Signature]</i>
REVISION	
DRAWING NUMBER	HLM341