

STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

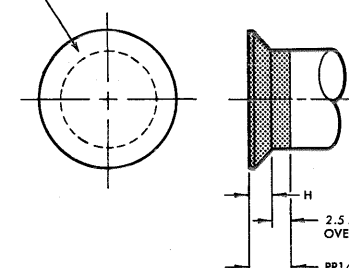
LI-SI AEROSPACE - Please refer to Central Documentation Website to check validity

Division of Hi-Shear Industries Inc.
VOI-SHAN, Division of VSI Corp., U.S.A.
SPS TECHNOLOGIES, U.S.A.
LITTON FASTENING SYSTEMS, U.S.A.
Division of Litton Systems, Inc.

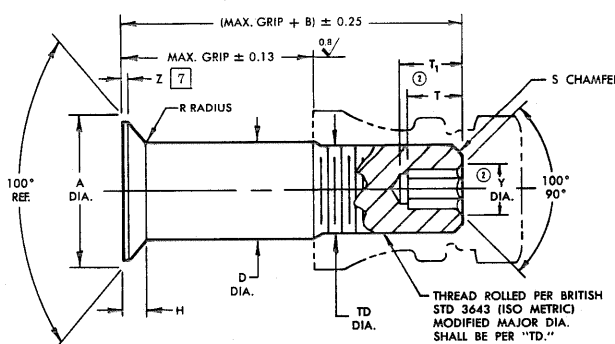
(Licensee) U.S. Federal Code I.D. No. 92215
(Licensee) U.S. Federal Code I.D. No. 56878
(Licensee) U.S. Federal Code I.D. No. 97928

KAMAX-WERKE, Germany (Licensee)
Rudolph Kellerman GmbH & Co.
ST. CHAMOND-GRANAT, S.A. France (Licensee)
TOKYO SCREW COMPANY, Japan (Licensee)

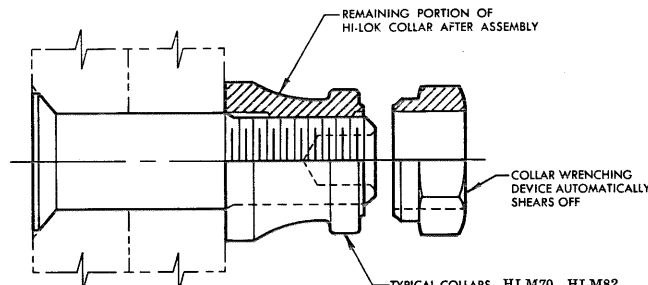
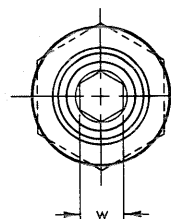
INDENTED HEAD MARKING AS TABULATED, MAXIMUM DEPTH 0.25, ARRANGEMENT OPTIONAL.
"HS" indicates HI-SHEAR trademark.
"VS" indicates VOI-SHAN trademark.
"SPS" indicates STANDARD PRESSED STEEL trademark.



PR1436G SEALANT
(FOR CODE "HB" ONLY)



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
					HLM35	HLM35TB OR HLM35HB								* W HEX.	T HEX DEPTH MIN.	T ₁ DEPTH MAX.	Y DIA.		
-04	HLM35M4	4	6.49 6.35	8.35	3.990 3.978	3.990 3.965	3.91 3.86	0.11	1.05 0.99	0.65 0.40	0.25	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	1.80	2.95	2.30 1.90	21600	8200
-05	HLM35M5	5	7.85 7.71	8.65	4.990 4.978	4.990 4.965	4.90 4.84	0.13	1.20 1.14	0.75 0.50	0.38	0.8 x 45°	M5 x 0.8-4h	2.05 2.01	2.00	3.05	3.05 2.60	33800	12200
-06	HLM35M6	6	9.68 9.54	10.70	5.990 5.978	5.990 5.965	5.88 5.81	0.16	1.55 1.49	0.75 0.50	0.38	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.25	3.40	3.60 3.10	48600	19300
-08	HLM35M8 x 1	8	12.73 12.59	12.95	7.987 7.972	7.987 7.962	7.88 7.80	0.18	1.99 1.93	1.00 0.75	0.38	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	2.80	4.15	4.60 4.05	86500	32000
-10	HLM35M10 x 1	10	15.68 15.54	15.20	9.987 9.972	9.987 9.962	9.88 9.80	0.21	2.39 2.33	1.00 0.75	0.38	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	3.80	5.35	5.55 5.00	135100	49600
-12	HLM35M12 x 1.25	12	18.42 18.28	18.15	11.984 11.966	11.984 11.959	11.87 11.76	0.23	2.70 2.64	1.25 1.00	0.56	1.2 x 45°	M12 x 1.25-4h	4.90 4.81	4.55	6.30	6.45 5.90	194500	68300

* Inch standard hex.

- GENERAL NOTES:
- Head edge out of roundness shall not exceed "F."
 - Concentricity: Conical surface of head to "D" diameter within 0.08 FIR.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ISO/R468.
 - Use HLM35 for oversize replacement.
 - Curved or flat edge manufacturer's option.
 - Parts made prior to this revision are OK to use.

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

HEAT TREAT: 860 MPa shear minimum.

FINISH: HLM35-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM35TB-()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM35HB-()-() = 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.

HOW TO ORDER
EXAMPLES:

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.

Pin Part Number Only
HLM35-04-8
8 mm Maximum Grip Length
4 mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HLM3570-04-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

U.S. patents 2,927,491; 2,940,495; 3,027,789; 3,138,987.
Other U.S. and Foreign patents granted and pending.
"Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.

DRAWN D.P.S.	DATE 9-6-78	hi-Lok® PIN (METRIC SERIES) 100° FLUSH SHEAR HEAD PH13-8Mo STAINLESS STEEL 1 mm GRIP VARIATION
APPROVED R.D.P.	DATE 9-6-78	
REVISION (2)	DATE D.P.S. 5-16-80	
		DRAWING NUMBER HLM35

© 1980, Hi-Shear Corporation

HLM35