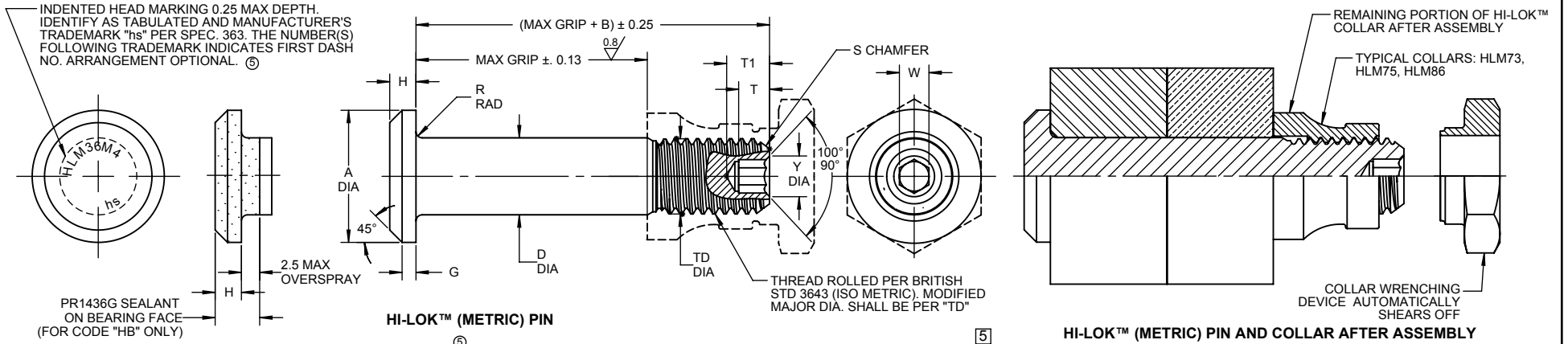




FIRST DASH NO.	HEAD MARKING	PIN NOM DIA	A DIA	B REF	D DIA		TD DIA	G REF	H	R RAD	S CHAMFER REF	THREAD MODIFIED	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					HLM36	HLM36HB HLM36TB HLM36HK							* W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA		
04	HLM36M4	4	8.15 7.75	8.35	3.990 3.978	3.990 3.965	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	1.80	2.95	2.30 1.90	21600	13600
05	HLM36M5	5	9.75 9.25	8.65	4.990 4.978	4.990 4.965	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	2.00	3.05	3.05 2.60	33800	22000
06	HLM36M6	6	10.90 10.40	10.70	5.990 5.978	5.990 5.965	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	2.25	3.40	3.60 3.10	48600	31100
08	HLM36M8 X 1	8	12.85 12.25	12.95	7.987 7.972	7.987 7.962	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	2.80	4.15	4.60 4.05	86500	58000
10	HLM36M10 X 1	10	16.20 15.40	15.20	9.987 9.972	9.987 9.962	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	3.80	5.35	5.55 5.00	135100	90800
12	HLM36M12 X 1.25	12	18.80 18.00	18.15	11.984 11.966	11.984 11.959	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	4.55	6.30	6.45 5.90	194500	130700

* Inch standard hex.

- GENERAL NOTES:**
- Concentricity: Head to "D" diameter within 0.25 FIR.
 - Dimensions are in millimeters and to be met after finish.
 - Surface texture per ISO/R468.
 - Use HLM336 for oversize replacement.
 - 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: ⑤ HLM36()-() = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLM36TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292, and cetyl alcohol lube per Hi-Shear Spec. 305.
 HLM36HB()-() = 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.
 ⑤ HLM36HK()-() = 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.
 Second dash number indicates maximum grip in 1 mm.
 See Finish note for explanation of code letters.

HOW TO ORDER
 ⑤ **EXAMPLE:**

Pin Part Number
 HLM36TB8-8
 8 mm Maximum Grip Length
 4 mm Nominal Diameter Pin
 Finish Code
 Pin Basic Part Number
 Pin and Collar Assembly Part Number combination
 HLM36373-04-8
 Size and Grip Length, See Above Example
 Collar Part Number
 Pin Part Number

"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
APPROVED R. TING	DATE 1977-05-19	
REVISION ⑤	DATE F. CARINGELLA 2017-10-02	DRAWING NUMBER HLM36