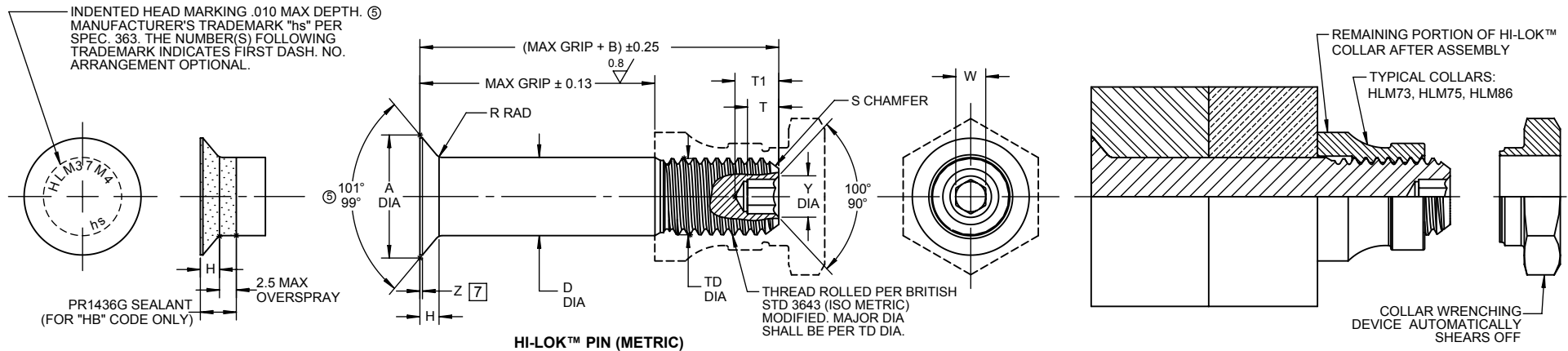




HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

FIRST DASH NO.	HEAD MARKING	PIN 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
					WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE								* W HEX	T DEPTH MIN	T1 DEPTH MAX	Y DIA		
4	HLM37M4	4	8.13 7.99	8.35	3.990 3.978	3.990 3.965	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	1.80	2.95	1.90	21600	13600
5	HLM37M5	5	10.13 9.99	8.65	4.990 4.978	4.990 4.965	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	2.00	3.05	2.60	33800	22000
6	HLM37M6	6	12.13 11.99	10.70	5.990 5.978	5.990 5.965	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	2.25	3.40	3.60 3.10	48600	31100
8	HLM37M8 x 1	8	16.13 15.99	12.95	7.987 7.972	7.987 7.962	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	2.80	4.15	4.60 4.05	86500	58000
10	HLM37M10 x 1	10	20.13 19.99	15.20	9.987 9.972	9.987 9.962	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	3.80	5.35	5.55 6.00	135100	90800
12	HLM41M12 x 1.25	12	24.13 23.99	18.15	11.984 11.966	11.984 11.959	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	4.55	6.30	6.45 5.90	194500	130700

* 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. [8]
 - "H" is dimensioned for maximum "D" diameter.
 - Dimensions are in millimeters, and to be met after finish.
 - Surface texture per ISO/R468.
 - Use HLM337 for oversize replacement.
 - Curved or flat edge manufacturer's option.
 - Parts made prior to this revision are OK to use.

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

HOW TO ORDER

EXAMPLE:

Pin Part Number
HLM37TB8-8
8mm Maximum Grip Length
4mm Nominal Diameter Pin
Finish Code
Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HLM3773-04-8

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) 100° FLUSH TENSION HEAD PH13-8Mo STAINLESS STEEL 1mm GRIP VARIATION
APPROVED R.TING	DATE 1977-05-19	
REVISION 5	DATE F.CARINGELLA 2017-09-21	DRAWING NUMBER HLM37 1 OF 1

SPECIFICATION: HI-LOK™ Product Specification M342.