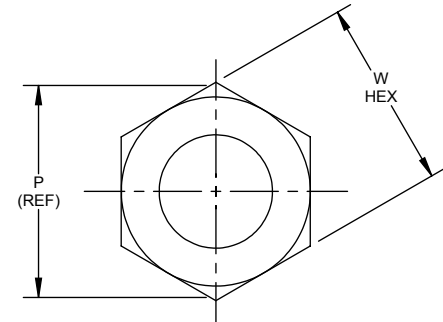
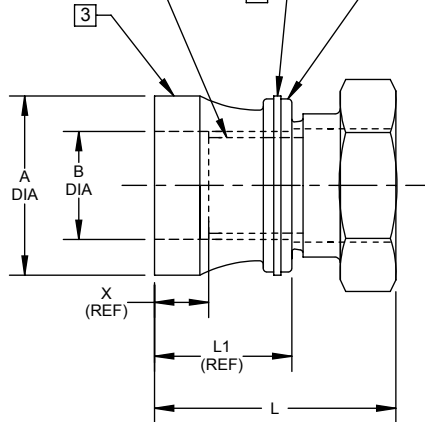


THREAD PER BRITISH
 STD 3643 (ISO METRIC)

"METRIC"
 IDENTIFICATION
 BEAD [4]

THIS AREA PROVIDED WITH A PREVAILING
 TORQUE LOCKING FEATURE



DASH NO. (METRIC)	PIN NOM DIA	THREAD	A DIA	B DIA	L	L1 (REF)	P (REF)	W HEX	X (REF)	TORQUE OFF	
										NEWTON- METER	ULT TNSN STR NEWTONS MINIMUM
04	4.5	M4 x 0.7-4H5H	7.75 7.65	4.75 4.65	12.25 11.75	7.7	8.87	8.00 7.78	3.3	1.7-2.9	5800
05	5.5	M5 x 0.8-4H5H	8.75 8.65	5.75 5.65	12.40 11.90	7.9	11.10	10.00 9.78	3.4	2.8-4.6	7300
06	7	M6 x 1.0-4H5H	11.30 11.20	7.25 7.15	15.70 15.20	10.4	12.12	11.00 10.73	4.5	5.6-9.1	12000
08	9	M8 x 1.0-4H5H	14.20 14.05	9.30 9.15	18.20 17.70	12.2	14.40	13.00 12.73	4.5	14.6-18.1	22200
10	11	M10 x 1.0-4H5H	17.70 17.50	11.30 11.15	20.95 20.45	14.1	15.56	14.00 13.73	4.5	23.7-28.3	33300
12	13	M12 x 1.25-4H5H	21.20 21.00	13.30 13.15	24.55 24.05	16.7	18.90	17.00 16.73	5.3	36.1-43.0	48900

NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution
 minimum after thread lock.

2. Dimensions are in millimeters and apply after finish.

[3] Break sharp edge.

[4] Parts made prior to this revision are OK to use.

MATERIAL: 2024 aluminum alloy per QQ-A-430 or AMS-QQ-A-225/6.

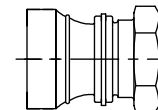
HEAT TREAT: Age to T6 condition per AMS2770.

FINISH: HLM370-() = Anodize, dye color blue, and cetyl alcohol lube
 per Hi-Shear Spec. 305.

SPECIFICATION: HI-LOK™ Product Specification M345.

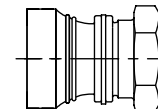
CODE: Dash number indicates nominal thread size in 1mm.

EXAMPLE: HLM370-08 = M8 x 1.0 HI-LOK™ Collar.



VOI-SHAN

1 raised bead indicates
VOI-SHAN identification



STANDARD PRESSED STEEL

2 raised beads indicate **STANDARD**
PRESSED STEEL identification.

"HI-LOK" AND "HL" ARE INTERNATIONAL
 REGISTERED TRADEMARKS OF HI-SHEAR CORPORATION

			TITLE	DRAWING NO.
DATE	BY			
DRAWN	1975-10-15	D.P.S.	HI-LOK™ COLLAR (METRIC SERIES) 2024-T6 ALUMINUM ALLOY 1 mm GRIP VARIATION - SHEAR APPLICATION FOR USE ON 0.5 AND 1 mm OVERSIZE HI-LOK™ PINS	HLM370 1 of 1
APPROVED	1975-12-15	R. TING		
2 REVISION	2017-12-18	K. TRAN		