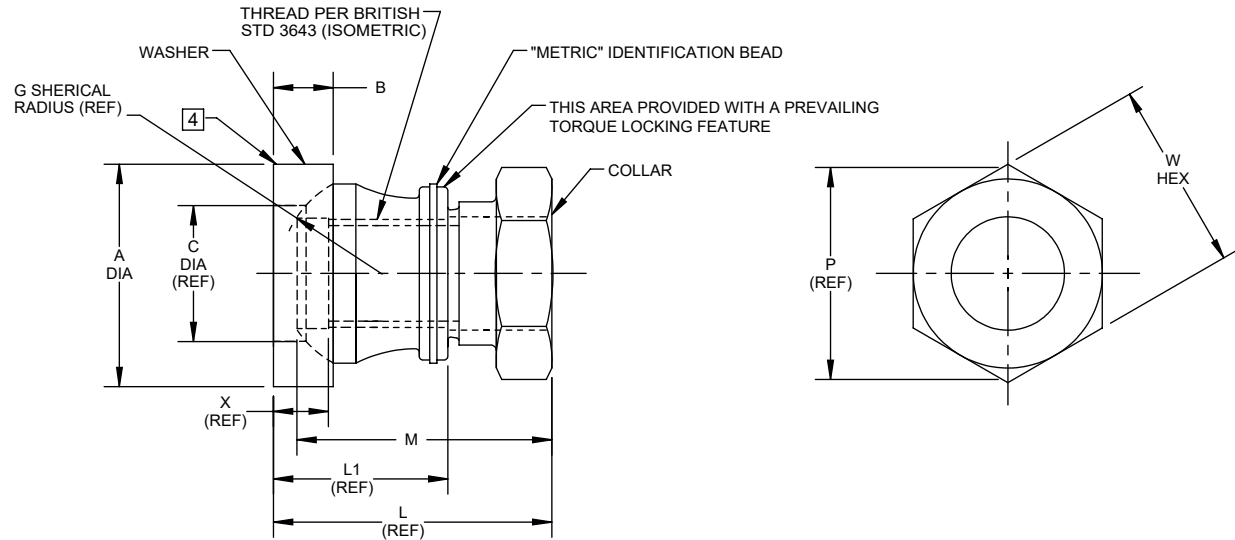




DASH NO. (METRIC)	PIN NOM DIA	THREAD	A DIA	B DIA	C DIA (REF)	G SPHER. RAD (REF)	L (REF)	L1 (REF)	M	P (REF)	W HEX	X (REF)	TORQUE OFF NEWTON-METER	ULT TNSN STR NEWTONS MINIMUM
04	4.5	M4 x 0.7-4H5H	10.90 10.64	2.29 2.03	6.5	5.1	12.20	7.8	11.45 10.95	8.87	8.00 7.78	3.3	2.8-4.0	9,600
05	5.5	M5 x 0.8-4H5H	12.80 12.54	2.67 2.41	8.1	6.7	12.30	8.0	11.55 11.05	11.10	10.00 9.78	3.4	3.9-5.7	12,700
06	7	M6 x 1.0-4H5H	15.75 15.49	3.31 3.05	9.6	8.7	15.35	10.3	14.35 13.85	12.12	11.00 10.73	4.5	9.0-12.5	20,700
08	9	M8 x 1.0-4H5H	19.18 18.92	4.07 3.81	12.0	9.8	17.95	12.1	16.65 16.15	14.40	13.00 12.73	4.5	20.3-26.0	36,900
10	11	M10 x 1.0-4H5H	22.74 22.48	4.58 4.32	14.5	11.4	20.95	14.3	19.30 18.80	15.56	14.00 13.73	4.5	40.6-47.5	62,300
12	13	M12 x 1.25-4H5H	25.53 25.27	5.97 5.71	17.0	13.1	24.10	16.7	22.10 21.60	18.90	17.00 16.73	5.3	67.7-76.3	97,800

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 - Dimensions are in millimeters and apply after finish.
 - For use on sloped surface up to 7° maximum on HI-LOK™ metric standard diameter pins.
 - Break sharp edge
 - Oversize replacement for HLM75.
 - Cetyl Alcohol lube per HI-Shear Spec. 305 may be applied, at manufacturer's option to meet procurement specification requirements

MATERIAL: Collar - Type 303 Se stainless steel per ASTM A 582 and AMS5640.
 Washer - "PBW" and "WU" = 17-4PH stainless steel per AMS5643, or 17-7PH per AMS5528, or PH15-7Mo or AMS5520.
 "PBW" = 4140 or 8740 alloy steel per AMS6349, AMS6382 or AMS6327.

HEAT TREAT: Collar - None.
 Washer - "PBW" and "WU" = Age to H-1025 condition for 17-4PH, age to TH1050 condition for 17-7PH and 15-7Mo per AMS-H-6875.
 "PBWA" = 180,000-200,000 psi tensile per AMS-H-6875.

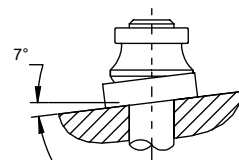
- ④ **FINISH:** Collar - HLM375DU()A = Solid film lube per AS5272, Type I, and cetyl alcohol lube per High-Shear Spec. 305, [6]
 Yellow identification on Body of shear collars MIL-PRF-23377
 HLM375PB()A = Cadmium plate per AMS-QQ-P-416, Type II, Class 2, and cetyl alcohol lube per Hi-Shear Spec. 305
 Washer - HLM375-()PBW = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 HLM375-()PBWA = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.
 HLM375-()WU = Passivate per AMS2700, Method 1, Type 8, Class 1

SPECIFICATION: HI-LOK™ Product Specification M345.

CODE: Dash number indicates nominal thread size in 1mm.
 Code letter "A" following dash number indicates HI-LOK™ collar.
 Code letters "PBW", "PBWA", and "WU" following dash number indicate self-aligning washer.
 See Finish note for explanation of code letters.

EXAMPLE: HLM375DU08AWU = M8 x 1.0 HI-LOK™ Collar and HLM375-08WU self-aligning washer.
 HLM375DU08A = M8 x 1.0 HI-LOK™ Collar with solid film lube.
 HLM375-08AWU = 8 mm size self-aligning washer with passivate finish.

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



DATE	BY	TITLE	DRAWING NO.
DRAWN	1977-07-11	D.P.S.	
APPROVED	1977-07-11	R. TING	
④ REVISION	2021-06-08	B. CHAN	

HI-LOK™ COLLAR (METRIC SERIES)
 SELF-ALIGNING COLLAR ASSEMBLY
 (STAINLESS STEEL COLLAR, STAINLESS OR ALLOY STEEL WASHER)
 1 mm GRIP VARIATION - TENSION APPLICATION
 FOR USE ON 0.5 AND 1 mm OVERSIZE HI-LOK™ PINS

HLM375

1 of 1