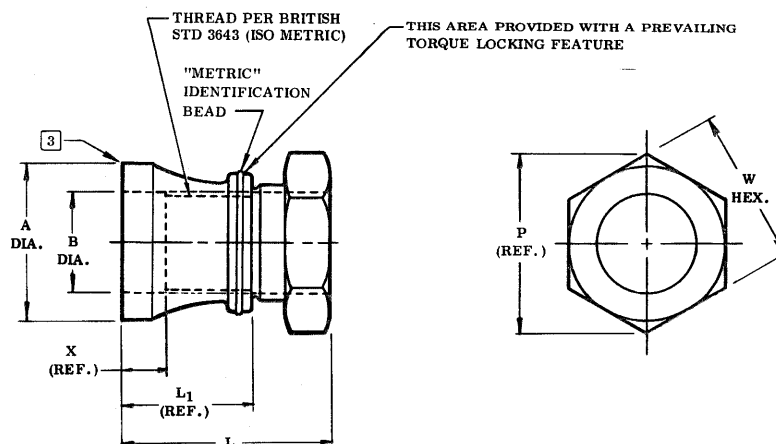


**STANDARDS COMMITTEE
FOR HI-LOK® PRODUCTS**
2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code I.D. No. 73197
Division of Hi-Shear Industries Inc. U.S.A. (Licensee) U.S. Federal Code I.D. No. 06725
AIR INDUSTRIES CO., INC. (Licensee) U.S. Federal Code I.D. No. 07523
DEUTSCH FASTENER CO., INC. (Licensee) U.S. Federal Code I.D. No. 06878
SFS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code I.D. No. 07215
VOI-SHAN, Division of VSI Corp. U.S.A. (Licensee) U.S. Federal Code I.D. No. 00516
WEST COAST AEROSPACE INC. U.S.A. (Licensee) U.S. Federal Code I.D. No. 00516
Pin & Slot Collars

HI-SHEAR FASTENERS EUROPE LTD. U.K. (Licensee)
Division of Hi-Shear Industries Inc. U.S.A. (Licensee) – EEC Countries
KAMAX-WEINKE Germany (Licensee) – EEC Countries
Rudolph Kellerman GmbH & Co. (Licensee) – EEC Countries
ST. CHAMOND GRANAT S.A. France (Licensee) – EEC Countries
SIMMONDS S.A. France (Licensee) – EEC Countries
Collars
TOKYO SCREW COMPANY, Japan (Licensee) – Japan



DASH NO. (METRIC)	PIN NOM. DIA.	THREAD	A DIA.	B DIA.	L	L ₁ (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	2.8 - 4.0	9600
-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	3.9 - 5.7	12700
-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	9.0 - 12.5	20700
-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	20.3 - 26.0	36900
-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	40.6 - 47.5	62300
-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	67.7 - 76.3	97800

- NOTES: 1. Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
2. Dimensions apply after finish.
3. Break sharp edge.

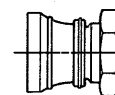
MATERIAL: A-286 high temperature alloy per AMS5731.

FINISH: HLM378-() = Solid film lubricant.
HLM378G-() = Silver plate per AMS2410 and cetyl alcohol lube per Hi-Shear Spec. 305.

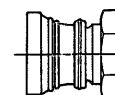
SPECIFICATION: Hi-Lok Product Specification M345.

CODE: Dash number indicates nominal thread size in 1mm.
See finish note for explanation of code letters.

EXAMPLE: HLM378-08 = M8 x 1.0 Hi-Lok collar with solid film lube.



VOI-SHAN
1 raised bead indicates
VOI-SHAN identification.



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

Patented internationally. "Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation.

DATE			BY		TITLE hi-Lok® COLLAR (METRIC SERIES) A-286 HIGH TEMPERATURE ALLOY 1mm GRIP VARIATION - TENSION APPLICATION FOR USE ON 0.5mm AND 1.0mm OVERSIZE HI-LOK PINS	DRAWING NUMBER HLM378
DRAWN	11-2-89		D.P.S.			
APPROVED	11-2-89		JBW			
REVISION						