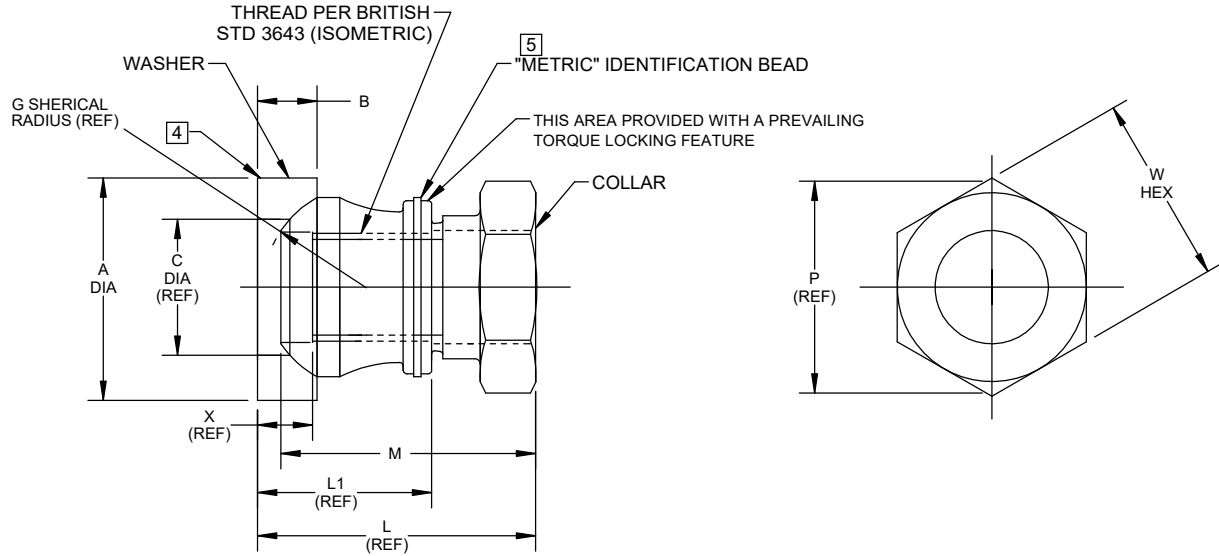




DASH NO. (METRIC)	PIN NOM DIA	THREAD	A DIA	B DIA	C DIA (REF)	G SPHER. RAD (REF)	L (REF)	L1 (REF)	M	P (REF)	W HEX	X (REF)	TORQUE OFF NEWTON-METER	ULT TNSN STR NEWTONS MINIMUM
04	4.5	M4 x 0.7-4H5H	9.66 9.40	2.29 2.03	6.5	5.1	12.20	7.8	11.45 10.95	8.87	8.00 7.78	3.3	1.7-2.9	5800
05	5.5	M5 x 0.8-4H5H	11.69 11.43	2.67 2.41	8.1	6.7	12.30	8.0	11.55 11.05	11.10	10.00 9.78	3.4	2.8-4.6	7300
06	7	M6 x 1.0-4H5H	14.74 14.48	3.31 3.05	9.6	8.7	15.35	10.3	14.35 13.85	12.12	11.00 10.73	4.5	5.6-9.1	12000
08	9	M8 x 1.0-4H5H	17.40 17.14	4.07 3.81	12.0	9.8	17.95	12.1	16.65 16.15	14.40	13.00 12.73	4.5	14.6-18.1	22200
10	11	M10 x 1.0-4H5H	20.45 20.19	4.58 4.32	14.5	11.4	20.95	14.3	19.30 18.80	15.56	14.00 13.73	4.5	23.7-28.3	33300
12	13	M12 x 1.25-4H5H	24.26 24.00	5.97 5.71	17.0	13.1	24.40	16.7	22.10 21.60	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. For use on sloped surface up to 7° maximum on HI-LOK™ metric standard diameter pins.

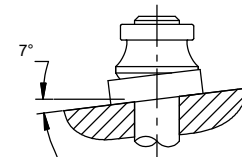
④ Break sharp edge

⑤ Parts made prior to this revision are OK to use.

MATERIAL: Collar - 2024 aluminum alloy per QQ-A-430 or AMS-QQ-A-225/6.
Washer - 4140 or 8740 alloy steel per AMS6349, AMS6382, AMS6322, AMS6327, and AMS6325.

HEAT TREAT: Collar - Age to T6 condition per AMS2770.
Washer - None

FINISH: Collar - HLM382-()A = Anodize, dye color gold, and cetyl alcohol lube per Hi-Shear Spec. 305
HLM382D-()A = Anodize, dye color natural, and solid film lube per AS5272.
Washer - HLM382-()W = Cadmium plate per AMS-QQ-P-416, Type II, Class 2.

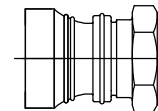


SPECIFICATION: HI-LOK™ Product Specification M345.

CODE: Dash number indicates nominal thread size in 1mm.
Code letter "A" following dash number indicates HI-LOK™ collar only.
Code letters "W" following dash number indicate swivel washer only.
See Finish note for explanation of code letters.

EXAMPLE: HLM382-08AW = M8 x 1.0 HI-LOK™ Collar and HLM382-08W swivel washer.
HLM382-08A = M8 x 1.0 HI-LOK™ Collar with cetyl alcohol lube.
HLM382-08W = 8 mm swivel washer with Type II cadmium plate.

③ **Arconic Fastening Systems**
1 raised bead indicates **Arconic Fastening Systems** identification



③ **SPS Technologies**
2 raised beads indicates **SPS Technologies** identification.

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

DATE	BY	TITLE	DRAWING NO.
DRAWN	1977-07-11	D.P.S.	HLM382 1 of 1
APPROVED	1977-07-11	R. TING	
③ REVISION	2020-01-07	K. MURKER	
HI-LOK™ COLLAR (METRIC SERIES) SELF-ALIGNING COLLAR ASSEMBLY (ALUMINUM COLLAR-ALLOY STEEL WASHER) 1 mm GRIP VARIATION - SHEAR APPLICATION FOR USE ON 0.5 AND 1 mm OVERSIZE HI-LOK™ PINS			