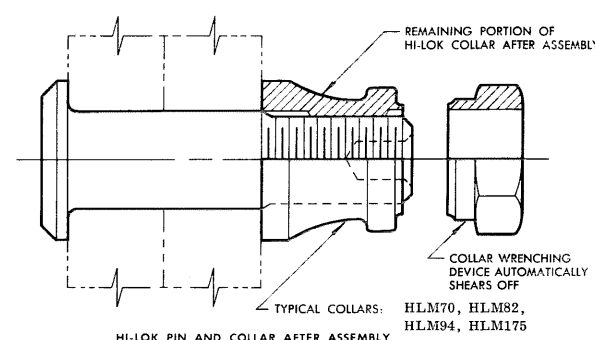
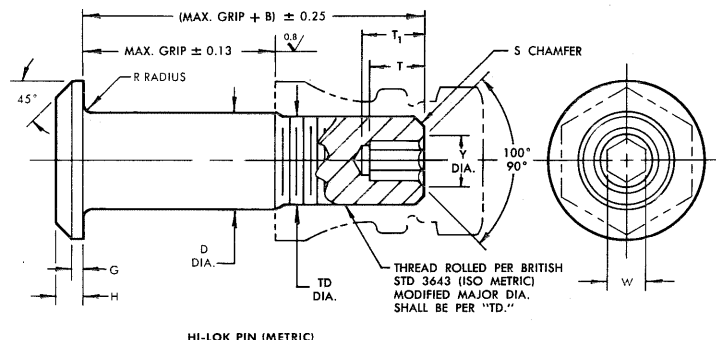
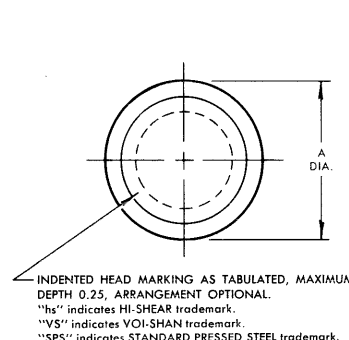


STANDARDS COMMITTEE FOR HI-LOK® PRODUCTS

2600 SKYPARK DRIVE, TORRANCE, CALIFORNIA 90509

① HI-SHEAR CORPORATION, U.S.A. (Patent Holder) U.S. Federal Code No. 73197	HI-SHEAR FASTENERS EUR. Division of Hi-Shear Industries Inc., U.S.A. (Licensee) U.S. Federal Code No. 08725	U.K. (Licensee)
AIR INDUSTRIES CO., INC. (Licensee - U.S. & Canada) U.S. Federal Code No. 08725	KAMAX-WERKE, Germany (Licensee - EEC Countries)	
DEUTSCH FASTENER CO., INC. (Licensee) U.S. Federal Code No. 08722	Rudolph Kollerhahn GmbH & Co. (Licensee - EEC Countries)	
SPS TECHNOLOGIES, U.S.A. (Licensee) U.S. Federal Code No. 08722	ST. CHAMOND GRAMAT, S.A. France (Licensee - EEC Countries)	
VOI-SHAN, Division of VSI Corp., U.S.A. (Licensee) U.S. Federal Code No. 08725	SIMMONDS, S.A. France (Licensee - EEC Countries)	
WEST COAST AEROSPACE INC., U.S.A. (Licensee) U.S. Federal Code No. 08716	TOKYO SCREW COMPANY, Japan (Licensee - Japan)	



FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	G REF.	H	R RAD.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET				DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM
					WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE							* W HEX.	T HEX DEPTH MIN.	T ₁ DEPTH MAX.	Y DIA.		
-04	HLM40M4	4	6.65 6.25	8.35	3.990 3.978	3.990 3.965	3.91 3.86	0.6	1.20 0.95	0.65 0.40	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	1.80	2.95	2.30 1.90	16400	7800
-05	HLM40M5	5	8.15 7.65	8.65	4.990 4.978	4.990 4.965	4.90 4.84	0.8	1.40 1.15	0.65 0.40	0.8 x 45°	M5 x 0.8-4h	2.05 2.01	2.00	3.05	2.60 2.60	25700	11800
-06	HLM40M6	6	10.20 9.70	10.70	5.990 5.978	5.990 5.965	5.88 5.81	0.9	1.75 1.50	0.65 0.40	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.25	3.40	3.60 3.10	37000	18200
-08	HLM40M8 x 1	8	12.85 12.25	12.95	7.987 7.972	7.987 7.962	7.88 7.80	1.0	2.20 1.95	0.75 0.50	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	2.80	4.15	4.60 4.05	65800	31600
-10	HLM40M10 x 1	10	16.20 15.40	15.20	9.987 9.972	9.987 9.962	9.88 9.80	1.3	2.65 2.40	0.75 0.50	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	3.80	5.35	5.55 5.00	102900	48900
-12	HLM40M12 x 1.25	12	18.80 18.00	18.15	11.984 11.966	11.984 11.959	11.87 11.76	1.5	2.95 2.70	0.75 0.50	1.2 x 45°	M12 x 1.25-4h	4.90 4.81	4.55	6.30	6.45 5.90	148100	66700

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

- GENERAL NOTES:**
1. Concentricity: "A" to "D" diameter within 0.25 FIR.
 2. Dimensions to be met after finish.
 3. Surface texture per ISO/R468.
 4. Use HLM340 for oversize replacement.

MATERIAL: A-286 high temperature alloy per Spec. AMS5737 or AMS5731.

HEAT TREAT: 655 N/mm² shear minimum at room temperature.

- ① **FINISH:** HLM40-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM40K-()-() = Solid film lube per Lubeco 905.
HLM40TF-()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292.

SPECIFICATION: Hi-Lok Product Specification No. M342.

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

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HLM40-04-8

8 mm Maximum Grip Length
4 mm Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HLM4094-04-8

Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

* INCH STANDARD HEX.

"Hi-Lok" and "HL" are internationally registered trademarks of Hi-Shear Corporation	
DRAWN D.P.S.	DATE 1-7-82
APPROVED <i>R. King</i>	DATE 1-7-82
REVISION ①	DATE T.Craine 2-12-93
hi-Lok® PIN (METRIC SERIES) PROTRUDING SHEAR HEAD A-286 HIGH TEMPERATURE ALLOY 1 mm GRIP VARIATION DRAWING NUMBER HLM40	

© 1993, Hi-Shear Corporation