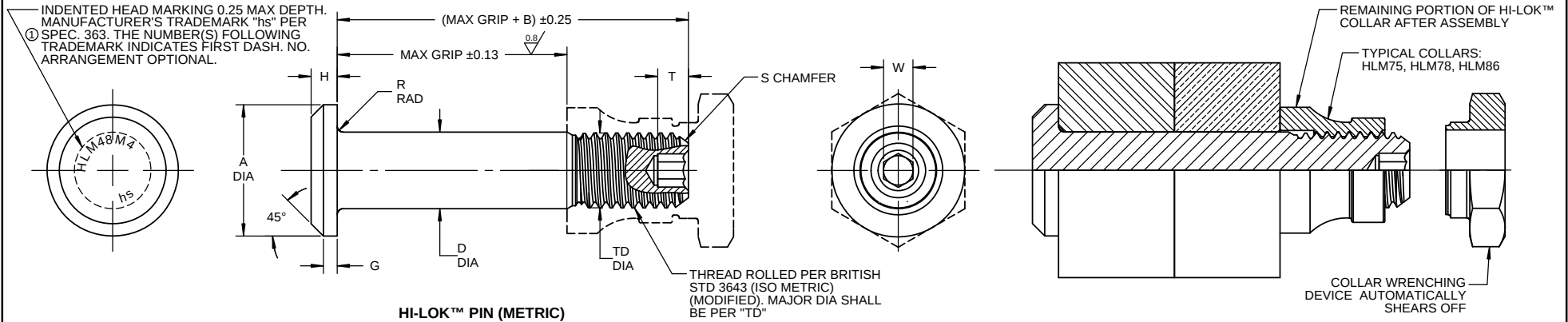


①

For the current list of licensed manufacturers, please visit the
LISI AEROSPACE website at:
[HTTP://WWW.LISI-AEROSPACE.COM/LICENSES](http://www.lisi-aerospace.com/licenses)



HI-LOK™ PIN (METRIC)

HI-LOK™ PIN AND COLLAR AFTER ASSEMBLY

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

①

FIRST DASH NO.	HEAD MARKING	PIN 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 OR COATING	WITH SOLID FILM LUBE OR COATING							* W HEX	T DEPTH		
4	HLM48M4	4	8.15 7.75	8.35	3.990 3.978	3.990 3.965	3.91 3.86	0.9	1.60 1.40	0.65 0.40	0.8 x 45°	M4 x 0.7-4h	1.64 1.61	2.05 1.65	16400	9800
5	HLM48M5	5	9.75 9.25	8.65	4.990 4.978	4.990 4.965	4.90 4.84	1.0	1.90 1.65	0.65 0.40	0.8 x 45°	M5 x 0.8-4h	2.05 2.01	2.55 2.00	25700	15600
6	HLM48M6	6	10.90 10.40	10.70	5.990 5.978	5.990 5.965	5.88 5.81	1.3	2.30 2.05	0.65 0.40	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	37000	22200
8	HLM48M8 x 1	8	12.85 12.25	12.95	7.987 7.972	7.987 7.962	7.88 7.80	1.6	3.05 2.80	0.75 0.50	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	65800	42000
10	HLM48M10 x 1	10	16.20 15.40	15.20	9.987 9.972	9.987 9.962	9.88 9.80	1.9	3.75 3.50	0.75 0.50	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	102900	68000
12	HLM48M12 x 1.25	12	18.80 18.00	18.15	11.984 11.966	11.984 11.959	11.87 11.75	2.3	4.45 4.20	0.75 0.50	1.2 x 45°	M12 x 1.25-4h	4.90 4.81	5.10 4.55	148100	100200

GENERAL NOTES:

1. Concentricity: "A" to "D" diameter within 0.25 FIR.
- ① 2. Dimensions are in millimeters, and to be met after finish.
3. Surface texture per ISO/DR221.
4. Use HLM348 for oversize replacement.

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

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

FINISH: HLM48(-)(-) = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM48TF(-)(-) = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292.

① HLM48HK(-)(-) = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LOK™ Product Specification M342.

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

HOW TO ORDER

① **EXAMPLE:**

Pin Part Number
HLM48TF8-8

8mm Maximum Grip Length
4mm Nominal Diameter Pin
Finish Code
Pin Basic Part Number

Pin and Collar Assembly Part Number Combination
HLM4878-04-8

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

* INCH STANDARD HEX

"HI-LOK", "HL", AND "HI-KOTE", ARE TRADEMARKS OF HI-SHEAR CORPORATION		
DRAWN BY D.P.S.	DATE 1977-01-25	TITLE HI-LOK™ PIN (METRIC SERIES) PROTRUDING TENSION HEAD A-286 HIGH TEMPERATURE ALLOY 1mm GRIP VARIATION
APPROVED R.TING	DATE 1977-01-25	
REVISION ①	DATE M.BEARD 2017-05-18	DRAWING NUMBER HLM48 1 OF 1