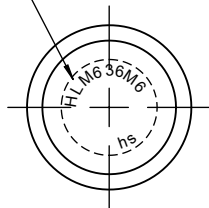
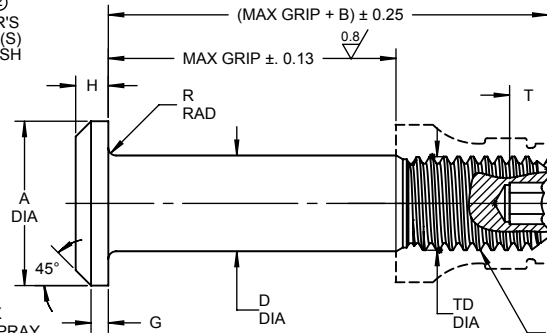
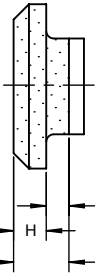


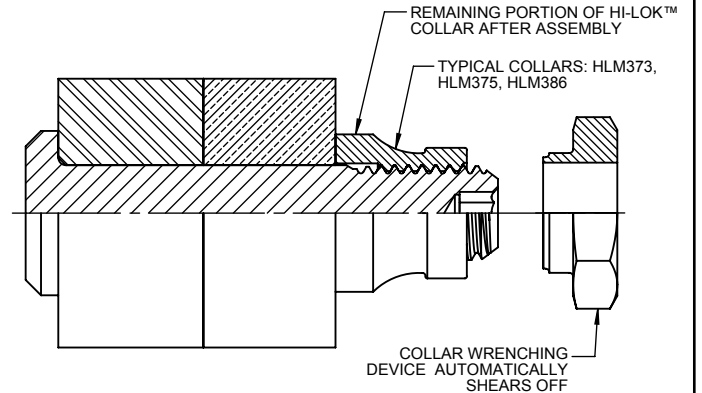
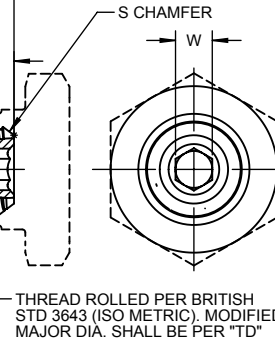
INDENTED HEAD MARKING 0.25 MAX DEPTH. ②
IDENTIFY AS TABULATED AND MANUFACTURER'S
TRADEMARK "hs" PER SPEC. 363. THE NUMBER(S)
FOLLOWING TRADEMARK INDICATES FIRST DASH
NO. ARRANGEMENT OPTIONAL.



PR1436G SEALANT
ON BEARING FACE
(FOR CODE "HB" ONLY)



HI-LOK™ (METRIC) PIN



HI-LOK™ (METRIC) PIN AND COLLAR AFTER ASSEMBLY

COLLAR WRENCHING
DEVICE AUTOMATICALLY
SHEARS OFF

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
					HLM636	HLM636HB HLM636TB HLM636HK							* W HEX	T DEPTH		
04		5			NOTE: Use HLM36-05 (See HLM36 Sales Drawing for Collar Selection)											
05		6			NOTE: Use HLM36-06 (See HLM36 Sales Drawing for Collar Selection)											
06	HLM636M6	7	11.90 11.40	11.7	6.990 6.978	6.990 6.965	5.88 5.81	1.3	2.20 2.05	0.65 0.40	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	66200	31100
08	HLM636M8 X 1	9	13.85 13.25	14.0	8.987 8.972	8.987 8.962	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	109400	58000
10	HLM636M10 X 1	11	17.20 16.40	16.2	10.987 10.972	10.987 10.962	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	163500	90800
12	HLM636M12 X 1.25	13	19.80 19.00	19.4	12.984 12.966	12.984 12.959	11.87 11.76	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	228300	130700

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

GENERAL NOTES: 1. Concentricity: Head to "D" diameter within 0.25 FIM.
② 2. Dimensions are in millimeters and to be met after finish.
3. Surface texture per ISO/R468.

CODE: First dash number indicates nominal diameter in 1 mm
which HLM636 oversize pin replaces,
Second dash number indicates maximum grip in 1 mm.
See Finish note for explanation of code letters.

HOW TO ORDER
② **EXAMPLE:**

Pin Part Number
HLM636TB06-8
8 mm Maximum Grip Length
Replaces 6 mm Nominal Diameter Pin
Finish Code
Pin Basic Part Number

Pin and Collar Assembly Part Number combination
HLM636383-06-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

* Inch standard hex.
** The Double Shear values shown
are based on cross sectional
area for nominal diameter pin.

MATERIAL: PH13-8Mo stainless steel per Spec. AMS5629

HEAT TREAT: 860 MPa shear minimum.

FINISH: ② HLM636()-() = Passivate per Hi-Shear Spec. 262 and cetyl alcohol lube
per Hi-Shear Spec. 305.
HLM636TB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292,
and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM636HB()-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and
apply precoat No. PR1436G sealant (.051-.127 mm thick)
plus cetyl alcohol lube per Hi-Shear Spec. 305.
② HLM636HK()-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

SPECIFICATION: HI-LOK™ Product Specification M342.

"HI-LOK", "HL", AND "HI-KOTE",
ARE TRADEMARKS OF HI-SHEAR CORPORATION

DRAWN BY D.P.S.	DATE 1977-09-21	TITLE HI-LOK™ PIN (METRIC SERIES) PROTRUDING TENSION HEAD PH13-8Mo STAINLESS STEEL 1 mm GRIP VARIATION - 1 mm OVERSIZE
APPROVED J.G.WILCOX	DATE 1977-09-21	
REVISION ②	DATE F.CARINGELLA 2017-10-11	DRAWING NUMBER HLM636