



FIRST DASH NO.	HEAD MARKING	NOM. DIA.	A DIA.	B REF.	D DIA.		TD DIA.	F	H	R RAD.	Z MAX.	S CHAMFER REF.	THREAD (MODIFIED)	SOCKET		** DOUBLE SHEAR NEWTONS MINIMUM	TENSION NEWTONS MINIMUM		
					HLM637	HLM637TB OR HLM637HB								W *	T DEPTH				
-04		5			NOTE: Use HLM37-05 (See HLM37 Sales Drawing for Collar Selection)														
-05		6			NOTE: Use HLM37-06 (See HLM37 Sales Drawing for Collar Selection)														
-06	HLM637M6	7	13.13 12.99	11.7	6.990 6.978	6.990 6.965	5.88 5.81	0.16	2.58 2.52	0.75 0.50	0.38	0.8 x 45°	M6 x 1.0-4h	2.46 2.40	2.80 2.25	66200	31100		
-08	HLM637M8 x 1	9	17.13 16.99	14.0	8.987 8.972	8.987 8.962	7.88 7.80	0.18	3.42 3.36	1.00 0.75	0.38	1.2 x 45°	M8 x 1.0-4h	3.29 3.22	3.35 2.80	109400	58000		
-10	HLM637M10 x 1	11	21.13 20.99	16.2	10.987 10.972	10.987 10.962	9.88 9.80	0.21	4.26 4.20	1.00 0.75	0.38	1.2 x 45°	M10 x 1.0-4h	4.11 4.02	4.35 3.80	163500	90800		
-12	HLM637M12 x 1.25	13	25.13 24.99	19.4	12.984 12.966	12.984 12.959	11.87 11.76	0.23	5.10 5.04	1.25 1.00	0.56	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:
- Head edge out of roundness shall not exceed "F."
 - Concentricity: Conical surface of head to "D" diameter within 0.13 FIR.
 - "H" is dimensioned from maximum "D" diameter.
 - Dimensions to be met after finish.
 - Surface texture per ISO/DR221.
 - Curved or flat edge manufacturer's option.

MATERIAL: PH13-8Mo stainless steel per Spec. AMS6629.

HEAT TREAT: 860 MPa shear minimum.

FINISH: HLM637-()-() = Passivate per Hi-Shear Spec. 258 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM637TB-()-() = Hi-Kote 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM637HB-()-() = 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.

SPECIFICATION: HI-Lok Product Specification No. M342.

CODE: First dash number indicates nominal diameter in 1 mm which HLM637 oversize pin replaces.
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

HLM637-06-8

8 mm Maximum Grip Length

Replaces 6 mm Nominal Diameter Pin

Pin Part Number

Pin and Collar Assembly Part Number Combination

HLM637386-06-8

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.

U.S. patents 2,882,773; 2,927,491; 2,940,495; 3,027,789; 3,138,987; design patent 191,883; other U.S. and Foreign patents granted and pending; property of Hi-Shear Corporation. "Hi-Lok" and "HL" are Registered Trademarks of Hi-Shear Corporation.	
DRAWN D.P.S.	DATE 9-21-77
APPROVED <i>Sevillan</i>	DATE 9/21/77
REVISION	DATE
hi-Lok® PIN (METRIC SERIES) 100° FLUSH TENSION HEAD PH13-8Mo STAINLESS STEEL 1 mm GRIP VARIATION - 1 mm OVERSIZE DRAWING NUMBER HLM637	