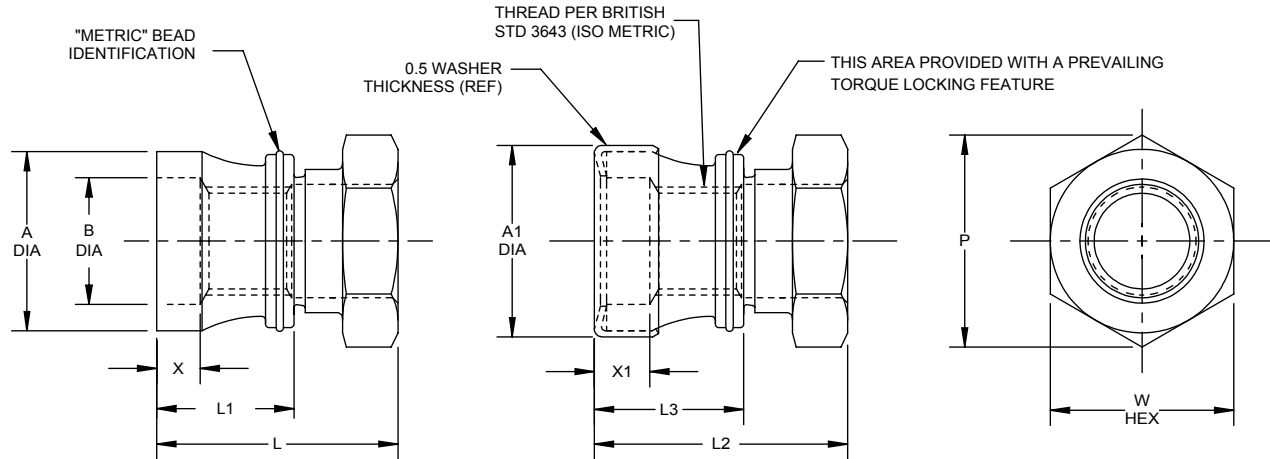




DASH NO. (METRIC)	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	TORQUE-OFF NEWTON - METER	ULT TNSN STR NEWTONS MINIMUM
04	4	M4 x 0.7-4H5H	7.42 7.15	8.6	4.25 4.15	11.75 11.25	7.2	12.3	8.0	8.65	8.00 7.78	2.8	3.6	1.7-2.9	5800
05	5	M5 x 0.8-4H5H	8.25 7.69	9.1	5.25 5.15	11.90 11.40	7.4	12.4	8.1	11.10	10.00 9.78	2.9	3.7	2.8-4.6	7300
06	6	M6 x 1.0-4H5H	10.47 10.30	11.7	6.25 6.15	14.50 14.00	9.2	15.0	9.9	12.12	11.00 10.73	3.3	4.1	5.6-9.1	12000
08	8	M8 x 1.0-4H5H	13.15 13.00	14.6	8.30 8.15	17.00 16.50	11.0	17.7	11.9	14.40	13.00 12.73	3.3	4.2	14.6-18.1	22200
10	10	M10 x 1.0-4H5H	16.50 15.78	17.5	10.30 10.15	19.75 19.25	12.9	20.5	13.9	15.56	14.00 13.73	3.3	4.3	23.7-28.3	33300
12	12	M12 x 1.25-4H5H	20.70 19.60	22.1	12.30 12.15	23.10 22.60	15.3	23.9	16.3	18.90	17.00 16.73	3.9	4.9	36.1-43.0	48900

- NOTES:**
1. Go thread gage penetration shall be 3/4 of one revolution minimum.
 2. Dimensions are in millimeters and apply after finish.
 3. Use HLM370 for oversize replacement.

MATERIAL: Collar - 2024 aluminum alloy per QQ-A-430 or QQ-A-225/6.
 Washer - 2024 aluminum alloy per QQ-A-250/4 or 250/5.

HEAT TREAT: Collar - Age to T6 condition per AMS2770.
 Washer - Age to T6 condition per AMS2770.

FINISH: Collar - HLM70-() = Anodize color red, and cetyl alcohol lube per Hi-Shear Spec. 305.
 Collar & Washer - HLM70TW() = Collar finish same as HLM70-(), and washer with anodize, color red.

SPECIFICATION: HI-LOK™ Product Specification M345.

CODE: Dash number indicates nominal thread size in 1 mm.
 See Finish note for explanation of code letters.

EXAMPLES: HLM70-08 = M8 x 1.0 HI-LOK™ collar.
 HLM70TW08 = M8 x 1.0 HI-LOK™ collar and washer.

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

DATE	BY	TITLE	DRAWING NO.
DRAWN	1970-04-17	VAN	HI-LOK™ COLLAR
APPROVED	1970-04-17	R. TING	(METRIC SERIES)
REVISION	2017-09-13	KEVIN TRAN	2024-T6 ALUMINUM ALLOY
			1 mm GRIP VARIATION, SHEAR APPLICATION
			1 of 1