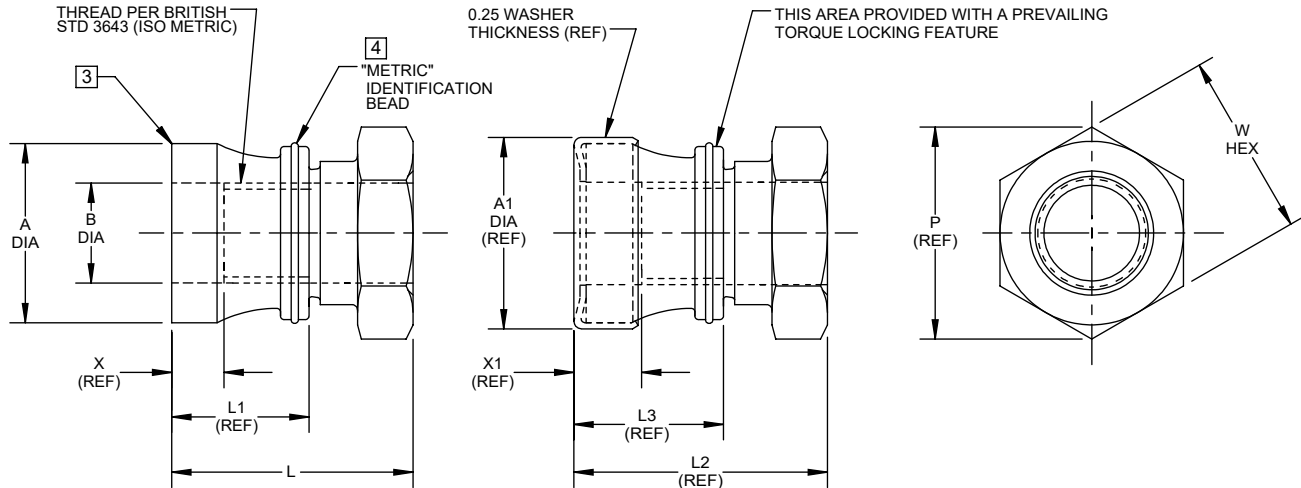




DASH NO. (METRIC)	PIN NOM DIA	THREAD	A DIA	A1 DIA (REF)	B DIA	L	L1 (REF)	L2 (REF)	L3 (REF)	P (REF)	W HEX	X (REF)	X1 (REF)	TORQUE OFF NEWTON - METER	ULT TNSN STR NEWTONS MINIMUM
04	4	M4 x 0.7-4H5H	7.42 7.15	8.1	4.25 4.15	11.75 11.25	7.2	12.0	7.7	8.87	8.00 7.78	2.8	3.3	2.8-4.0	13300
05	5	M5 x 0.8-4H5H	8.25 7.69	8.6	5.25 5.15	11.90 11.40	7.4	12.2	7.9	11.10	10.00 9.78	2.9	3.4	3.9-5.7	17800
06	6	M6 x 1.0-4H5H	10.47 10.30	11.2	6.25 6.15	14.50 14.00	9.2	14.8	9.7	12.12	11.00 10.73	3.3	3.8	9.0-12.5	30200
08	8	M8 x 1.0-4H5H	13.15 13.00	14.0	8.30 8.15	17.00 16.50	11.0	17.5	11.6	14.40	13.00 12.73	3.3	3.9	20.3-26.0	53400
10	10	M10 x 1.0-4H5H	16.50 15.78	16.9	10.30 10.15	19.75 19.25	12.9	20.2	13.6	15.56	14.00 13.73	3.3	4.0	40.6-47.5	86700
12	12	M12 x 1.25-4H5H	21.54 19.60	22.4	12.30 12.15	23.10 22.60	15.3	23.6	16.0	18.90	17.00 16.73	3.9	4.5	67.7-76.3	117900

- NOTES:**
- Go thread gage penetration shall be 3/4 of one revolution minimum after thread lock.
 - Dimensions are in millimeters and apply after finish.
 - Break sharp edge.
 - Parts made prior to this revision are OK to use.
 - Use HLM373 for oversize replacement.

MATERIAL: Collar - 17-4PH stainless steel per AMS5643.
Washer - 300 series stainless steel.

HEAT TREAT: ⑧ To condition H1025 per AMS2759 (collar only).

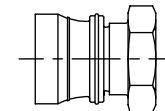
FINISH: ⑧ Collar - HLM73-() = Silver plate per Spec. AMS2410 (.0050-.0125 thick), color identification blue, and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM73DU-() = Solid film lube per AS5272.
HLM73TB-() = HI-KOTE™ 2 solid film lube per Hi-Shear Spec. 292 and cetyl alcohol lube per Hi-Shear Spec. 305.
HLM73V-() = Solid film lubricant per "Lubeco" 2123, Type II.
HLM73HK-() = HI-KOTE™ 4 NC aluminum coating per Hi-Shear Spec. 397.

Collar and Washer - HLM73W-() = Collar finish same as HLM73-(), and washer is passivate.

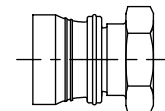
SPECIFICATION: HI-LOK™ Product Specification M345.

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

EXAMPLES: HLM73-08 = M8 x 1.0 HI-LOK™ collar.
HLM73W-08 = M8 x 1.0 HI-LOK™ collar with washer.



VOI-SHAN
1 raised bead indicates
VOI-SHAN identification



STANDARD PRESSED STEEL
2 raised beads indicate STANDARD
PRESSED STEEL identification.

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

DATE	BY	TITLE	DRAWING NO.
1971-12-02	VAN	HI-LOK™ COLLAR (METRIC SERIES) 17-4PH STAINLESS STEEL	HLM73
1971-12-02	R. TING	1 mm GRIP VARIATION, TENSION APPLICATION	1 of 1
2023-06-19	C. ARTOS		